

DESCRIPTION

Stoody 1102 is a solid core electrode designed for wear resistance in metal-to-metal applications. It has an extruded coating containing the alloying elements. Stoody 1102 has an all-weld-metal composition and physical properties that are similar to those of H-12 tool steel. Weldability is very good and can be applied in all-positions. Stoody 1102 requires carbide tools for machining. It is good for hot wear applications up to 1100°F. Multiple layers can be applied without difficulty when proper preheat, interpass temperature, and cooling rates are controlled.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Good
Compressive Strength	High
Hardness on 1020 Carbon Steel	HRC 52 – 58
Deposit Layers to ½"	4 Layers Nominal
Magnetic	Yes
Surface Cross Checks	No with Proper Heat
Machinability	Yes with Carbide Tools
Hot Wear Applications	Up to 1100°F

ALLOY TYPE

H12 Tool Steel

TYPICAL APPLICATIONS

Typical applications include:

- Cable Sheaves
- Forging Dies
- Crane Wheels
- Hot and Col Shear Blades
- Drillpipe Hard Banding
- Hot Work Extrusion Rolls

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)
Current, Amp. DCEP	125 – 150
Position	All
Length	14"
Diameter, In. (mm)	5/32 (4.0)
Current, Amp. DCEP	140 – 200
Position	All
Length	14"

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
1/8" (3.2mm)	10# Vac Pak	11857000
5/32" (4.0mm)	10# Vac Pak	11857100