

DESCRIPTION

Stoody 120 deposit is a high manganese alloy for applications involving wear and severe impact. Deposits are austenitic whether applied to carbon steel or manganese steel. Stoody 120 deposits work harden, are non-magnetic, are machinable with carbide tools, and can be flame cut.

TYPICAL DEPOSIT CHARACTERISTICS

Impact Strength	Excellent
Tensile Strength	133 KSI
Yield Strength	91.5 KSI
Elongation in 2"	20%
Hardness	
As Deposited	HRC 18
Work Hardened	HRC 55
Deposit Layers	Multiple
Surface Cross Checks	No
Machinability	Yes

ALLOY TYPE

Austenitic Manganese Steel

TYPICAL APPLICATIONS

- Railroad Track Components
- Crusher Cone Nuts and Mantles
- Crusher Hammer Rolls
- Impactor Bars and Rotors

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

	120-G	120-O
Diameter, In. (mm)	0.045 (1.2)	1/16 (1.6)
Current, Amp. DCRP	150 – 200	150 – 250
Voltage	23 – 27	23 – 27
Wire Extension	1/2" – 3/4"	1/2" – 1"
Shielding Gas	98 % Ar/ 2% O ₂	None or CO ₂
Position	Flat or Horizontal	Flat or Horizontal

	120
Diameter, In. (mm)	3/32 (2.4)
Current, Amp. DCRP	225 – 300
Voltage	23 – 27
Wire Extension	1" – 1 1/2"
Shielding Gas	None
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.045" (1.2mm)	33# WB	11438500
1/16" (1.6mm)	33# WB	11402500
1/16" (1.6mm)	50# PP	11420400
3/32" (2.4mm)	11363800	11086600