

DESCRIPTION

Stoody 104 deposits have excellent resistance to impact and plastic deformation. Deposits are machinable with high speed tools, easily machinable with carbide tools, crack-free, and can be flame cut. Stoody 104 is ideal for build-up and for under base to support hardfacing. Maximum deposit thickness is unlimited.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Low
Impact Resistance	Excellent
Compressive Strength	Excellent
Hardness	HRC 29
Surface Cross Checks	No
Magnetic	Yes
Deposit Layers	Unlimited
Machinability	Yes

ALLOY TYPE

Low Alloy Steel

TYPICAL APPLICATIONS

Typical applications include:

- Build up prior to hardfacing of tractor rollers, idlers, trunnions, rolls, and cable drums.
- Shaft rebuilding.

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	3/32 (2.4)	7/64 (2.8)
Current, Amp. DC+	250 – 300	300 – 325
Voltage	28 – 30	28 – 30
Wire Extension	1" – 1 ½"	1" – 1 ½"
Flux Type	Stoody "S"	Stoody "S"
Position	Flat	Flat
Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DC+	350 – 400	425 – 475
Voltage	28 – 30	28 – 30
Wire Extension	1" – 1 ½"	1" – 1 ½"
Flux Type	Stoody "S"	Stoody "S"
Position	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
3/32" (2.4mm)	500# POP	11431100
7/64" (2.8mm)	60# Coil	11001400
1/8" (3.2mm)	60# Coil	11820300
1/8" (3.2mm)	100# Coil	11001500
1/8" (3.2mm)	200# HP	11040900
1/8" (3.2mm)	500# POP	11039500
1/8" (3.2mm)	750# POP	11902800
5/32" (4.0mm)	100# Coil	11001600
5/32" (4.0mm)	500# POP	11111900