

**DESCRIPTION**

Stoody Versalloy Plus coated electrode is a modified austenitic stainless steel recommended for joining, rebuilding, or cushion-overlaying on applications involving high strength, heat, and corrosion resistance. It is frequently used in dissimilar metal applications to join carbon steels to stainless steels. Versalloy Plus has excellent welder appeal with a smooth semi-spray arc and self-peeling slag.

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>3/32 (2.4)</b>	<b>1/8 (3.2)</b>
Current, Amp. DCRP	50 – 90	75 – 125
Position	All	All

Diameter, In. (mm)	<b>5/32 (4.0)</b>
Current, Amp. DCRP	90 – 150
Position	Flat & Horizontal

**TYPICAL DEPOSIT CHARACTERISTICS**

Hardness	
As Deposited	230 BHN
Work Hardened	HRC 34
Magnetic	No
Tensile Strength	116 ksi
Yield Strength	90 ksi
Elongation in 2"	22%
Machinable	Yes

**STANDARD SIZES & PACKAGING**

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
3/32" (2.4mm)	5# Vac Pak	11820600
1/8" (3.2mm)	10# Vac Pak	11816900
5/32" (4.0mm)	10# Vac Pak	11820700

**ALLOY TYPE**

Modified Austenitic Stainless Steel

**TYPICAL APPLICATIONS**

Typical applications include:

- Joining Stainless Steels to Other Alloys
- General Purpose Repair Electrode
- Cushion Layer for Hardfacing

**Stoody Company**

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