STOODY
A THERMADYNE Company

Stoody® 107
Submerged Arc Welding Wire

DESCRIPTION

Stoody 107 deposit has good resistance to metal-to-metal wear, excellent impact resistance, good compressive strength, and resistance to plastic deformation. Multiple layer check-free deposits can be obtained up to ¾" thick. Deposits are readily machinable with carbide tools and can be flame cut. Stoody 107 can be used for both build-up and hardfacing on rollers and idlers.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Excellent
Compressive Strength	Good
Hardness	HRC 38
Surface Cross Checks	No
Magnetic	Yes
Deposit Thickness	Up to ¾"
Machinability	Yes

TYPICAL APPLICATIONS

Low Alloy Steel

TYPICAL APPLICATIONS

Typical applications include:

- Rollers
- Carbon Steel Crane Wheels
- House Rollers
- Idlers
- Mine Car Wheels

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	**1/8 (3.2)**	**5/32 (4.0)**
Current, Amp. DCRP	350 – 400	425 – 475
Voltage	29 – 31	29 – 31
Wire Extension	1 ¼" – 1 ½"	1 ¼" – 1 ½"
Flux Type	Stoody "S"	Stoody "S"
Position	Flat	Flat

Diameter, In. (mm)	**3/32 (2.4)**	**7/64 (2.8)**
Current, Amp. DCRP	250 – 300	300 – 350
Voltage	28 – 30	28 – 30
Wire Extension	1 ¼" – 1 ½"	1 ¼" – 1 ½"
Flux Type	Stoody "S"	Stoody "S"
Position	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	100# Coil	11001800
1/8" (3.2mm)	200# HP	11041200
1/8" (3.2mm)	500# POP	11039800
5/32" (4.0mm)	500# POP	11112200
3/32" (2.4mm)	60# Coil	11833000
3/32" (2.4mm)	500# POP	11474000
7/64" (2.8mm)	60# Coil	11001700

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