

**DESCRIPTION**

Primary applications for Stoody 35 involve severe abrasion with moderate to heavy impact. It is normally used for earth-to-metal wear or wear due to abrasion of other particulate material. Stoody 35 is a solid core electrode with a heavy extruded coating that contains the alloying elements. It can be applied out of position. Deposits are uniform with excellent bead appearance and slag removal. Stoody 35 bonds readily to carbon, low alloy, and manganese steel. It develops surface checks and is not machinable or forgeable. Compressive strength is very high.

**TYPICAL DEPOSIT CHARACTERISTICS**

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Compressive Strength	Very High
Hardness	
On Carbon Steel	HRC 53 - 57
On Manganese Steel	HRC 50 - 53
Deposits May Work Harden To	HRC 58 - 60
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	Up to 2

**ALLOY TYPE**

Primary Chromium Carbides in an Austenitic Matrix

**TYPICAL APPLICATIONS**

Typical applications include:

- Bucket Teeth
- Augers and Screws (Earth Engaging)
- Crushing Equipment
- Tile Mixer Paddles
- Mill Hammers

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>1/8 (3.2)</b>	<b>5/32 (4.0)</b>
Current, Amp. DCRP	125 - 175	175 - 250
Position	Flat or Horizontal	Flat
Length	14"	14"
Diameter, In. (mm)	<b>3/16 (4.8)</b>	<b>1/4 (6.4)</b>
Current, Amp. DCRP	225 - 300	275 - 350
Position	Flat	Flat
Length	14"	18"

**STANDARD SIZES & PACKAGING**

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
1/8" (3.2mm)	10# Vac Pak	11322900
5/32" (4.0mm)	10# Vac Pak	11318200
3/16" (4.8mm)	10# Vac Pak	11318300
1/4" (6.4mm)	10# Vac Pak	11318400