

GROUP 3: METAL TO EARTH FOR MODERATE TO SEVERE IMPACT AND MODERATE TO SEVERE ABRASION

STOODY® SELF-HARDENING - COATED

STOODY SELF-HARDENING, is a solid core electrode with an extruded coating containing the alloying elements. It is magnetic on carbon or low alloy steels.

Welding Procedures/Characteristics: Can be applied AC or DCEP (reverse polarity). Out of position characteristics are limited. Limit weave beads to 3/4" or use stringers. Maximum of three layers if a crack free deposit is desired. Can be applied to carbon, low alloy, and manganese steel. Can be forged at red heat; not readily machinable.

Applications: Churn Drills, Trailer Hitch, Machine Components, Bearings, Sliding Metal Parts

Typical Chemical Composition:

Alloy Content – 12% (Chromium, Manganese, Silicon, Carbon)
Iron Base

Typical Mechanical Properties:

Hardness:
All Weld Metal52-58 HRC
2 Layers (weave beads) - Mild Steel.....52-56 HRC
Water-quenched from 1700°F (925°C).....56-59 HRC
Furnace-cooled from 1700°F (925°C).....19-22 HRC
2 Layers (weave beads) - 1045 Steel.....54-58 HRC
Water-quenched from 1700°F (925°C).....56-60 HRC
Furnace-cooled from 1700°F (925°C).....19-23 HRC

Part Number	Packaging	Dimensions Diameter x Length	Amperage (AC, DC±)
■ 11172400	10 lb Box (4.5 kg)	1/8" x 14" (3.2 mm x 35.6 cm)	110 – 150
■ 11172500	10 lb Box (4.5 kg)	5/32" x 14" (4.0 mm x 35.6 cm)	150 – 200
11172600	10 lb Box (4.5 kg)	3/16" x 14" (4.8 mm x 35.6 cm)	175 – 275

STOODY® 33 - COATED

STOODY 33 is an all-position tubular electrode recommended where sound deposits with low coefficient of friction are desired. It bonds well with carbon, low alloy, and manganese steels, and polishes to a mirror finish. Multiple layer deposits are sound, and can be heat treated. Stody 33 has a versatile balance of abrasion wear resistance and impact strength.

Welding Procedures/Characteristics: Can be applied AC or DC, either polarity - DCEP (reverse preferred). Can be applied in multiple layers. With proper welding procedures, can be applied crack-free. The deposit is non-machinable and can be applied to carbon, low alloy and manganese steels.

Applications: Cement Mill Gudgeons, Pump Shells, Rendering Screws, Debarking Hammers, Dredge Parts, Friction Type Guides, Hog Anvils

Typical Chemical Composition:

Alloy Content – 32% (Chromium, Carbon, Manganese, Molybdenum, Nickel, Silicon)
Iron Base

Typical Mechanical Properties:

Abrasion Resistance Good
Impact Resistance..... Moderate
Hardness:
On Carbon Steel.....42-46 HRC
On Manganese Steel.....37-41 HRC
Magnetic:
On Carbon Steel..... Slightly
On Manganese Steel..... No

Part Number	Packaging	Dimensions Diameter x Length	Amperage (AC, DC±)
■ 11305700	10 lb Vac Pak (4.5 kg)	5/32" x 14" (4.0 mm x 35.6 cm)	120 – 165
■ 11305600	10 lb Vac Pak (4.5 kg)	3/16" x 14" (4.8 mm x 35.6 cm)	160 – 250

STOODY® 19 - COATED

STOODY 19 is a solid core electrode with an extruded coating containing the alloying elements. This electrode has excellent welder appeal. It bonds well with carbon or alloy steel including manganese.

Welding Procedures/Characteristics: Apply in weave beads using AC or DC, either polarity - DCEP (reverse preferred). Limit to two layers. A severe water quench should be avoided. Easy slag removal with excellent out of position characteristics. Deposits are slightly magnetic on carbon and low alloy steels. Not machinable or forgeable. Deposits will develop cross checks

Applications: Crusher Rolls, Dredge Pump Shells Impellers, Impact Breaker Bars Scrapers

Typical Chemical Composition:

Alloy Content – 26% (Chromium, Carbon, Molybdenum, Manganese, Silicon)
Iron Base

Typical Mechanical Properties:

Hardness:
2 Layers - Mang. Steel45-49 HRC
2 Layers - Med. Carbon51-55 HRC

Part Number	Packaging	Dimensions Diameter x Length	Amperage (AC, DC±)
■ 11360000	10 lb Vac Pak (4.5 kg)	1/8" x 14" (3.2 mm x 35.6 cm)	90 – 130
■ 11356700	10 lb Vac Pak (4.5 kg)	5/32" x 14" (4.0 mm x 35.6 cm)	120 – 160
■ 11356800	10 lb Vac Pak (4.5 kg)	3/16" x 14" (4.8 mm x 35.6 cm)	140 – 220
11356900	10 lb Vac Pak (4.5 kg)	1/4" x 18" (6.4 mm x 45.7 cm)	175 – 300

Products marked by the "■" symbol are typically stocked items. All others manufactured upon customer request - may require a minimum quantity and/or may be subject to production lead time. Contact customer care or your sales representative with any questions.