

DESCRIPTION

Stoody® 102 deposit has a composition and physical properties that are similar to those of H-12 tool steel. Weldability is very good and the wire can be applied out-of-position. Stoody 102 requires carbide tools for machining. It is good for hot wear applications up to 1100°F. Multiple layers can be applied without difficulty when proper preheat and interpass temperatures are maintained.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Moderate
Compressive Strength	Good
Hardness on 0.2% Carbon Steel	HRC 48-53
Deposit	Multiple
Magnetic	Yes
Surface Cross Checks	No
Machinability	Using Carbide Tools
Hot Wear Applications	Up to 1100°F

ALLOY TYPE

H-12 Tool Steel

TYPICAL APPLICATIONS

Typical applications include:

- Cable Sheaves
- Forging Dies
- Crane Wheels
- Hot & Cold Shear Blades
- Drillpipe Hardbonding
- Hot Work Extrusion Rolls

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, in. (mm)	.045 (1.2)
Amperage (DCEP)	135 – 185
Voltage	18 – 24
Position	Flat & Horizontal
Shielding Gas	98% Ar, 2% O ₂
Wire Extension, in (mm)	½" – ¾"
Diameter, in. (mm)	1/16 (1.6)
Amperage (DCEP)	225 – 275
Voltage	25 – 27
Position	Flat & Horizontal
Shielding Gas	None / 98% Ar, 2% O ₂
Wire Extension, in (mm)	½" – 1"

STANDARD SIZES & PACKAGING

Stoody 102-O

Diameter	Packaging	Part #
1/16" (1.6)	50# PP	11426700
1/16" (1.6)	33# WB	11426800

Stoody 102-G

Diameter	Packaging	Part #
1/16" (1/6)	50# PP	11422000
.045" (1.2)	33# WB	11422300
.045" (1.2)	10# PS	11422400

Stoody Company

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