

## DESCRIPTION

Primary applications for Stoody 35 involve severe abrasion with moderate to heavy impact. It is normally used for earth-to-metal wear or wear due to abrasion of other particulate material. Stoody 35 is a solid core electrode with a heavy extruded coating that contains the alloying elements. It can be applied out of position. Deposits are uniform with excellent bead appearance and slag removal. Stoody 35 bonds readily to carbon, low alloy, and manganese steel. It develops surface checks and is not machinable or forgeable. Compressive strength is very high.

## TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Compressive Strength	Very High
Hardness	
On Carbon Steel	HRC 53 - 57
On Manganese Steel	HRC 50 - 53
Deposits May Work Harden To	HRC 58 - 60
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	Up to 2

## ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

## TYPICAL APPLICATIONS

Typical applications include:

- Bucket Teeth
- Augers and Screws (Earth Engaging)
- Crushing Equipment
- Tile Mixer Paddles
- Mill Hammers

## OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	<b>1/8 (3.2)</b>	<b>5/32 (4.0)</b>
Current, Amp. DCRP	125 - 175	175 - 250
Position	Flat or Horizontal	Flat
Length	14"	14"

Diameter, In. (mm)	<b>3/16 (4.8)</b>	<b>¼ (6.4)</b>
Current, Amp. DCRP	225 - 300	275 - 350
Position	Flat	Flat
Length	14"	18"

## STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Vac Pak	11322900
5/32" (4.0mm)	10# Vac Pak	11318200
3/16" (4.8mm)	10# Vac Pak	11318300
¼" (6.4mm)	10# Vac Pak	11318400

**Stoody Company**

5557 Nashville Road • Bowling Green, KY 42101  
1-800-426-1888

PDS-CRC-E-011  
Revision 1  
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.

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