

STOODY® 2110

Shielded Metal Arc Welding Electrode

Stoody 2110 is a solid core electrode designed for build-up of austenitic manganese parts subject to high impact loading. It is a modified high chromium - high manganese steel that combines toughness and wear resistance. There is no limitation on deposit thickness. Stoody 2110 is not recommended for cast iron. It can be used on carbon steel or manganese steel base metal.

TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Good
Impact Resistance	Excellent
Hardness	
On Carbon Steel - As Deposited, BHN	200
On Carbon Steel - Work Hardened, HRC	48 - 53
On Manganese Steel - As Deposited, BHN	210
On Manganese Steel - Work Hardened, HRC	50 - 55
Magnetic	No
Surface Cross Checks	No
Deposit Layers	Unlimited

ALLOY TYPE

Austenitic Chromium Manganese Steel

TYPICAL APPLICATIONS

- Shovel pads
- Hammers
- Grate bars
- Switch points
- Roll crushers
- Shovel teeth
- Carbon or manganese steel frogs
- Manganese steel components

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

1/8" (3.2 mm)	
Current, amp	100 – 130
Position	Flat
Length, in (mm)	14 (355)
5/32" (4.0 mm)	
Current, amp	125 – 190
Position	Flat
Length, in (mm)	14 (355)
3/16" (4.8 mm)	
Current, amp	150 – 260
Position	Flat
Length, in (mm)	14 (355)
1/4" (6.4 mm)	
Current, amp	240 – 325
Position	Flat
Length, in (mm)	14 (355)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2 mm)	10 lb (4.5 kg) Vacuum Pak	11431300
5/32" (4.0 mm)	10 lb (4.5 kg) Vacuum Pak	10202800
3/16" (4.8 mm)	10 lb (4.5 kg) Vacuum Pak	10202900
1/4" (6.4 mm)	10 lb (4.5 kg) Vacuum Pak	10203000

PDS-MN-E-006
Revision 3
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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 including the Warning Labels on the products and the Safety Data Sheets ("SDS"). The SDS and additional safety information may be found on materials or links at: Stoody.com.