

**DESCRIPTION**

Stoody 104-TJ is a submerged arc wire intended for rebuilding oil drilling tool joints. It has excellent resistance to impact and plastic deformation. Deposits are crack-free, can be machined with high speed tools, are readily machinable with carbide tools, and can be flame cut. It can be applied in multiple layers.

**TYPICAL DEPOSIT CHARACTERISTICS**

Abrasion Resistance	Moderate
Impact Resistance	Excellent
Compressive Strength	Excellent
Hardness	HRC 30 – 37
Surface Cross Checks	No
Magnetic	Yes
Deposit Layers	Multiple
Machinability	Yes

**ALLOY TYPE**

Low Alloy Steel

**TYPICAL APPLICATIONS**

Typical applications include:

- Tool Joints

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>1/8 (3.2)</b>
Current, Amp. DC+	350 – 400
Voltage	28 – 30
Wire Extension	1" – 1 1/2"
Flux Type	Lincoln 860
Position	Flat

Diameter, In. (mm)	<b>3/32 (2.4)</b>
Current, Amp. DC+	250 – 300
Voltage	28 – 30
Wire Extension	1" – 1 1/2"
Flux Type	Lincoln 860
Position	Flat

**STANDARD SIZES & PACKAGING**

Diameter	Packaging	Part #
3/32" (2.4mm)	60# Coil	11824100
3/32" (2.4mm)	200# Half Pak	11865700
3/32" (2.4mm)	625# POP	11823800
1/8" (3.2 mm)	100# Coil	11478300
1/8" (3.2 mm)	200# Half Pak	11893100
1/8" (3.2 mm)	625# POP	11402400