

DESCRIPTION

Stoody® Alloy C is a coated nickel based electrode that has excellent resistance to high heat and corrosion accompanied by abrasion / impact. Stoody Alloy C retains hardness up to 1200⁰F and has low frictional properties. Deposits are dense and smooth.

TYPICAL APPLICATIONS

Typical applications include:

- Tong bits
- Hot shear blades
- Hot trimming dies
- Bleeder valves
- Hot forging dies

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Excellent
Corrosion Resistance	Excellent
Hardness (2 layers - work hardened)	HRC 35 - 40
Hot Hardness	Excellent up to 1200 ⁰ F (650 ⁰ C)
Magnetic	No
Deposit Layers	Unlimited
Surface Cross Check	No
Machinability	Yes

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	3/32 (2.4)	1/8 (3.2)
Current, Amp. DCEP	55 – 100	80 - 120
Position	Flat	Flat
Diameter, In. (mm)	5/32(4.0)	3/16(4.8)
Current, Amp. DCEP	110 - 150	130 - 170
Position	Flat	Flat

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	0.04
Chromium	15.3
Iron	6.1
Manganese	0.1
Molybdenum	16.6
Silicon	0.5
Cobalt	0.1
Tungsten	4.0
Nickel	Balance

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
3/32" (2.4mm)	5# Vac Pak	11848400
1/8" (3.2mm)	10# Vac Pak	11412800
5/32" (4.0mm)	10# Vac Pak	10245700
3/16" (4.8mm)	10# Vac Pak	10245900

Stoody Company

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