

DESCRIPTION

Stoody 2110 is a solid core electrode designed for build-up of austenitic manganese parts subject to high impact loading. It is a modified high chromium – high manganese steel that combines toughness and wear resistance. There is no limitation on deposit thickness. Stoody 2110 is not recommended for cast iron. It can be used on carbon steel or manganese steel base metal.

TYPICAL APPLICATIONS

Typical applications include:

- Shovel Pads
- Hammers
- Grate Bars
- Switch Points
- Roll Crushers
- Shovel Teeth
- Carbon or Manganese Steel Frogs
- Manganese Steel Components

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Excellent
Hardness	
On Carbon Steel – As Deposited	BHN 200
On Carbon Steel – Work Hardened	HRC 48 – 53
On Manganese Steel – As Deposited	BHN 210
On Manganese Steel – Work Hardened	HRC 50 – 55
Magnetic	No
Surface Cross Checks	No
Deposit Layers	Unlimited

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	100 – 130	125 – 190
Position	Flat	Flat
Length	14"	14"
Diameter, In. (mm)	3/16 (4.8)	¼ (6.4)
Current, Amp. DCRP	150 – 260	240 – 325
Position	Flat	Flat
Length	14"	14"

ALLOY TYPE

Austenitic Chromium Manganese Steel

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Vac Pak	11431300
5/32" (4.0mm)	10# Vac Pak	10202800
3/16" (4.8mm)	10# Vac Pak	10202900
¼" (6.4mm)	10# Vac Pak	10203000

Stoody Company

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NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data.
PROTECT YOURSELF AND OTHERS - Users should read and follow all recommended guidance on health and safety from their employer, the supplier, the manufacturer, and government authorities. These, at a minimum including the Warning Labels on the products and the Material Safety Data Sheets ("MSDS"). The MSDS and additional safety information may be found on materials or links at: www.stoody.com.