

DESCRIPTION

Stoody 105-G deposit is a low alloy steel developed for the rebuilding of carbon and low alloy steels parts used in applications involving metal-to-metal wear. Stoody 105-G requires carbide tools for machining. It is good for hot wear applications up to 600°F. Multiple layers can be applied without difficulty when proper preheat and interpass temperatures are maintained.

TYPICAL APPLICATIONS

Typical applications include:

- Tractor Rollers
- Shovel Idlers and Rollers
- Top Carrier Rolls
- Mine Car Wheels
- Undercarriage Parts
- Shovel House Roll
- Crane Wheels

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Moderate
Impact Resistance	Moderate
Hardness on 0.2% Carbon Steel	HRC 41 – 46
Deposit Layers	Multiple
Magnetic	Yes
Surface Cross Checks	No
Machinability	Using Carbide Tools
Hot Wear Applications	Up to 600°F

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/16 (1.6)
Current, Amp. DC+	250 – 300
Voltage	25 – 26
Wire Extension	¾" – 1"
Shielding Gas	98% Ar, 2% O ₂
Position	Flat & Horizontal

ALLOY TYPE

Low Alloy Steel

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/16" (1.6mm)	50# PP	11441100

Stoody Company

5557 Nashville Road • Bowling Green, KY 42101
1-800-227-9333

PDS-CS-W-004
Revision 1
07/24/02

Notice: The information contained or otherwise referenced herein is presented only as "typical", without guarantee or warranty. Stoody expressly disclaims any liability from any reliance thereon. Typical data are those obtained when welded and tested in accordance with Stoody's internal procedures. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Stoody.