

**DESCRIPTION**

Stoody 104 deposits have excellent resistance to impact and plastic deformation. Deposits are machinable with high speed tools, easily machinable with carbide tools, crack-free, and can be flame cut. Stoody 104 is ideal for build-up and for under base to support hardfacing. Maximum deposit thickness is unlimited.

**TYPICAL DEPOSIT CHARACTERISTICS**

Abrasion Resistance	Low
Impact Resistance	Excellent
Compressive Strength	Excellent
Hardness	HRC 29
Surface Cross Checks	No
Magnetic	Yes
Deposit Layers	Unlimited
Machinability	Yes

**ALLOY TYPE**

Low Alloy Steel

**TYPICAL APPLICATIONS**

Typical applications include:

- Build up prior to hardfacing of tractor rollers, idlers, trunnions, rolls, and cable drums.
- Shaft rebuilding.

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>3/32 (2.4)</b>	<b>7/64 (2.8)</b>
Current, Amp. DC+	250 – 300	300 – 325
Voltage	28 – 30	28 – 30
Wire Extension	1" – 1 ½"	1" – 1 ½"
Flux Type	Stoody "S"	Stoody "S"
Position	Flat	Flat
Diameter, In. (mm)	<b>1/8 (3.2)</b>	<b>5/32 (4.0)</b>
Current, Amp. DC+	350 – 400	425 – 475
Voltage	28 – 30	28 – 30
Wire Extension	1" – 1 ½"	1" – 1 ½"
Flux Type	Stoody "S"	Stoody "S"
Position	Flat	Flat

**STANDARD SIZES & PACKAGING**

<b>Diameter</b>	<b>Packaging</b>	<b>Part #</b>
3/32" (2.4mm)	500# POP	11431100
7/64" (2.8mm)	60# Coil	11001400
1/8" (3.2mm)	60# Coil	11820300
1/8" (3.2mm)	100# Coil	11001500
1/8" (3.2mm)	200# HP	11040900
1/8" (3.2mm)	500# POP	11039500
1/8" (3.2mm)	750# POP	11902800
5/32" (4.0mm)	100# Coil	11001600
5/32" (4.0mm)	500# POP	11111900

**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 include 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](http://www.stoody.com).