

**DESCRIPTION**

Stoody 965 AP-G is a gas shielded, flux cored, all position, general purpose, hardfacing wire. The deposit offers a good balance of impact and abrasion resistance. It can be used in both metal-to-metal and metal-to-earth applications. Deposits are forgeable but not readily machinable. Stoody 965 AP-G has a smooth semi spray transfer and can be applied to carbon, low alloy, and manganese steels. It is magnetic on carbon and low alloy steels but not on manganese steels. Analysis and properties are similar to Stoody Self Hardening covered electrode.

**TYPICAL APPLICATIONS**

- Tillage Tools
- Dredge Parts
- Sliding Metal Parts
- Tire Shedder Knives
- Drag Line Bucket Lips
- Extruder Screws
- Tamper Feet
- Churn Drills
- Muller Tires

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

**TYPICAL DEPOSIT CHARACTERISTICS**

Abrasion Resistance	Good
Impact Resistance	Good
2 Layer Hardness	HRC 57 – 62
Deposit Layers	2 Normal, 3 Max
Position	Flat, Horizontal Vertical, Overhead
Magnetic	
On Low Alloy and Carbon Steel	Yes
On Manganese Steel	No
Surface Cross Checks	No
Machinability	Grind Only

Diameter, In. (mm)	<b>.045 (1.2)</b>
Current, Amp. DCRP	140 – 225
Wire Feed Speed (ipm)	240 – 470
Voltage	26 – 29
Wire Extension	1/2" – 3/4"
Shielding Gas	75 Ar / 25 CO <sub>2</sub>
Position	All

Diameter, In. (mm)	<b>1/16 (1.6)</b>
Current, Amp. DCRP	170 – 275
Wire Feed Speed (ipm)	140 – 240
Voltage	24 – 30
Wire Extension	1/2" – 3/4"
Shielding Gas	75 Ar / 25 CO <sub>2</sub>
Position	All

**ALLOY TYPE**

Martensitic Tool Steel

**STANDARD SIZES & PACKAGING**

Diameter	Packaging	Part #
.045 (1.2mm)	33# Wire Basket	11807800
1/16" (1.6mm)	33# Wire Basket	11808600

**Stoody Company**

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