

DESCRIPTION

Stoody® 31 is the most general purpose hardfacing electrode in Stoody's product line. It offers an excellent balance of abrasion resistance and impact strength, making it very versatile. Stoody 31 is a tubular electrode with an extruded coating. Deposits have a low coefficient of friction and provide good resistance to corrosion and heat. The deposits are not machinable or forgeable. Weldability is excellent with slag coverage that is virtually self-removing. Stoody 31 can be applied to carbon, low alloy, and manganese steels.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Moderate
Hardness	HRC 45 – 49
Magnetic	
on Carbon steel	Slightly
on Manganese steel	No
Surface Cross Checks	Yes
Deposit Layers	2
Machinable	No
Hot Wear Applications	Up to 950°F

ALLOY TYPE

Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

- Bucket Arms
- Chain Links
- Buckets
- Scrapers
- Rolling Mill Guides, Pulleys
- Blades
- Hammers
- Crusher Parts

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DC+, AC	100 – 120	120 – 180
Position	Flat / Horizontal	Flat
Diameter, In. (mm)	3/16 (4.8)	¼ (6.4)
Current, Amp. DC+, AC	170 – 240	250 – 325
Position	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Vac Pak	10206300
5/32" (4.0mm)	10# Vac Pak	10206400
3/16" (4.8mm)	10# Vac Pak	10206500
1/4" (6.4mm)	10# Vac Pak	10206600