

DESCRIPTION

Stoody 134 deposit is a high chromium-iron alloy recommended for applications subject to severe abrasion, moderate impact, and high compressive loads. It can be deposited on carbon, low alloy, and manganese steel. Deposits are normally limited to two layers, develop cross checks, and are not machinable or forgeable. It can be used in hot wear applications up to 900°F.

TYPICAL APPLICATIONS

- Shovel Bucket Tooth Adapters
- Vertical Screen Deflector Plates
- Gyratory Crusher Liners or Concaves
- Crushing Rolls, Hammers, and Impactors
- Hammer Mill Rotor Discs
- Sizing / Scalping Screens
- Grizzly Bars
- Bucket Teeth
- Rippers
- Bucket Lips

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Resistance to Plastic Deformation	Excellent
Hardness	
1 Pass on Carbon Steel	HRC 42 – 46
2 Passes on Carbon Steel	HRC 56 – 60
1 Pass on Manganese Steel	HRC 43 – 47
2 Passes on Manganese Steel	HRC 45 - 50
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	2
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Hot Wear Applications	900°F

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	7/64 (2.8)
Current, Amp. DCRP	300 – 350
Voltage	26 – 28
Wire Extension	3/4" – 1 1/4"
Shielding Gas	None
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
7/64" (2.8mm)	60# Coil	11000900
7/64" (2.8mm)	110# QP	11143900
7/64" (2.8mm)	200# HP	11141500

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix