STOODY
A Thermadyne Company

Stoody 100HD
Open Arc Welding Wire

DESCRIPTION

Stoody® 100HD is a high chromium-iron alloy developed for high deposition rate hardfacing of large surface areas for severe abrasion. It develops a very tight cross checking pattern. Stoody 100HD is generally limited to 2 layers although in rebuilding of coal pulverizer rolls, multiple layers can be used. Deposits are not machinable or forgeable and can be used in hot wear applications up to 900^{0}F (482^{0}C).

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Low
Surface Cross Checks	Yes
Magnetic	Yes
Hot Wear Application	Up to 900^{0}F (482^{0}C)
Hardness	55 – 62
Machinable	No
Deposit Layers	Up to 3
	Multi-Layer with special automatic operations

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

- Wear plate manufacturing
- Crusher roll rebuilding (coal pulverizer type)
- Large tillage tool repair
- Coal pulverizer roll & grinding ring

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS (DCEP)

Diameter, In. (mm)	**7/64 (2.8)**	**1/8 (3.2)**
Current, Amp., DC±	425 – 650	450 – 650
Voltage	27 – 30	30 – 34
Wire Extension	3/4” – 1¼”	1” – 1½”

STANDARD SIZES & PACKAGING

Diameter	**Packaging**	**Part #**
7/64” (2.8mm)	750# POP	11905600
7/64” (2.8mm)	500# POP	11484500
7/64” (2.8mm)	200# Half Pak	11501100
7/64” (2.8mm)	60# Coil	11848200
1/8” (3.2mm)	500# POP	11489700
1/8” (3.2mm)	200# Half Pak	11435900
1/8” (3.2mm)	60# Coil	11859000

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