

DESCRIPTION

Stoody 110 deposit is a modified chromium, high manganese steel used in the rebuilding of manganese steel parts subject to severe impact loading. This materials offers good toughness and wear resistance, and is sometimes used as the final hardfacing layer in extreme impact situations. Deposits cannot be flame cut but are machinable with carbide tools, are non-magnetic, and are not recommended for cast iron. It can be used on carbon, low alloy, and manganese steels. It also offers cavitation resistance in fluid component applications. Stoody 110 MC, G, and O are metal cored wires, producing a very light slag covering, causing no interference in multi-layer welding.

TYPICAL DEPOSIT CHARACTERISTICS

Tensile Strength	119 KSI
Yield Strength	76 KSI
Elongation in 2"	40%
Hardness	
As Deposited	HRC 17
Work Hardened	HRC 55
Abrasion Resistance	Moderate
Impact Toughness	Good
Cavitation Resistance	Good
Cross Checks	No
Machinable	Yes
Deposit Layers	Multiple

ALLOY TYPE

Austenitic Chromium Manganese Steel

TYPICAL APPLICATIONS

- Drive Tumblers
- Turbine Cones
- Manganese Frogs
- Shovel Pads
- Wobbler Feeders
- Crusher Rolls
- Fluid Components

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

	110-G	110-O
Diameter, In. (mm)	0.045 (1.2)	1/16 (1.6)
Current, Amp. DCRP	135 – 185	150 – 210
Voltage	18 – 24	22 – 26
Wire Extension	1/2" – 3/4"	1/2" – 1"
Shielding Gas	98% Ar/2% O ₂	None or CO ₂
Position	Flat	Flat

	110	110, 110 MC
Diameter, In. (mm)	3/32 (2.4)	7/64 (2.8)
Current, Amp. DCRP	225 – 300	225 – 375
Voltage	23 – 27	23 – 27
Wire Extension	1" – 1 1/2"	1" – 1 1/2"
Shielding Gas	None	None
Position	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.045" (1.2mm)	10# PS	11884500
.045" (1.2mm)	33# WB	11452600
1/16" (1.6mm)	10# PS	11425300
1/16" (1.6mm)	33# WB	11424400
1/16" (1.6mm)	50# PP	11345000
3/32" (2.4mm)	60# Coil	11214400
7/64" (2.8mm)	60# Coil	11000300
7/64" (2.8mm)	110# QP	11143400
7/64" (2.8mm)	200# HP	11140900
7/64" (2.8mm)	110 MC, 60# Coil	11836900
7/64" (2.8mm)	110 MC, 110# QP	11836800

Stoody Company

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