

DESCRIPTION

Stoody 33 is an all position tubular electrode that is recommended where sound deposits with low coefficient of friction and desired. It bonds well with carbon, low alloy, and manganese steels, and polishes to a mirror finish. Multiple layer deposits are sound and it can be heat treated. Stoody 33 has a versatile balance of abrasion wear resistance and impact strength.

TYPICAL APPLICATIONS

Typical applications include:

- Cement Mill Gudgeons
- Pump Shells
- Rendering Screws
- Debarking Hammers
- Dredge Parts
- Friction Type Guides
- Hog Anvils

TYPICAL DEPOSIT CHARACTERISTICS

| | |
|----------------------|-------------|
| Abrasion Resistance | Good |
| Impact Resistance | Moderate |
| Hardness | |
| On Carbon Steel | HRC 42 – 46 |
| On Manganese Steel | HRC 37 – 41 |
| Magnetic | |
| On Carbon Steel | Slightly |
| On Manganese Steel | No |
| Surface Cross Checks | No |
| Machinability | No |
| Deposit Layers | Multiple |

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

| | | |
|--------------------|-------------------|-------------------|
| Diameter, In. (mm) | 5/32 (4.0) | 3/16 (4.8) |
| Current, Amp. DCRP | 120 – 165 | 160 – 250 |
| Position | All | All |

ALLOY TYPE

Eutectic Chromium Carbides in an Austenitic Matrix

STANDARD SIZES & PACKAGING

| <u>Diameter</u> | <u>Packaging</u> | <u>Part #</u> |
|-----------------|------------------|---------------|
| 5/32" (4.0mm) | 10# Vac Pak | 11305700 |
| 3/16" (4.8mm) | 10# Vac Pak | 11305600 |