

DESCRIPTION

Stoody 135 open arc wire is a high chromium-carbide, iron based tubular alloy wire recommended for metal-to-earth applications subject to severe abrasion. It develops a tight cross-checking pattern (3/8" – 1/2") and is frequently used in crushing and construction application. It can be applied to carbon, low alloy, or manganese steels and can be used in hot wear applications up to 900°F. Deposits cannot be machined or forged.

TYPICAL APPLICATIONS

Typical applications include:

- Scraper sides, cutters, and blades
- Shovel bucket tooth adapters
- Tillage tools, augers, and auger flights
- Crushing and grinding equipment
- Ripper shanks and teeth
- Bucket sides and lips
- Conveyors screws
- Fan Blades

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Low
Hardness	
2 Layers 1020 Carbon Steel	HRC 54 – 62
Surface Cross Checks	Yes
Magnetic	Yes
Hot Wear Application	Up to 900°F

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/16 (1.6)
Current, Amp. DC+	200 – 220
Voltage	24 – 26
Wire Extension	1"
IPM Wire Feed Speed	260

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/16" (1.6mm)	33# WB	11862600
1/16" (1.6mm)	50# PP	11835100

Stoody Company

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