

DESCRIPTION

Stoody 102 deposit provides excellent compressive strength along with abrasion resistance. The maximum deposit thickness is determined by the mass of the work piece – check free deposits can be made up to 3/4” thick on 24” diameter parts without cross checking. The all weld metal composition is similar to a H12 tool steel. Stoody 102 requires rigid, heavy duty equipment and carbide tools for machining. It is difficult to flame cut.

TYPICAL APPLICATIONS

Typical applications include:

- Work Rolls
- Vertical Edger Rolls
- Flaking Rolls
- Pipe Forming Rolls
- Leveler Rolls
- Dredge Ladder rolls
- Hot Work Extrusion Rolls
- Tool Steel Crane Wheels

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Good
Compressive Strength	High
Hardness	HRC 52
Surface Cross Checks	No
Magnetic	Yes
Deposit Thickness	Up to 3/4” on large dias. without cross checking
Machinability	With Difficulty

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	375 – 425	475 – 525
Voltage	28 – 30	29 – 31
Wire Extension	1” – 1 1/2”	1” – 1 1/2”
Flux Type	Stoody “S”	Stoody “S”
Position	Flat	Flat

ALLOY TYPE

H12 Tool Steel

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8” (3.2mm)	100# Coil	11002800
1/8” (3.2mm)	500# POP	11039400
5/32” (4.0mm)	100# Coil	11002900
5/32” (4.0mm)	500# POP	11111700

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