

**DESCRIPTION**

Stoody® Build Up deposit is a low alloy steel that has excellent compressive strength and resistance to plastic deformation. This is an ideal alloy for use as an underbase for subsequent hardfacing. Several diameters are available for use both with and without gas shielding. Build Up has good machinability in the as-welded condition using carbide tools, and it can be forged at red heat. It is recommended for use on carbon and low alloy steels, but not on manganese steels or cast iron. It does not work harden and should not be used for joining.

**TYPICAL DEPOSIT CHARACTERISTICS**

Compressive Strength	Excellent
Resistance to Plastic Deformation	Excellent
Abrasion Resistance	Good
Impact Resistance	Low
Deposit Layers	Moderate
Hardness	Multiple
Surface Cross Checks	HRC 29
Machinability	No
Magnetic	Good
	Yes

**ALLOY TYPE**

Low Alloy Steel

**TYPICAL APPLICATIONS**

Typical applications include:

- Hammers
- Shafting
- Pump parts
- Steel mill wobblers & slip joints
- Carbon steel shovel pads
- Wheels burns
- Rolls
- Repairing battered rail

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

<b>Diameter, in. (mm)</b>	<b>.045 (1.2)</b>	<b>1/16 (1.6)</b>
Current, Amp.	175 – 225	200 – 300
DCEP		
Voltage	18 – 24	24 – 26
Position	Flat & Horizontal	Flat
Shielding Gas	98% Ar, 2% O <sub>2</sub>	None or CO <sub>2</sub>
Wire Extension	1/2" – 3/4"	1/2" – 1"
<b>Diameter, in. (mm)</b>	<b>3/32 (2.4)</b>	<b>7/64 (2.8)</b>
Current, Amp.	300 – 400	350 – 450
DCEP		
Voltage	26 – 28	26 – 28
Position	Flat	Flat
Shielding Gas	None	None
Wire Extension	3/4" – 1 1/4"	3/4" – 1 1/4"

**STANDARD SIZES & PACKAGING**

Diameter	Packaging	Part #
7/64" (2.8mm)	60# Coil	11000100
7/64" (2.8mm)	110# Quarter Pak	11142800
7/64" (2.8mm)	200# Half Pak	11813100
7/64" (2.8mm)	500# POP	11869900
3/32" (2.4mm)	60# Coil	11183600
1/16" (1.6mm)	10# Plastic Spool	11420000
1/16" (1.6mm)	33# Wire Basket	11304900
1/16" (1.6mm)	50# Poly Pak	11258300
.045" (1.2mm)	10# Plastic Spool	11423900
.045" (1.2mm)	33# Wire Basket	11423800