

DESCRIPTION

Stoody 105 deposit has very good resistance to metal-to-metal wear. Multiple layers, crack-free deposits can be obtained. When more than 3 layers are required, an underbase of Stoody 104 is recommended. Tungsten carbide tools and rigid, well powered equipment are required for machining. Deposits are difficult to flame cut.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Very Good
Impact Resistance	Good
Compressive Strength	Good
Hardness	HRC 45
Surface Cross Checks	No
Magnetic	Yes
Deposit Layers	3
Machinability	With Difficulty

TYPICAL APPLICATIONS

Low Alloy Steel

TYPICAL APPLICATIONS

Typical applications include:

- Rollers
- Mine Car Wheels
- Charging Car Wheels
- Idlers
- Arch Wheels

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	350 – 400	425 – 475
Voltage	29 – 31	29 – 31
Wire Extension	1 ¼" – 1 ½"	1 ¼" – 1 ½"
Flux Type	Stoody "S"	Stoody "S"
Position	Flat	Flat

Diameter, In. (mm)	7/64 (2.8)
Current, Amp. DCRP	300 – 350
Voltage	28 – 30
Wire Extension	1 ¼" – 1 ½"
Flux Type	Stoody "S"
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	100# Coil	11002300
1/8" (3.2mm)	200# HP	11041000
1/8" (3.2mm)	500# POP	11039600
5/32" (4.0mm)	100# Coil	11002400
5/32" (4.0mm)	500# POP	11112000
7/64" (2.8mm)	60# Coil	11002200

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.