

STOODY® SELF-HARDENING

Shielded Metal Arc Welding Electrode

Stoody Self-Hardening is a general purpose solid core hardfacing electrode that offers a good balance of impact and abrasion resistance. It can be used on both metal-to-metal and metal-to-earth applications. Self-Hardening can be applied to carbon and low alloy steels. It can be forged at red heat, but it is not readily machinable.

TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Good
Impact Resistance	Good
Hardness:	
As Welded, HRC	52 – 58
Water Quenched from 1700°F (927°C), HRC	56 – 60
Furnace Cooled from 1700°F (927°C), HRC	19 – 23
Magnetic	Yes
Deposit Layers	2 Max
Surface Cross Checks	No
Machinability	No

ALLOY TYPE

Martensitic Tool Steel

TYPICAL APPLICATIONS

- Churn drills
- Machine components
- Sliding metal parts
- Trailer hitches
- Bearings
- Crusher jaws

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

1/8" (3.2 mm)	
Current, amp	100 – 150
Position	Flat
Length, in (mm)	14 (355)
5/32" (4.0 mm)	
Current, amp	150 – 200
Position	Flat
Length, in (mm)	14 (355)
3/16" (4.8 mm)	
Current, amp	175 – 275
Position	Flat
Length, in (mm)	14 (355)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2 mm)	10 lb (4.5 kg) Box	11172400
5/32" (4.0 mm)	10 lb (4.5 kg) Box	11172500
3/16" (4.8 mm)	10 lb (4.5 kg) Box	11172600

PDS-CRC-E-001
Revision 2
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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.