

DESCRIPTION

Stoody 105 deposit has very good resistance to metal-to-metal wear. Multiple layers, crack-free deposits can be obtained. When more than 3 layers are required, an underbase of Stoody 104 is recommended. Tungsten carbide tools and rigid, well powered equipment are required for machining. Deposits are difficult to flame cut.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Very Good
Impact Resistance	Good
Compressive Strength	Good
Hardness	HRC 45
Surface Cross Checks	No
Magnetic	Yes
Deposit Layers	3
Machinability	With Difficulty

TYPICAL APPLICATIONS

Low Alloy Steel

TYPICAL APPLICATIONS

Typical applications include:

- Rollers
- Mine Car Wheels
- Charging Car Wheels
- Idlers
- Arch Wheels

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	350 – 400	425 – 475
Voltage	29 – 31	29 – 31
Wire Extension	1 ¼” – 1 ½”	1 ¼” – 1 ½”
Flux Type	Stoody “S”	Stoody “S”
Position	Flat	Flat

Diameter, In. (mm)	7/64 (2.8)
Current, Amp. DCRP	300 – 350
Voltage	28 – 30
Wire Extension	1 ¼” – 1 ½”
Flux Type	Stoody “S”
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8” (3.2mm)	100# Coil	11002300
1/8” (3.2mm)	200# HP	11041000
1/8” (3.2mm)	500# POP	11039600
5/32” (4.0mm)	100# Coil	11002400
5/32” (4.0mm)	500# POP	11112000
7/64” (2.8mm)	60# Coil	11002200