

**DESCRIPTION**

Stoody® XHC combines excellent weldability with a high deposition rate. It is a solid core electrode with an extruded graphitic coating containing the alloying elements. Deposits are highly resistant to both sliding and grinding abrasion, but they are not machinable or forgeable. Stoody® XHC retains good wear resistance up to 1000°F (538°C) and it bonds well with carbon, low alloy, and manganese steels.

**TYPICAL DEPOSIT CHARACTERISTICS**

Abrasion Resistance	Excellent
Impact Resistance	Low
Hardness	
On Carbon Steel	HRC 60 - 66
On Manganese Steel	HRC 50 - 55
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Deposit Layers	2
Surface Cross Check	Yes
Machinability	No
Hot Wear Applications	Up to 1000°F

**ALLOY TYPE**

Primary Chromium Carbides in an Austenitic Matrix

**TYPICAL APPLICATIONS**

Typical applications include:

- Grader blades
- Harrow plows
- Slurry pipe

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>1/8 (3.2)</b>	<b>5/32 (4.0)</b>
Current, Amp. AC/DC	100 - 150	125 - 250
Position	Flat	Flat
Diameter, In. (mm)	<b>3/16 (4.8)</b>	<b>1/4 (6.4)</b>
Current, Amp. AC/DC	150 - 300	250 - 375
Position	Flat	Flat

**STANDARD SIZES & PACKAGING**

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
1/8" (3.2mm)	10# box	11383000
5/32" (4.0mm)	10# box	11382700
3/16" (4.8mm)	10# box	11382500
1/4" (6.4mm)	10# box	11382400