STOODY
A THERMADYNE Company

Stoody® 100XHC
Open Arc Welding Wire

DESCRIPTION

Stoody 100XHC deposit is a high chromium-iron alloy recommended for application subject to severe abrasion and moderate impact and heat. The deposit surface develops very tight cross checking pattern and is generally limited to 2 layers. It can be used in hot wear applications up to 900°F.

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	**7/64 (2.8)**
Current, Amp. DCRP	225 – 375
Voltage	24 – 28
Wire Extension	¾" – 1 ¼"
Shielding Gas	None

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Low
Hardness	
1 pass on mild steel	HRC 55 – 59
2 passes on mild steel	HRC 60 – 66
1 pass on Manganese steel	HRC 46 – 50
2 passes on Manganese steel	HRC 51 – 55
Deposit Layers	2
Surface Cross Checks	Yes
Hot Wear Application	900°F
Machinable	No

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
7/64" (2.8mm)	60# Coil	11370000
7/64" (2.8mm)	200# HP	11384700

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

- Catalyst Piping
- Clinker Grinder Rolls
- Large Tillage Tool Repair
- Crushers

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