STOODY
A THERMADYNE Company

Stoody® AC-DC Borod®
Shielded Metal Arc Welding Electrode

DESCRIPTION

Stoody AC-DC Borod coated electrode is used for metal-to-earth applications requiring extreme abrasion resistance and low impact resistance. It is similar to Stoody AC-DC Tube Borium® in all respects except that the mesh size is finer (40 – down) to provide deposits resembling fine grit sandpaper. The finer mesh size generally provides slightly increased wear protection.

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:

- Log Grapplers
- Ash Plows
- Sand Slinger Buckets
- Concrete Plug Mill Paddles
- Ore Chutes

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	**1/8 (3.2)**	**5/32 (4.0)**
Current, Amp. DCEP, AC	80 – 100	100 – 120
Mesh Size	40 – Down	40 – Down
Length	14”	14”
Position	Flat	Flat

Diameter, In. (mm)	**3/16 (4.8)**
Current, Amp. DCEP, AC	120 – 150
Mesh Size	40 – Down
Length	14”
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8” (3.2mm)	10# Vac Pak	10234400
5/32” (4.0mm)	10# Vac Pak	10234600
3/16” (4.8mm)	10# Vac Pak	10234800

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