

DESCRIPTION

Stoody 2110 is a solid core electrode designed for build-up of austenitic manganese parts subject to high impact loading. It is a modified high chromium – high manganese steel that combines toughness and wear resistance. There is no limitation on deposit thickness. Stoody 2110 is not recommended for cast iron. It can be used on carbon steel or manganese steel base metal.

TYPICAL APPLICATIONS

Typical applications include:

- Shovel Pads
- Hammers
- Grate Bars
- Switch Points
- Roll Crushers
- Shovel Teeth
- Carbon or Manganese Steel Frogs
- Manganese Steel Components

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Excellent
Hardness	
On Carbon Steel – As Deposited	BHN 200
On Carbon Steel – Work Hardened	HRC 48 – 53
On Manganese Steel – As Deposited	BHN 210
On Manganese Steel – Work Hardened	HRC 50 – 55
Magnetic	No
Surface Cross Checks	No
Deposit Layers	Unlimited

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	100 – 130	125 – 190
Position	Flat	Flat
Length	14"	14"
Diameter, In. (mm)	3/16 (4.8)	1/4 (6.4)
Current, Amp. DCRP	150 – 260	240 – 325
Position	Flat	Flat
Length	14"	14"

ALLOY TYPE

Austenitic Chromium Manganese Steel

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
1/8" (3.2mm)	10# Vac Pak	11431300
5/32" (4.0mm)	10# Vac Pak	10202800
3/16" (4.8mm)	10# Vac Pak	10202900
1/4" (6.4mm)	10# Vac Pak	10203000

Stoody Company

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Notice: The information contained or otherwise referenced herein is presented only as "typical", without guarantee or warranty. Stoody expressly disclaims any liability from any reliance thereon. Typical data are those obtained when welded and tested in accordance with Stoody's internal procedures. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Stoody.