

**DESCRIPTION**

Stoody AC-DC Tube Borium coated electrode is manufactured by metering crushed tungsten carbide particles of controlled mesh size into steel tubes. It receives a thin graphitic coating. The tungsten carbide particles are available in a variety of sizes – fine mesh size increases wear resistance and coarse improves cutting efficiency.

**TYPICAL DEPOSIT CHARACTERISTICS**

Cutting Efficiency	Excellent
Abrasion Resistance	Excellent
Impact Resistance	Low
Magnetic	Yes
Deposition Layers	1
Surface Cross Checks	Yes
Hot Wear Applications	Up to 900°F
Machinability	No

**ALLOY TYPE**

Tungsten Carbide Particles in an Iron Based Matrix

**TYPICAL APPLICATIONS**

Typical applications include:

- Furrowing Shovels
- Rasp Bars
- Muller Plows
- Subsoiler Points
- Tool Joints

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>1/8 (3.2)</b>	<b>5/32 (4.0)</b>
Current, Amp. DCEP, AC	80 – 100	100 – 120
Mesh Size	30 – 40	20 – 30
Length	14"	14"
Position	Flat	Flat

Diameter, In. (mm)	<b>3/16 (4.8)</b>	<b>1/4 (6.4)</b>
Current, Amp. DCEP, AC	120 – 150	140 – 165
Mesh Size	20 – 30	10 – 30
Length	14"	14"
Position	Flat	Flat

**STANDARD SIZES & PACKAGING**

<b>Diameter</b>	<b>Packaging</b>	<b>Part #</b>
1/8" (3.2mm)	10# Vac Pak	10229100
5/32" (4.0mm)	10# Vac Pak	10229300
3/16" (4.8mm)	10# Vac Pak	10229500
1/4" (6.4mm)	10# Vac Pak	10229700