

DESCRIPTION

Stoody Self-Hardening is a general purpose solid core hardfacing electrode that offers a good balance of impact and abrasion resistance. It can be used on both metal-to-metal and metal-to-earth applications. Self-Hardening can be applied to carbon and low alloy steels. It can be forged at red heat, but it is not readily machinable.

TYPICAL APPLICATIONS

Typical applications include:

- Churn Drills
- Machine Componentes
- Sliding Metal Parts
- Trailer Hitches
- Bearings

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Good
Hardness, As Welded	HRC 52 – 58
Water Quenched from 1700°F	HRC 56 – 60
Furnace Cooled from 1700°F	HRC 19 – 23
Magnetic	Yes
Deposit Layers	2 Max
Surface Cross Checks	No
Machinability	No

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	100 – 150	150 – 200
Position	Flat	Flat
Length	14"	14"
Diameter, In. (mm)	3/16 (4.8)	¼ (6.4)
Current, Amp. DCRP	175 – 275	240 – 400
Position	Flat	Flat
Length	14"	18"

ALLOY TYPE

Martensitic Tool Steel

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Box	11172400
1/8" (3.2mm)	50# Bulk Pak	10204700
5/32" (4.0mm)	10# Box	11172500
5/32" (4.0mm)	50# Bulk Pak	10204800
3/16" (4.8mm)	10# Box	11172600
3/16" (4.8mm)	50# Bulk Pak	10204900
¼" (6.4mm)	50# Bulk Pak	10205000