

**DESCRIPTION**

Stoody 131 is recommended for parts where a low coefficient of friction and minimum cross checking are desirable. Deposits provide excellent bearing surfaces on friction type guides and cement mill gudgeons. It can be applied to carbon, low alloy, and manganese steels. Deposits are not machinable or forgeable. It is generally limited to 2 passes, although multiple layers can be applied with proper procedure (fast travel and preheat control).

**TYPICAL DEPOSIT CHARACTERISTICS**

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Hardness with 2 Layers:	
On Carbon Steel	HRC 40 – 45
On Manganese Steel	HRC 37 – 40
Deposit Layers	2
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	No
Machinability	No

**ALLOY TYPE**

Eutectic Chromium Carbides in a Semi-Austenitic Matrix

**TYPICAL APPLICATIONS**

- Gyrotory Cross Heads
- Guides
- Dredge Parts
- Pumps

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>1/16 (1.6)</b>
Current, Amp. DCRP	175 – 225
Voltage	24 – 26
Wire Extension	1/2" – 1"
Shielding Gas	None
Position	Flat
Diameter, In. (mm)	<b>7/64 (2.8)</b>
Current, Amp. DCRP	250 – 350
Voltage	24 – 28
Wire Extension	3/4" – 1 1/4"
Shielding Gas	None
Position	Flat

**STANDARD SIZES & PACKAGING**

Diameter	Packaging	Part #
1/16" (1.6mm)	33# WB	11464900
7/64" (2.8mm)	60# Coil	11000700
7/64" (2.8mm)	110# QP	11143800
7/64" (2.8mm)	200# HP	11141400