

**DESCRIPTION**

Stoody Super Build Up deposit is a low alloy steel that can be used both as a build-up and hardfacing material because it has good compressive strength and hardness. It is not intended to be used as an underbase for subsequent hardfacing. It can be used on carbon and low alloy steels, but not on manganese steels or cast iron.

**TYPICAL DEPOSIT CHARACTERISTICS**

Compressive Strength	Good
Impact Resistance	Moderate
Deposit Layers	Multiple
Hardness	HRC 35 – 40
Surface Cross Checks	No
Machinability	Good
Magnetic	Yes

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

<b>Diameter, in. (mm)</b>	<b>.045 (1.2)</b>	<b>1/16 (1.6)</b>
Current, Amp.	120 – 220	140 – 260
DCEP, AC		
Voltage	18 – 24	23 – 26
Position	Flat & Horizontal	Flat & Horizontal
Shielding Gas	98% Ar, 2% O <sub>2</sub>	None or CO <sub>2</sub>
Wire Extension	1/2" – 3/4"	1/2" – 1"

<b>Diameter, in. (mm)</b>	<b>3/32 (2.4)</b>
Current, Amp.	200 – 350
DCEP, AC	
Voltage	24 – 28
Position	Flat
Shielding Gas	None
Wire Extension	3/4" – 1 1/4"

**STANDARD SIZES & PACKAGING**

**ALLOY TYPE**

Low Alloy Steel

Diameter	Packaging	Part #
3/32" (2.4mm)	50# PP	11837900
3/32" (2.4mm)	200# HP	11466200
1/16" (1.6mm)	10# PS	11426600
1/16" (1.6mm)	33# WB	11426500
1/16" (1.6mm)	50# PP	11426400
.045" (1.2mm)	10# PS	11423700
.045" (1.2mm)	33# WB	11423600

**TYPICAL APPLICATIONS**

Typical applications include:

- Gear Teeth
- Sprockets
- Steel Shovel Pads
- Overlaying Carbon Steel Shafts