

DESCRIPTION

Stoody 19 is a solid core hardfacing electrode with easy slag removal. It has a moderate alloy content, providing a balanced performance on abrasion resistance and impact. It has an extruded coating containing the alloying elements. Deposits are not machinable or forgeable. Stoody 19 bonds well with carbon, low alloy, and manganese steels. Deposits are slightly magnetic on carbon and low alloy steels, but not on manganese steels, and will develop cross checks.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Moderate
Hardness	
On Carbon Steel	HRC 51 – 55
On Manganese Steel	HRC 45 - 49
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	Up to 2

ALLOY TYPE

Chromium Carbides in an Semi-Austenitic Matrix

TYPICAL APPLICATIONS

Typical applications include:

- Crusher Rolls
- Impact Breaker Bars
- Dredge Pump Shells and Impellers
- Scrapers

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	90 – 130	120 – 160
Position	Flat or Horizontal	Flat
Diameter, In. (mm)	3/16 (4.8)	1/4 (6.4)
Current, Amp. DCRP	140 – 220	175 – 300
Position	Flat	Flat

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
1/8" (3.2mm)	10# Vac Pak	11360000
5/32" (4.0mm)	10# Vac Pak	11356700
3/16" (4.8mm)	10# Vac Pak	11356800
1/4" (6.4mm)	10# Vac Pak	11356900