

DESCRIPTION

Stoody Super 20 is a solid core electrode with a heavy extruded coating that contains the alloying elements. It's extremely good wear resistance is attributed to the addition of molybdenum, tungsten, and chromium. It can be used in hot wear service up to 1100°F. The abrasion resistance of this alloy approaches that of a tungsten carbide and thus has been given the name "the poor man's tungsten carbide". Deposits will cross check and should be limited to one layer. The deposits are not machinable or forgeable.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Low – Moderate
Hardness	
On Carbon Steel	HRC 60 – 65
On Manganese Steel	HRC 58 – 63
Deposit Layers	1
Machinability/Forgeability	No
Hot Wear Applications	Up to 1100°F

ALLOY TYPE

Primary Chromium Carbides and Secondary Molybdenum and Tungsten Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

Typical applications include:

- Crusher Parts
- Ash Fan Blades
- Spiral Conveyors
- Feed Mill Hammers
- Anhydrous Ammonia
- Coke Pusher Shoes
- Hot Slag Dipper Teeth
- Pug Mill Paddles
- Sintering Plant Parts

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	70 – 160	130 – 250
Position	Flat	Flat
Diameter, In. (mm)	3/16 (4.8)	
Current, Amp. DCRP	200 – 300	
Position	Flat	

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Box	46520810
1/8" (3.2mm)	60# Bulk Pak	46520850
5/32" (4.0mm)	10# Box	46521010
5/32" (4.0mm)	60# Bulk Pak	46521050
3/16" (4.8mm)	10# Box	46521210

Stoody Company

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