

DESCRIPTION

Stoody 117 deposit consists of uniformly dispersed chromium carbides in a semi-austenitic matrix that provides a deposit with good impact, abrasion, and anti-galling properties. It develops a light cross-checking patten which allows this material to be applied in multiple layers without difficulty. It is frequently used as both a build-up and hardfacing alloy on carbon, low alloy, and manganese steels. Weldability is very good and deposits are not machinable.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Good
Deposit Layers (using stringer beads) And Fast Travel	Multiple
As Deposited Carbon Steel (3 layers)	HRC 43 – 45
As Deposited Manganese Steel (2 layers)	HRC 38 – 40
Work Hardened	HRC 55 – 60
Surface Cross Checks	Yes
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Machinability	Yes

ALLOY TYPE

Chromium Carbides in a Semi-Austenitic Matrix

TYPICAL APPLICATIONS

- Crusher Rolls
- Cones
- Hammers
- Gyratory Mantles
- Bucket Lips
- Dredge Pump Shells

**OPERATIONAL CHARACTERISTICS /
WELDING PARAMETERS**

Diameter, In. (mm)	1/16 (1.6)	3/32 (2.4)
Current, Amp. DCRP	190 – 230	275 – 325
Voltage	24 – 25	25 – 28
Wire Extension	1" – 1 1/4"	1" – 1 1/2"
Shielding Gas	None	Non
Position	Flat	Flat

Diameter, In. (mm)	7/64 (2.8)
Current, Amp. DCRP	300 – 600
Voltage	31 – 35
Wire Extension	1 1/4" – 1 1/2"
Shielding Gas	None
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/16" (1.6mm)	33# Wire Basket	11808400
3/32" (2.4mm)	60# Coil	11835900
7/64" (2.8mm)	60# Coil	11289100
7/64" (2.8mm)	110# Quarter Pak	11320600
7/64" (2.8mm)	200# Half Pak	11289000
7/64" (2.8mm)	500# POP	11832400

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