

DESCRIPTION

Stoody® XHC combines excellent weldability with a high deposition rate. It is a solid core electrode with an extruded graphitic coating containing the alloying elements. Deposits are highly resistant to both sliding and grinding abrasion, but they are not machinable or forgeable. Stoody® XHC retains good wear resistance up to 1000°F (538°C) and it bonds well with carbon, low alloy, and manganese steels.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Low
Hardness	
On Carbon Steel	HRC 60 - 66
On Manganese Steel	HRC 50 - 55
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Deposit Layers	2
Surface Cross Check	Yes
Machinability	No
Hot Wear Applications	Up to 1000°F

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

Typical applications include:

- Grader blades
- Harrow plows
- Slurry pipe

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. AC/DC	100 - 150	125 - 250
Position	Flat	Flat
Diameter, In. (mm)	3/16 (4.8)	1/4 (6.4)
Current, Amp. AC/DC	150 - 300	250 - 375
Position	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# box	11383000
5/32" (4.0mm)	10# box	11382700
3/16" (4.8mm)	10# box	11382500
1/4" (6.4mm)	10# box	11382400

Stoody Company

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PDS-CRC-E-009
Revision 3
January 4, 2008

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.
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