STOODY
A THERMADYNE Company

Stoody® 121, 121-G, 121-O

Open Arc/Gas Shielded Welding Wire

DESCRIPTION

Stoody 121 deposit consists of uniformly distributed chromium carbides in a semi-austenitic matrix. It is recommended for applications involving severe abrasion and moderate impact. This product provides excellent service on a wide variety of heavy equipment and earth engaging tools. It typically has cross checking and is not machinable. Stoody 121 can be applied to carbon, low alloy, and manganese steels. Deposits should be limited to two layers.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Hardness	
1 Layer	HRC 40 – 44
2 Layers	HRC 47 - 51
Deposit Layers	2
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes

ALLOY TYPE

Chromium Carbides in a Semi-Austenitic Matrix

TYPICAL APPLICATIONS

- Scraper Sides and Cutters
- Pug Mill Paddles
- Vibratory Ditcher Shanks
- Augers
- Tamper Tools

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

	121-G	121-O
Diameter, In. (mm)	**0.045 (1.2)**	**1/16 (1.6)**
Current, Amp. DCRP	175 – 200	205 – 255
Voltage	22 – 26	24 – 28
Wire Extension	½" – ¾"	½" – 1"
Shielding Gas	98/2 or 75/25	None
Position	Flat	Flat

	121	
Diameter, In. (mm)	**3/32 (2.4)**	**7/64 (2.8)**
Current, Amp. DCRP	250 – 350	300 – 400
Voltage	24 – 28	24 – 28
Wire Extension	¾" – 1 ¼"	¾" – 1 ¼"
Shielding Gas	None	None
Position	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.045" (1.2mm)	10# PS	11423300
.045" (1.2mm)	33# WB	11423200
1/16" (1.6mm)	10# PS	11420700
1/16" (1.6mm)	33# WB	11408300
1/16" (1.6mm)	50# PP	11420600
3/32" (2.4mm)	60# Coil	11086600
3/32" (2.4mm)	200# HP	11087700
7/64" (2.8mm)	60# Coil	11000500
7/64" (2.8mm)	110# QP	11143700

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