

DESCRIPTION

Stoody 105B deposit has very good resistance to metal-to-metal wear. The deposits that are readily machinable with carbide tools. Multiple layer, crack-free deposits can be obtained. When more than 4 layers are required, an underbase of Stoody 104 is recommended. Deposits are difficult to flame cut.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Very Good
Impact Resistance	Good
Compressive Strength	Good
Hardness	43 HRC
Surface Cross Checks	No
Magnetic	Yes
Deposit Layers	4
Machinability	Yes

ALLOY TYPE

Low Alloy Steel

TYPICAL APPLICATIONS

Typical applications include:

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

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)
Current, Amp. DC+	350 – 400
Voltage	28 – 30
Wire Extension	1" – 1½"
Flux Type	Stoody "S" Flux
Position	Flat

Diameter, In. (mm)	5/32 (4.0)
Current, Amp. DC+	425 – 475
Voltage	28 – 30
Wire Extension	1" – 1½"
Flux Type	Stoody "S" Flux
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	100# Coil	11002000
1/8" (3.2mm)	200# HP	11041600
1/8" (3.2 mm)	500# POP	11040100
1/8" (3.2mm)	750# POP	11902600
5/32" (4.0mm)	500# POP	11112500