

DESCRIPTION

Stoody 103CP is a submerged arc wire used primarily on coal pulverizer rings and rolls and crusher mantles, and bowl liners. Deposits exhibit a fine relief check pattern which reduces distortion. The deposits are not machinable and cannot be flame cut. Stoody 103CP is intended for parts subject to extreme abrasion where relief checking can be tolerated.

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	350 – 400	425 – 475
Voltage	28 – 30	29 – 31
Wire Extension	1 ¼” – 1 ½”	1 ¼” – 1 ½”
Flux Type	Stoody “S”	Stoody “S”
Position	Flat	Flat

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Deposit Rate	12 lbs/hr
Hardness	HRC 52 – 58
Surface Cross Checks	Yes
Magnetic	Yes
Deposit Layers	Multiple
Machinability	No

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8” (3.2mm)	100# Coil	11428700
1/8” (3.2mm)	110# QP	11429100
1/8” (3.2mm)	200# HP	11428200
1/8” (3.2mm)	500# HP	11430100
5/32” (4.0mm)	100# Coil	11428800
5/32” (4.0mm)	500# POP	11430600

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

Typical applications include:

- Coal Pulverizing Rolls
- Crusher Mantles and Bowl Liners
- Steel Mill Guides

Stoody Company

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