

DESCRIPTION

Stoodite®12 coated electrodes provide excellent hot hardness and abrasion resistance and good corrosion resistance. These properties make Stoodite®12 well suited for wood cutting saws and bars and for industrial cutting applications for carpet, plastics, paper and chemical industries. It bonds well to all steels, including stainless.

TYPICAL APPLICATIONS

Typical applications include:

- Valve plugs and seats
- Turbine engine seals
- Saw teeth
- Bearing areas
- Rotary cutters
- Chain saw guide bars

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Good
Corrosion Resistance	Good
Hardness (2 layer)	HRC 41 - 44
Hot Hardness	Excellent
Magnetic	No
Deposit Layers	2 Maximum
Surface Cross Check	No
Machinability	Use carbide tools
Specifications	
AWS / SFA A5.13-2000	ECoCr-B

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, in. (mm)	1/8 (3.2)	5/32(4.0)
Current, Amp. DCEP	90 - 120	135 - 160
Position	Flat	Flat

Diameter, In. (mm)	3/16 (4.8)	1/4 (6.4)
Current, Amp. DCEP	160 - 180	220 - 270
Position	Flat	Flat

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	1.3
Chromium	29.8
Iron	3.3
Manganese	0.1
Molybdenum	0.1
Nickel	2.2
Silicon	0.9
Tungsten	3.3
Cobalt	Balance

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Vac Pak	811211205125
5/32" (4.0mm)	10# Vac Pak	811211205156
3/16" (4.8mm)	10# Vac Pak	811211205187
1/4" (6.4mm)	10# Vac Pak	811211205250

Stoody Company

5557 Nashville Road • Bowling Green, KY 42101
1-800-227-9333

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