

DESCRIPTION

Stoody 160 wire consists of tungsten carbide particles in a nickel silicon boron matrix. This microstructure gives Stoody 160 superior toughness, corrosion and excellent fine particle erosion resistance in slurry type applications.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Matrix Hardness Single Layer	HRC 50 - 60
Matrix Hardness Two Layer	HRC 50 - 60
Deposit Layers	2 Maximum
Surface Cross Check	Depends on application
Machinability	No

TYPICAL APPLICATIONS

Typical applications include:

- Dredge rotary cutter heads
- Pipe ID & filtering screens
- Drill bits & stabilizers

STANDARD SIZES & PACKAGING

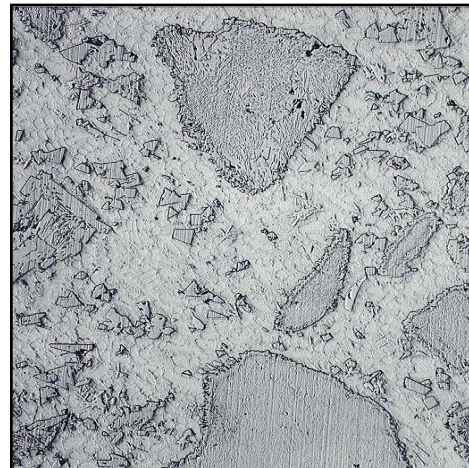
Diameter	Packaging	Part #
7/64" (2.8mm)	50# Poly Pak	11870100
3/32" (2.4mm)	50# Poly Pak	11927500
1/16" (1.6mm)	25# Wire Basket	11898800

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS*

GMAW		
Diameter, In. (mm)	7/64 (2.8)	3/32 (2.4)
Current, Amp. DCEP	275 – 355	250 – 325
Voltage	19 – 22	18 – 21
Shielding Gas	None	None
Wire Extension	5/8" - 1"	5/8" - 1"
WFS	<i>in/min</i>	70 – 100
	<i>(m/min)</i>	(1.8) – (2.5)
Position	Flat	Flat

GMAW		
Diameter, In. (mm)	1/16 (1.6)	
Current, Amp. DCEP	150 – 200	
Voltage	18 – 20	
Shielding Gas	75 - 80% Ar, Bal. CO ₂	
Wire Extension	1/2 - 5/8	
WFS	<i>in/min</i>	90 – 110
	<i>(m/min)</i>	(2.3) – (2.8)
Position	Flat	

***Microstructures are parameter sensitive. Use lowest possible heat input.**



MICROSTRUCTURE

200 X

Tungsten Carbides and Borides in a Nickel- Silicon Matrix

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PDS-WC-W-004

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