

DESCRIPTION

Stoody Build-Up LH deposit is a low alloy steel designed for low severity metal-to-metal wear. The electrode has a special low hydrogen coating which provides a high strength fusion bond on carbon and low alloy steels. As a base alloy for hardsurfacing overlays or for restoring parts to original dimensions, it provides a weld deposit with excellent compressive strength capable of absorbing heavy impact and/or compressive loads. It can be applied in multiple layers without cracking, spalling, or mushrooming. It is machinable in the as-welded condition with reasonable procedural care and can be forged at red heat. It is not recommended for manganese steel or cast iron and does not work harden. It should not be used for joining.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Low
Impact Resistance	Good
Hardness on Carbon Steel	
1 Layer	HRC 27
2 Layers	HRC 29
3 Layers	HRC 31
Tensile Strength	118,000 psi
Yield Strength	113,000 psi
Elongation	6%
Deposit Layers	Unlimited

ALLOY TYPE

Low Alloy Steel

TYPICAL APPLICATIONS

Typical applications include:

- Tractor Rollers
- Tractor and Shovel Idlers
- Machine Shafts
- Clevis Pins
- Steel Shovel Pads
- Gear Teeth
- Sprockets

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	100 – 185	140 – 250
Position	All	All
Length	14"	14"
Diameter, In. (mm)	3/16 (4.8)	1/4 (6.4)
Current, Amp. DCRP	180 – 310	200 – 360
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	11414100
5/32" (4.0mm)	10# Vac Pak	11412900
3/16" (4.8mm)	10# Vac Pak	11413000
1/4" (6.4mm)	10# Vac Pak	11413100