STOODY
A THERMADYNE Company

Stoody® 133 & Stoody® 133-0

Open Arc / Gas Metal Arc Welding Wire

DESCRIPTION

Stoody 133 deposits offer good resistance to corrosion, heat and galling and can be applied in multiple layers crack free. Deposits are machinable with carbide tools and will polish to a mirror finish in service. It can be applied to carbon, low alloy, and manganese steels. It is recommended for parts where a low coefficient of friction is desirable and where cross checking is undesirable. The 1/16" & 3/32" diameter Stoody 133 can be applied in a twin arc spray operation, producing a thermal spray coating with an excellent balance of abrasion and corrosion resistance.

TYPICAL DEPOSIT CHARACTERISTICS

Corrosion Resistance	Good
Heat Resistance	Good
Galling Resistance	Good
Deposit Layers	Multiple
Hardness	
2 layers on Carbon Steel	HRC 39 – 42
2 layers on Manganese Steel	HRC 35 – 39
Surface Cross Checks	No
Machinability	Yes
Magnetic	Yes

ALLOY TYPE

Eutectic Chromium Carbides in a Semi-Austenitic Matrix

TYPICAL APPLICATIONS

- Slitter blades
- Rendering screws
- Debarking hammers
- Chipper knife components
- Log anvils
- Auger flights

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	**.045 (1.2)**	**1/16 (1.6)**
Current, Amp. DCRP	175 – 225	200 – 300
Voltage	20 – 24	22 – 26
Wire Extension	½" – ¾"	½" – 1"
Shielding Gas	98% Ar – 2% O_2	None or 100% CO_2
Position	Flat	Flat

Diameter, In. (mm)	**3/32 (2.4)**
Current, Amp. DCRP	250 – 350
Voltage	24 – 28
Wire Extension	1" – 1 ½"
Shielding Gas	None
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	**Packaging**	**Part #**
.045 (1.2mm)	33# Wire Basket	11867600
1/16" (1.6mm)	33# Wire Basket	11319000
1/16" (1.6mm)	50# Poly Pak	11288200
3/32" (2.4mm)	60# Coil	11288100

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