Special Purpose and Hardfacing Consumables
Stoody is the world’s leader in the production of welding wires and welding electrodes used to combat various types of wear and corrosion. Our extensive family of MIG welding products includes iron, nickel, cobalt, tungsten and vanadium based alloys. Some of the major industries we serve are power generation, mining, construction, railroad, steel, foundry, oil and gas production and exploration as well as the pulp and paper industry.

Stoody is given credit for the creation of the term ‘hardfacing’. Founded by two brothers in Southern California in 1921, the company has grown to be a world class supplier providing hardfacing and high alloy products to almost every major industry in the world.

KEY TO ICONS

- Requires shielding gas
- No shielding gas required
- Direct current - electrode positive
- Alternating and Direct Current
- Alternating current or Direct Current electrode positive
- Suitable for overhead welding
- Suitable for vertical up welding
- Suitable for side horizontal welding
- Suitable for HV (horizontal/vertical) fillet welding
- Suitable for flat welding
- Copper-coated seamless flux cored wire
- Weld metal hardness
- Open circuit voltage

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Manual Arc Hardfacing Electrodes

Stoody 33

- Highly alloyed manual arc electrode.
- High Chromium Carbide Iron deposit.
- Primary Chromium Iron Carbides in a single layer.
- Ideal for coarse abrasion and low to moderate impact loading.
- Typical applications include the hard surfacing of crusher cones and mantles, swing hammers, bucket teeth and lips, dozer end plates and sugar mill rolls.

Typical Weld Deposit Analysis:
- Single layer on Mild Steel
  - C: 1.9%  Mn: 0.8%  Si: 0.6%  Cr: 25%
  - Ni: 3%  Mo: 0.8%  Fe: Bal

Typical Weld Deposit Hardness:
- HRC HV30
  - All weld metal deposit 44 420

Finishing Recommendations:
- Grinding only

Comparable Thermadyne Product:
- Stoody 100 HC-O/101 HC-G/O tubular wire
  (AS/NZS 2576: 2360-B5/87)

Classifications:
- AS/NZS 2756: 2145-A4
- WTIA Tech. Note 4: 2145-A4

Packaging and Operating Data:

<table>
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<th>Size mm</th>
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AC (minimum 50 OCV) DC+ polarity.

ACDC Tube Borium

- Highly alloyed tubular electrode.
- Partially dissolved Tungsten Carbides bonded in an iron rich matrix.
- Resistant to extreme abrasion and low impact loading.
- Typical applications include drill bits, augers and scraper blades.

Typical Weld Deposit Analysis*:
- Single layer on Mild Steel
  - C: 3.1%  Mn: 0.9%  W: 44%  Cr: 6%  Fe: Bal
  - All weld metal deposit
    - C: 3.7%  Mn: 1.9%  W: 53%  Cr: 7%  Fe: Bal

Typical Weld Deposit Hardness:
- HRC HV30
  - Single layer on Mild Steel 62 750
  - All weld metal deposit 64 800

Deposits contain Tungsten Carbides with hardness up to 2,200 HV.

Finishing Recommendations:
- Grinding only

Comparable Thermadyne Product:
- Stoody 130-O tubular hardfacing wire
  (AS/NZS 2576: 3460-B7)

Classifications:
- AS/NZS 2756: 3460-A1
- WTIA Tech. Note 4: 3460-A1

Packaging and Operating Data:

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AC (minimum 50 OCV) DC+ polarity.

Stoody 160-E

- Highly alloyed tubular electrode.
- Partially dissolved Tungsten Carbides bonded in a nickel silicon boron matrix.
- Resistant to extreme abrasion and low impact loading.
- For the hardfacing of drill bits, cutter heads and dredgers.

Typical Weld Deposit Analysis*:
- Single layer on Mild Steel
  - C: 2.2%  Mn: 0.2%  Si: 0.4%  B: 1.2%  W: 45%  Ni: Bal
  - All weld metal deposit
    - C: 3.2%  Mn: 0.3%  Si: 0.6%  B: 1.5%  W: 54%  Ni: Bal

Typical Weld Deposit Hardness:
- HRC HV30
  - Single layer on Mild Steel 62 750
  - All weld metal deposit 64 800

Deposits contain Tungsten Carbides with hardness up to 2,200 HV.

Finishing Recommendations:
- Grinding only

Comparable Thermadyne Product:
- Stoody 160/160 DM tubular hardfacing wire
  (AS/NZS 2576: 3665-B7)

*Actual weld deposit consists of undisclosed Tungsten Carbide particles in a matrix of C-W-O-Fe. The analysis of the matrix will vary with the proportion of Tungsten Carbides dissolved during welding. 
**Dynamang-O**

- Self shielded (-O) tubular hardfacing wire.
- Tough, work hardening Austenitic Manganese Steel deposit.
- Typical applications include the repair of Manganese steel crusher rolls, jaw and hammer crushers, gyratory mantles, blow bars and dredge pump cutters, etc.

**Typical All Weld Metal Deposit Analysis:**
- C: 0.90%
- Mn: 13.40%
- Si: 0.37%
- Ni: 2.7%
- Cr: 2.50%
- Fe: Bal

**Typical Weld Deposit Properties:**
- Yield Stress: 615 MPa
- Tensile Strength: 810 MPa
- Elongation: 21%

**Typical Weld Deposit Hardness:**
- HRC HV30
  - All weld metal deposit: 17
  - Work hardened: 42

**Finishing Recommendations:**
- Machinable as deposited

**Recommended Shielding Gas:**
- Open arc or welding grade CO2: ISO14175: C1

**Comparable Thermadyne Product:**
- Cobalarc Mangcraft extruded electrode (AS/NZS 2576: 1215-A4)

**Classifications:**
- AS/NZS 2756: 1215-B7
- WTIA Tech. Note 4: 1215-B7

**Packaging and Operating Data:**

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<th>Wire Diam. mm</th>
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<th>Weight</th>
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<tbody>
<tr>
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<td>12-25</td>
<td>Spool</td>
<td>15kg</td>
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<tr>
<td>2.8</td>
<td>275-375</td>
<td>25-28</td>
<td>20-45</td>
<td>Coil</td>
<td>27kg</td>
</tr>
</tbody>
</table>

DC electrode positive.

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**Build Up-O**

- Self shielded (-O) tubular build-up wire.
- Tough, machinable low carbon pearlitic steel deposit.
- Resistant to high compressive loading.
- Ideal as an underbase prior to hardfacing.
- For rebuilding worn steel components.

**Typical All Weld Metal Deposit Analysis:**
- C: 0.10%
- Mn: 2.00%
- Si: 0.50%
- Cr: 1.00%
- Mo: 0.25%
- Fe: Bal

**Typical Weld Deposit Hardness:**
- HRC HV30
  - Single layer on Mild Steel: 28
  - All weld metal deposit: 30

**Finishing Recommendations:**
- Machinable

**Recommended Shielding Gas:**
- Open arc or welding grade CO2: ISO14175: C1

**Comparable Thermadyne Products:**
- Cobalarc 350 extruded electrode (AS/NZS 2576: 1435-A4)
- Stoody Super Build Up-G (AS/NZS 2576: 1435-B5)

**Classifications:**
- AS/NZS 2756: 1125-B7
- WTIA Tech. Note 4: 1125-B7

**Packaging and Operating Data:**

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<td>2.8#</td>
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<td>2.8#</td>
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<td>226kg</td>
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</table>

DC electrode positive #Indent items

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**Super Build Up-G**

- Gas (-G) tubular hardfacing wire.
- Tough, machinable low carbon martensitic steel deposit.
- Recommended for the build-up and surfacing of steel track rolls, idler wheels, track pads, drive sprockets, pins, links and other components subject to abrasion and/or metal-to-metal wear.
- 1.2mm & 1.6mm sizes can be used for vertical surfacing by depositing overlapping horizontal stringer passes.
- 1.2mm & 1.6mm wires are B5 type wires which require a shielding gas.

**Typical All Weld Metal Deposit Analysis:**
- C: 0.20%
- Mn: 1.5%
- Si: 0.4%
- Cr: 2.0%
- Mo: 0.5%
- Fe: Bal

**Typical Weld Deposit Hardness:**
- HRC HV30
  - Single layer on Mild Steel: 30
  - All weld metal deposit: 40

**Finishing Recommendations:**
- Machinable. Carbide tools recommended.

**Recommended Shielding Gas:**
- Ar + 1-3% O2: ISO14175: M13
- Ar + 10-25% CO2 or equiv.: ISO14175: M21

**Comparable Thermadyne Product:**
- Cobalarc 350 extruded electrode (AS/NZS 2576: 1435-A4)

**Classifications:**
- 1.2mm & 1.6mm AS/NZS 2756: 1435-B5
- WTIA Tech. Note 4: 1435-B5

**Packaging and Operating Data:**

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<th>Wire Diam. mm</th>
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<tr>
<td>1.2</td>
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<td>18-24</td>
<td>15-20</td>
<td>Spool</td>
<td>15kg</td>
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<td>1.6</td>
<td>140-250</td>
<td>23-26</td>
<td>15-25</td>
<td>Spool</td>
<td>15kg</td>
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</table>

DC electrode positive
Stoody 105-G

- 1.6mm gas shielded tubular wire.
- Tough, machinable, crack-free steel deposit.
- Resistant to high compressive loading.
- For re-building worn steel components such as tractor rollers, crane wheels, idler rolls.

Typical All Weld Metal Deposit Analysis:
- C: 0.2%
- Mn: 2.0%
- Si: 1.3%
- Cr: 2.8%
- Mo: 0.4%
- V: 0.15%
- Fe: Bal

Deposit Characteristics:
- Abrasion resistance: Very good
- Impact resistance: Good
- Compressive strength: Good
- Hardness: 45HRC
- Surface cross checks: No
- Magnetic: Yes
- Deposit layers: Three
- Machinability: With difficulty

Recommended Shielding Gas:
- Argon + 2% O2 ISO14175: M13

Packaging and Operating Data:
- Wire Diam. mm Range (amps) Voltage Range (volts) Electrode Stickout mm Pack Type Pack Weight Part No
- 1.6 250-300 25-26 20-25 Coil 27kg 11441100

DC electrode positive

Stoody 102-O/Cobremax

- Self shielded (-O) tubular build-up wire.
- H12 tool steel type deposit.
- Resistant to high corrosive loading.
- Good for hotwear applications up to 600°C.
- For rebuilding worn steel components such as crane wheels, forging dies and shear blades.

Typical All Weld Metal Deposit Analysis:
- C: 0.4%
- Mn: 2.00%
- Si: 0.9%
- Cr: 7.2%
- Mo: 1.4%
- W: 1.2%
- Fe: Bal

Recommended Shielding Gas:
- Open arc or welding grade CO2 ISO14175: C1

Comparable Thermadyne Product:
- Cobalarc 650 extruded electrode (AS/NZS 2576: 1855-A4)

Packaging and Operating Data:
- Wire Diam. mm Range (amps) Voltage Range (volts) Electrode Stickout mm Pack Type Pack Weight Part No
- 2.4 200-350 24-28 20-30 Coil 27kg 11906700
- 2.8# 300-450 26-30 20-35 Coil 27kg 11891800

DC electrode positive  #Indent item

Stoody RA45-O

- Self shielded (-O) tubular hardfacing wire.
- Seamless copper coated sheath for outstanding arc starting and wire feeding.
- Developed for out of position 'open arc' hard surfacing of sugar mill rolls.
- Martensitic steel surfacing deposit for enhanced roll toughness and wear resistance.

Typical All Weld Metal Deposit Analysis:
- C: 0.4%
- Mn: 2.00%
- Si: 0.9%
- Cr: 7.2%
- Mo: 1.4%
- W: 1.2%
- Fe: Bal

Recommended Shielding Gas:
- CO2: ISO14175: C1

Comparable Thermadyne Product:
- Stoody 117 Hardfacing wire

Welding positions:
- For roller arcing applications, Stoody RA45-O can be used in the flat, horizontal, vertical up and vertical down welding positions.
- For conventional hardfacing applications Stoody RA45-O is restricted to use in the flat and horizontal welding positions.

Packaging and Operating Data:
- Wire Diam. mm Range (amps) Voltage Range (volts) Electrode Stickout mm Pack Type Pack Weight Part No
- 2.0# 240-300 28-35 40-50 Coil 25kg 11122100
- 2.8 300-350 30-35 40-50 Coil 25kg 11122200

DC electrode positive  #Indent item
**Stoody BoroClad-O**

- Self shielded (-O) tubular hardfacing wire.
- Seamless copper coated sheath for outstanding arc starting and wire feeding.
- Developed for out of position 'open arc' hard surfacing of sugar mill rolls.
- Martensitic steel surfacing deposit for enhanced roll toughness and wear resistance.

**Classifications:**

- AS/NZS 2756: 2260-87
- WTiA Tech. Note 4: 2260-87

**Packaging and Operating Data:**

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<td>2.8</td>
<td>300-350</td>
<td>30-35</td>
<td>40-50</td>
<td>Spool</td>
<td>25kg</td>
<td>11133300</td>
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</table>

DC electrode positive

**Typical All Weld Metal Deposit Analysis:**

- C: 0.60%
- Mn: 1.70%
- Si: 1.40%
- Cr: 6.20%
- Fe: Bal

**Typical Weld Deposit Hardness:**

- HRC HV30
  - Single layer on Cast Iron: 52 - 540
  - All weld metal deposit: 62 - 750

**Finishing Recommendations:**

- Grinding only.

**Recommended Shielding Gas:**

- Open arc
  - Welding grade CO2 or Argon + CO2 gas mixtures

**Comparable Thermadyne Product:**

- Cobalarc 650 extruded electrode (AS/NZS 2576: 1855-A4)

**Welding positions:**

- For roller arcing applications, Stoody BoroClad-O can be used in the flat, horizontal, vertical up and vertical down welding positions.
- For conventional hardfacing applications Stoody BoroClad-O is restricted to use in the flat and horizontal welding positions.

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**Stoody 965-G/O**

- Gas (-G) & Self shielded (-O) tubular hardfacing wires.
- Air hardening, crack free Martensitic steel deposit.
- Resistant to high particle abrasion and moderate impact loading.
- Typical applications include the surfacing of agricultural points, shares and tynes, sand dredge cutter heads, dredge rollers and tumblers, conveyor screws, bucket lips, etc.

**Classifications:**

- AS/NZS 2756: 1855-B5
- WTiA Tech. Note 4: 1855-B5
- 1.2mm & 1.6mm: 1855-B7
- 2.0 & 2.4mm: 1855-B7

**Packaging and Operating Data:**

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<td>2.4</td>
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<td>20-30</td>
<td>Coil</td>
<td>27kg</td>
<td>11869900</td>
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</table>

DC electrode positive

**Typical All Weld Metal Deposit Analysis:**

- C: 0.80%
- Mn: 1.70%
- Si: 1.40%
- Cr: 6.20%
- Fe: Bal

**Typical Weld Deposit Hardness:**

- HRC HV30
  - Single layer on Mild Steel: 55 - 600
  - All weld metal deposit: 58 - 640

**Finishing Recommendations:**

- Not machinable. Grinding only.

**Recommended Shielding Gas:**

- 1.2mm & 1.6mm: 965-G/965-O
  - Ar + 25% CO2: ISO14175: M13
- 2.0 & 2.4mm: 965-O
  - Open arc or welding grade CO2: ISO14175: C1

**Comparable Thermadyne Product:**

- Cobalarc 650 extruded electrode (AS/NZS 2576: 1855-A4)

**Welding positions:**

- For roller arcing applications, Stoody 965-G/O can be used in the flat, horizontal, vertical up and vertical down welding positions.
- For conventional hardfacing applications Stoody 965-G/O is restricted to use in the flat and horizontal welding positions.

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**Stoody 965 AP-G**

- Gas (-G) shielded all-positional.
- Air hardening, crack free, martensitic steel deposit.
- Resistant to hard particle abrasion and moderate impact loading.
- Typical applications include the surfacing of agricultural points, shares and tynes, sand dredge cutter heads, dredge rollers and tumbers, conveyor screws, bucket lips, etc.

**Classifications:**

- AS/NZS 2756: 2260-B7
- WTiA Tech. Note 4: 2260-B7

**Packaging and Operating Data:**

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<th>Wire Diam. mm</th>
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<th>Pack Weight</th>
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<td>40-50</td>
<td>Spool</td>
<td>25kg</td>
<td>11133100</td>
</tr>
<tr>
<td>2.8</td>
<td>300-350</td>
<td>30-35</td>
<td>40-50</td>
<td>Spool</td>
<td>25kg</td>
<td>11133300</td>
</tr>
</tbody>
</table>

DC electrode positive

**Typical All Weld Metal Deposit Analysis:**

- C: 0.80%
- Mn: 1.70%
- Si: 1.40%
- Cr: 6.20%
- Fe: Bal

**Typical Weld Deposit Hardness:**

- HRC HV30
  - Single layer on Mild Steel: 55 - 600
  - All weld metal deposit: 58 - 640

**Finishing Recommendations:**

- Not machinable. Grinding only.

**Recommended Shielding Gas:**

- Open arc
  - Welding grade CO2 or Argon + CO2 gas mixtures

**Comparable Thermadyne Product:**

- Cobalarc 650 extruded electrode (AS/NZS 2576: 1855-A4)

**Welding positions:**

- For roller arcing applications, Stoody 965 AP-G can be used in the flat, horizontal, vertical up and vertical down welding positions.
- For conventional hardfacing applications Stoody 965 AP-G is restricted to use in the flat and horizontal welding positions.
**Stoody 850-O**

- Self shielded (-O) tubular hardfacing wire.
- Air hardening, crack prone high carbon, Martensitic steel deposit.
- Resistant to severe abrasion and low impact loading.
- Typical applications include the hard surfacing of agricultural, mining and materials handling equipment including tynes, points, conveyor screws, dredge buckets, cane harvester cutters/elevators and sugar mill scraper plates.

**Classifications:**

AS/NZS 2756: 1865-B7

WTIA Tech. Note 4: 1865-B7

**Packaging and Operating Data:**

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<th>Wire Diam. mm</th>
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<td>18-24</td>
<td>Spool</td>
<td>15kg</td>
<td>11945500</td>
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</table>

DC electrode positive.

Typical All Weld Metal Deposit Analysis:

C: 0.95%  Mn: 0.6%  Si: 0.9%  Cr: 6.5%  Mo: 3.5%  B: 1.5%  Fe: Bal

Typical Weld Deposit Hardness:

HRC  HV30

All weld metal deposit 62  750
Work hardened 65  830

Finishing Recommendations:

Grinding only.

Recommended Shielding Gas:

Open arc or welding grade CO2: ISO14175: C1

Self shielded (-O) tubular hardfacing wire.

**Stoody 101HC-G/O**

- High alloy, tubular hardfacing wire.
- High Chromium-Carbide Iron deposit for ground engaging applications.
- Resistant to severe abrasion and low to moderate impact loading.
- Typical applications include the hard surfacing of crusher cones and mantles, swing hammers, earthmoving buckets, scarifier points and sugar harvesting and milling equipment.
- 1.2mm size is suitable for vertical-up surfacing using a wide weaving technique.

**Classifications:**

1.2mm*  1.6mm**

AS/NZS 2756: 2360-B5  2360-B7

WTIA Tech. Note 4: 2360-B5  2360-B7

*1.2mm 101 HC-G is a B5 type wire which requires shielding gas.

**1.6mm 101 HC-G is a B7 type wire which requires no shielding gas.

**Packaging and Operating Data:**

<table>
<thead>
<tr>
<th>Wire Diam. mm</th>
<th>Current Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Type</th>
<th>Pack Type</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2</td>
<td>150-200</td>
<td>22-26</td>
<td>Spool</td>
<td>15kg</td>
<td>11436300</td>
</tr>
<tr>
<td>1.6</td>
<td>200-260</td>
<td>24-28</td>
<td>Spool</td>
<td>15kg</td>
<td>11304700</td>
</tr>
</tbody>
</table>

DC electrode positive.

Typical All Weld Metal Deposit Analysis:

Single layer on Mild Steel

C: 4.0%  Mn: 0.7%  Si: 0.7%  Cr: 14.0%  Fe: Bal

All weld metal deposit 60  700

Deposits contain Chromium Carbides with hardness up to 1,500 HV (80HRc).  

Finishing Recommendations:

Grinding only.

Recommended Shielding Gas:

1.2mm 101 HC-G
Ar + 1.3% O2 or equiv  ISO14175: M13

1.6mm 101 HC-O
Open arc or welding grade CO2: ISO14175: C1

Comparable Thermadyne Product:

Cobalarc CR70 extruded electrode  
(AS/NZS 2576: 2355-A4)

**Stoody 100HC-O**

- Self shielded (-O) tubular hardfacing wire.
- High Chromium Carbide Iron deposit.
- For ground engaging applications.
- Resistant to coarse abrasion and low to moderate impact loading.
- Primary Chromium Carbides in single layer.

**Classifications:**

AS/NZS 2756: 2360-B7

WTIA Tech. Note 4: 2360-B7

**Packaging and Operating Data:**

<table>
<thead>
<tr>
<th>Wire Diam. mm</th>
<th>Current Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Type</th>
<th>Pack Type</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.4</td>
<td>250-350</td>
<td>25-30</td>
<td>Coil</td>
<td>27kg</td>
<td>11313400</td>
</tr>
<tr>
<td>2.8</td>
<td>300-450</td>
<td>27-33</td>
<td>Coil</td>
<td>27kg</td>
<td>11001000</td>
</tr>
<tr>
<td>2.8#</td>
<td>300-450</td>
<td>27-33</td>
<td>Drum</td>
<td>228kg</td>
<td>11235400</td>
</tr>
</tbody>
</table>

DC electrode positive #Indent item

Typical All Weld Metal Deposit Analysis:

Single layer on Mild Steel

C: 4.0%  Mn: 1.0%  Si: 1.0%  Cr: 20%  Mo: 0.7%  Fe: Bal

All weld metal deposit 63  780

Deposits contain Chromium Carbides with hardness up to 1,500 HV (80HRc).  

Finishing Recommendations:

Grinding only.

Recommended Shielding Gas:

Open arc or welding grade CO2: ISO14175: C1

Comparable Thermadyne Product:

Cobalarc CR70 extruded electrode  
(AS/NZS 2576: 2355-A4)
### Stoody Fineclad

- Self shielded (-O) tubular hardfacing wire.
- Chromium Carbides in a hard martensitic matrix.
- Resistant to fine, wet or dry abrasion.
- High deposit hardness – typically 65 HRC.
- For the hardfacing of dredge components, chutes and scraper blades.

#### Typical All Weld Metal Deposit Analysis:

<table>
<thead>
<tr>
<th>Layer Description</th>
<th>C (%)</th>
<th>Mn (%)</th>
<th>Si (%)</th>
<th>Cr (%)</th>
<th>Nb (%)</th>
<th>Fe (%)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single layer on Mild Steel</td>
<td>3.5%</td>
<td>0.3%</td>
<td>0.4%</td>
<td>14%</td>
<td>0.4%</td>
<td>0%</td>
</tr>
<tr>
<td>All weld metal deposit</td>
<td>4.8%</td>
<td>0.5%</td>
<td>0.6%</td>
<td>20%</td>
<td>0.75%</td>
<td>0%</td>
</tr>
</tbody>
</table>

#### Typical Weld Deposit Hardness:

<table>
<thead>
<tr>
<th>Type</th>
<th>HRC</th>
<th>HV30</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single layer on Mild Steel</td>
<td>58</td>
<td>670</td>
</tr>
<tr>
<td>All weld metal deposit</td>
<td>65</td>
<td>830</td>
</tr>
</tbody>
</table>

#### Finishing Recommendations:
Grinding only.

**Recommended Shielding Gas:**
Open arc or welding grade CO2 ISO14175: C1

**Comparable Thermadyne Product:**
Cobalarc Borochrome extruded electrode (AS/NZS 2576: 2560-A4)

### Stoody 143-O

- Self shielded (-O) tubular hardfacing wire.
- Complex Niobium/Chromium Carbide Iron deposit.
- Resistant to severe fine or coarse abrasion and low to moderate impact loading.
- For high temperature applications up to 650°C.
- Can be used in many applications where severe wear is a problem.
- Applications include steel industry (crushers, hoppers, exhaust fan blades), cement/refractory industries (screws, furnace parts, presses), non-ferrous (ladies, scrapers) and mining (wear plate, bucket teeth and slurry pipes).

#### Typical All Weld Metal Deposit Analysis:

<table>
<thead>
<tr>
<th>Layer Description</th>
<th>C (%)</th>
<th>Mn (%)</th>
<th>Si (%)</th>
<th>Cr (%)</th>
<th>Mo (%)</th>
<th>Ti (%)</th>
<th>Fe (%)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single layer on Mild Steel</td>
<td>1.7%</td>
<td>1.8%</td>
<td>0.5%</td>
<td>7.5%</td>
<td>0.6%</td>
<td>5.3%</td>
<td>0%</td>
</tr>
<tr>
<td>All weld metal deposit</td>
<td>5.2%</td>
<td>0.7%</td>
<td>0.4%</td>
<td>22%</td>
<td>7.3%</td>
<td>0%</td>
<td>0%</td>
</tr>
</tbody>
</table>

#### Typical Weld Deposit Hardness:

<table>
<thead>
<tr>
<th>Type</th>
<th>HRC</th>
<th>HV30</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single layer on Mild Steel</td>
<td>58</td>
<td>670</td>
</tr>
<tr>
<td>All weld metal deposit</td>
<td>62</td>
<td>780</td>
</tr>
</tbody>
</table>

#### Finishing Recommendations:
Grinding only.

**Recommended Shielding Gas:**
Open arc or welding grade CO2 ISO14175: C1

**Comparable Thermadyne Product:**
Cobalarc 9e extruded electrode (AS/NZS 2576: 2560-A4)

### Stoody 600

- Self shielded (-O) tubular hardfacing wire.
- Crack free, martensitic alloy steel containing hard Titanium Carbides.
- Excellent resistance to high stress abrasion and heavy impact.
- Applications include hammer mills, crushing rolls and bucket lips.

#### Typical All Weld Metal Deposit Analysis:

<table>
<thead>
<tr>
<th>Layer Description</th>
<th>C (%)</th>
<th>Mn (%)</th>
<th>Si (%)</th>
<th>Cr (%)</th>
<th>Mo (%)</th>
<th>Ti (%)</th>
<th>Fe (%)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single layer on Mild Steel</td>
<td>1.7%</td>
<td>1.8%</td>
<td>0.5%</td>
<td>7.5%</td>
<td>0.6%</td>
<td>5.3%</td>
<td>0%</td>
</tr>
<tr>
<td>Two layers of Mild Steel</td>
<td>60</td>
<td>690</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3-8 layers of Mild Steel</td>
<td>60</td>
<td>690</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

#### Typical Weld Deposit Hardness:

<table>
<thead>
<tr>
<th>Type</th>
<th>HRC</th>
<th>HV30</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single layer on Cast Iron</td>
<td>62</td>
<td>750</td>
</tr>
<tr>
<td>All weld metal deposit</td>
<td>65</td>
<td>830</td>
</tr>
</tbody>
</table>

#### Finishing Recommendations:
Grinding only.

**Recommended Shielding Gas:**
Open arc operation

**Comparable Thermadyne Product:**
Cobalarc 9e extruded electrode (AS/NZS 2576: 2560-A4)
**Stoody 130-O**

- Self shielded (-O) tubular hardfacing wire.
- Tungsten Carbide Iron deposit.
- Resistant to extreme abrasion and low impact loading.
- For earth cutting and boring applications.

**Typical All Weld Metal Deposit Analysis:**
- C: 2.4%
- Mn: 0.5%
- Si: 0.1%
- W: 58.0%
- Fe: Bal

**Typical Weld Deposit Hardness:**
- HRC HV30
- All weld metal deposit 65 825

Deposits contain Tungsten Carbides with hardness up to 2,200 HV.

**Finishing Recommendations:**
- Grinding only.

**Recommended Shielding Gas:**
- Open arc operation

**Comparable Thermadyne Product:**
- Stoody ACDC Tube Borium electrode (AS/NZS 2576: 3460-A1)

**Classifications:**
- AS/NZS 2756: 3460-B7
- WTIA Tech. Note 4: 3460-B7

**Packaging and Operating Data:**

<table>
<thead>
<tr>
<th>Wire Diam. mm</th>
<th>Current Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Stickout mm</th>
<th>Pack Type</th>
<th>Pack Weight</th>
<th>Part No</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.6</td>
<td>90-120</td>
<td>18-24</td>
<td>15-20</td>
<td>Spool</td>
<td>15kg</td>
<td>11413200</td>
</tr>
<tr>
<td>2.8#</td>
<td>120-150</td>
<td>18-24</td>
<td>30-35</td>
<td>Coil</td>
<td>27kg</td>
<td>11001100</td>
</tr>
</tbody>
</table>

DC electrode positive. #Indent item

**Stoody 160/160DM**

- Self shielded (-O) tubular hardfacing wire.
- Tungsten Carbide in Ni-Si-B type deposit.
- Resistant to extreme abrasion and low impact loading.
- For earth cutting, dredging and boring applications.

**Typical All Weld Metal Deposit Analysis:**
- C: 2.8%
- Mn: 0.5%
- Si: 0.4%
- B: 1.4%
- W: 51%
- Ni: Bal

**Typical Weld Deposit Hardness:**
- HRC HV30
- All weld metal deposit 65 825

Deposits contain Tungsten Carbides with hardness up to 2,200 HV.

**Finishing Recommendations:**
- Grinding only.

**Recommended Shielding Gas:**
- Open arc operation

**Comparable Thermadyne Product:**
- Stoody 160E electrode (AS/NZS 2576: 3665-A1)

**Classifications:**
- AS/NZS 2756: 3665-B7
- WTIA Tech. Note 4: 3665-B7

**Packaging and Operating Data:**

<table>
<thead>
<tr>
<th>Wire Diam. mm</th>
<th>Current Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Stickout mm</th>
<th>Pack Type</th>
<th>Pack Weight</th>
<th>Part No</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.6</td>
<td>90-120</td>
<td>18-24</td>
<td>15-20</td>
<td>Spool</td>
<td>11.3kg</td>
<td>11413200</td>
</tr>
<tr>
<td>2.8#</td>
<td>120-150</td>
<td>18-24</td>
<td>30-35</td>
<td>Coil</td>
<td>22kg</td>
<td>11001100</td>
</tr>
</tbody>
</table>

DC electrode positive. #Indent item
Stoody 104

- Submerged arc (-SA) tubular build-up wire.
- Tough, machinable, crack free steel deposit.
- Resistant to high compressive loading.
- Ideal as an underbase prior to hardfacing.
- For the unlimited build-up of worn steel components.

Classifications:
AS/NZS 2756: 1125-B1
WTIA Tech. Note 4: 1125-B1

Packaging and Operating Data:

<table>
<thead>
<tr>
<th>Wire Diam. (mm)</th>
<th>Current Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Stickout mm</th>
<th>Pack Type</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.2</td>
<td>350-400</td>
<td>26-30</td>
<td>25-35</td>
<td>Coll</td>
<td>27kg</td>
</tr>
<tr>
<td>3.2</td>
<td>350-400</td>
<td>26-30</td>
<td>25-35</td>
<td>Half Pack</td>
<td>90kg</td>
</tr>
<tr>
<td>3.2</td>
<td>350-400</td>
<td>26-30</td>
<td>25-35</td>
<td>Drum</td>
<td>228kg</td>
</tr>
</tbody>
</table>

AC, DC electrode positive or negative.

Stoody 107

- Submerged arc tubular build-up wire.
- Tough, machinable, low carbon pearlitic steel deposit.
- Resistant to high compressive loading.
- Ideal as an underbase prior to hardfacing.
- For re-building worn steel components.

Classifications:
AS/NZS 2756: 1440-B1
WTIA Tech. Note 4: 1440-B1

Packaging and Operating Data:

<table>
<thead>
<tr>
<th>Wire Diam. (mm)</th>
<th>Current Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Stickout mm</th>
<th>Pack Type</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.2</td>
<td>350-400</td>
<td>26-30</td>
<td>25-35</td>
<td>Half Pack</td>
<td>90kg</td>
</tr>
<tr>
<td>3.2</td>
<td>350-400</td>
<td>26-30</td>
<td>25-35</td>
<td>Drum</td>
<td>228kg</td>
</tr>
</tbody>
</table>

AC, DC electrode positive or negative. #Indent item.

Stoody 105

- 3.2mm submerged arc tubular build-up wire.
- Tough, machinable, crack-free steel deposit.
- Resistant to high compressive loading.
- Ideal as an underbase prior to hardfacing.
- For re-building worn steel components.

Classifications:
AS/NZS 2756: 1445-B1
WTIA Tech. Note 4: 1445-B1

Packaging and Operating Data:

<table>
<thead>
<tr>
<th>Wire Diam. (mm)</th>
<th>Current Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Stickout mm</th>
<th>Pack Type</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.2</td>
<td>350-400</td>
<td>28-30</td>
<td>25-35</td>
<td>Half Pack</td>
<td>90kg</td>
</tr>
<tr>
<td>3.2</td>
<td>350-400</td>
<td>28-30</td>
<td>25-35</td>
<td>Drum</td>
<td>228kg</td>
</tr>
</tbody>
</table>

AC, DC electrode positive or negative. #Indent items.

Typical All Weld Metal Deposit Analysis:
- C: 0.07% Mn: 2.90% Si: 1.25%
- Cr: 1.15% Mo: 0.3% Fe: Bal

Deposit Characteristics:
- Abrasion resistance: Good
- Impact resistance: Good
- Compressive strength: Good
- Hardness: 30 HRc
- Surface cross checks: Yes
- Magnetic: Yes
- Deposit layers: Unlimited
- Machinability: Yes

Comparable Thermadyne Products:
- Cobalarc 350 extruded electrode (AS/NZS 2576: 1435-A4)
- Stoody Super Build Up-G/O (AS/NZS 2576: 1435-B5/B7)
**Thermaclad 102**

- Submerged arc tubular build-up wire.
- Tough, machinable crack free steel deposit.
- Resistant to high compressive loading.
- Tool steel type deposit for the rebuilding of work rolls, edge rolls, crane wheels and dragline pins.

**Classifications:**
- AS/NZS 2756: 1550-B1
- WTIA Tech. Note 4: 1550-B1

**Typical All Weld Metal Deposit Analysis:**
- C: 0.3%
- Mn: 1.6%
- Si: 0.8%
- Cr: 6.0%
- Mo: 1.6%
- W: 1.4%
- Fe: Bal

**Typical Weld Deposit Hardness:**
- 3 layers maximum on Mild Steel
  - HRC 52
  - HV30 550

**Finishing Recommendations:**
- Machinable with difficulty

**Recommended Flux:**
- Stoody R20

**Deposit Characteristics:**
- Abrasion resistance: Good
- Impact resistance: Good
- Compressive strength: High
- Hardness: 52 HRC
- Surface cross checks: No
- Magnetic: Yes
- Deposit layers: Three
- Machinability: With difficulty

**Comparable Thermadyne Products:**
- Cobalarc 650 extruded electrode (AS/NZS 2576: 1855-A4)
- Stoody 965-G/O (AS/NZS 2576: 1855-B5/B7)
- Stoody Cobremax-O (AS/NZS 2576: 1550-B7)

**Packaging and Operating Data:**

<table>
<thead>
<tr>
<th>Wire Diam. mm</th>
<th>Current Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Stickout mm</th>
<th>Pack Type</th>
<th>Pack Weight kg</th>
<th>Part No</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.2</td>
<td>350-500</td>
<td>26-30</td>
<td>30-40</td>
<td>Drum</td>
<td>228</td>
<td>11820400</td>
</tr>
</tbody>
</table>

DC electrode positive

**Stoody Fluxes**

**Stoody ‘S’ Flux**

**Description & Applications:**
- Stoody ‘S’ Flux is an active fused flux designed for use with Stoody Submerged Arc Welding Wires (other than Thermaclad® wire). As the deposit composition is significantly altered from the wire composition, care should be exercised in the matching of this flux to the right wire.

**Packaging Data:**
- Stoody ‘S’ Flux is available in 22kg bags. Part No. 11008400

**Stoody R20 Flux**

**Description & Applications:**
- Stoody R20 Flux is a neutral flux that is specially designed for use with Stoody Thermaclad® wires. Applications include use with Thermaclad 104, 107 or 42 for undercarriage re-building and other Thermaclad wires for steel mill roll rebuilding. The flux is formulated to achieve excellent deposit composition control and slag removal.

**Packaging Data:**
- Stoody R20 Flux is available in 25kg bags. Part No. 11810900
**Stoody SOS 308L**

- Stainless steel flux cored wire.
- Convenient self shielded (open arc) operation for ‘in situ’ or outdoor applications.
- High deposition rate downhand welding.
- For downhand welding application on 19Cr/10Ni type stainless steels including type 301, 302, 304 and 304L.

**Classifications:**
- AWS/ASME-SFA A5.22: E308LT0-3
- WTIA Tech. Note 4/AS 2576: 1315-B9

**Typical All Weld Metal Analysis:**
- C: 0.02%
- Mn: 1.20%
- Si: 0.50%
- Cr: 24.4%
- Ni: 12.6%
- Fe: Bal

**Typical All Weld Metal Mechanical Properties:**
- Tensile Strength: 600 MPa
- Elongation: 610 MPa
- Ferrite Number: 10-18 FN

**Recommended Shielding Gas:**
- Not required.

**Comparable Thermadyne Products:**
- Verti-Cor 308LT all positional gas shielded FCAW wire (AWS A5.22: E308LT1-1/E308LT1-4)
- Autocraft 308LSi GMAW wire (AWS A5.9: ER308LSi)
- Comweld 308L Gas/TIG rod (AWS A5.9: ER308L)
- Satincombe 308L-17 electrode (AWS A5.4: ER308L-17)

**Packaging and Operating Data:**

<table>
<thead>
<tr>
<th>Wire Diam. mm</th>
<th>Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Stickout mm</th>
<th>Pack</th>
<th>Pack Type</th>
<th>Weight (kg)</th>
<th>Part No</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.4</td>
<td>300-350</td>
<td>28-30</td>
<td>20-25</td>
<td>Coil</td>
<td>22kg</td>
<td>11175400</td>
<td></td>
</tr>
</tbody>
</table>

**Stoody SOS 309L**

- Stainless steel flux cored wire.
- Convenient self shielded (open arc) operation for ‘in situ’ or outdoor applications.
- For joining dissimilar steels or as a buffer layer prior to hard surfacing.
- High deposition rate downhand welding.

**Classifications:**
- AWS/ASME-SFA A5.22: E309LT0-3
- WTIA Tech. Note 4/AS 2576: 1315-B9

**Typical All Weld Metal Analysis:**
- C: 0.02%
- Mn: 1.20%
- Si: 0.50%
- Cr: 22.80%
- Ni: 10.2%
- Fe: Bal

**Recommended Shielding Gas:**
- Not required.

**Comparable Thermadyne Products:**
- Verti-Cor 309LT all positional gas shielded FCAW wire (AWS A5.22: E308LT1-1/E308LT1-4)
- Autocraft 309LSi GMAW wire (AWS A5.9: ER309LSi)
- Comweld 309L Gas/TIG rod (AWS A5.9: ER309L)
- Satincombe 309Mo-17 electrode (AWS A5.4: ER309Mo17)

**Packaging and Operating Data:**

<table>
<thead>
<tr>
<th>Wire Diam. mm</th>
<th>Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Electrode Stickout mm</th>
<th>Pack</th>
<th>Pack Type</th>
<th>Weight (kg)</th>
<th>Part No</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.4</td>
<td>300-350</td>
<td>28-30</td>
<td>20-25</td>
<td>Coil</td>
<td>22kg</td>
<td>11231200</td>
<td></td>
</tr>
</tbody>
</table>

**Stoody 2209-T1**

- For welding of 22%Cr/5%Ni/3%Mo duplex type stainless steels.
- Extra low carbon (<0.03%) corrosion resistant weld deposits.
- Precision layer wound for improved feedability and performance.
- For the joining of 2205 and other 22% Cr type duplex stainless steels.

**Classifications:**
- AWS/ASME-SFA A5.22: E2209-T1-1/4

**Typical Wire Analysis:**
- C: 0.03%
- Mn: 0.9%
- Si: 0.7%
- Cr: 22.80%
- Ni: 8.63%
- Mo: 3.10%
- P: 0.018%
- S: 0.007%
- Cu: 0.06%
- Fe: Bal

**Recommended Shielding Gas:**
- Ar + 20-25% CO2
- Welding Grade CO2

**Comparable Thermadyne Products:**
- Comweld 2209 TIG rod (AWS A5.9: ER2209)
- Autocraft 2209 GMAW wire (AWS A5.9: ER2209)

**Typical All Weld Metal Mechanical Properties:**

<table>
<thead>
<tr>
<th>Welding Grade CO2:</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.2% Proof Stress: 660 MPa</td>
</tr>
<tr>
<td>Tensile Strength: 820 MPa</td>
</tr>
<tr>
<td>Elongation: 28%</td>
</tr>
<tr>
<td>CVN Impact Value: @ -40°C</td>
</tr>
<tr>
<td>60J av @ -40°C</td>
</tr>
<tr>
<td>80J av @ -20°C</td>
</tr>
<tr>
<td>100J av @ +20°C</td>
</tr>
</tbody>
</table>

**Packaging and Operating Data:**

<table>
<thead>
<tr>
<th>Wire Diam. mm</th>
<th>Range (amps)</th>
<th>Voltage Range (volts)</th>
<th>Wire Feed Speed m/min</th>
<th>Pack</th>
<th>Pack Type</th>
<th>Weight (kg)</th>
<th>Part No</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2</td>
<td>150-210</td>
<td>24-27</td>
<td>7-11</td>
<td>Spool</td>
<td>15kg</td>
<td>11205600</td>
<td></td>
</tr>
<tr>
<td>1.6</td>
<td>190-270</td>
<td>24-28</td>
<td>5-8</td>
<td>Spool</td>
<td>15kg</td>
<td>11802000</td>
<td></td>
</tr>
</tbody>
</table>

**DC electrode positive.**
Stoody 2594-T1

- For welding of 25%Cr/9%Ni/4%Mo super duplex stainless steels.
- Extra low carbon (<0.03%) corrosion resistant weld deposits.
- Precision layer wound for improved feedability and performance.
- Applications include the joining of 2507 and other super duplex type stainless steels or to weld low alloy steels to duplex stainless steels.

**Classification:**
AWS/ASME-SFA A5.22: E2594 T1-1/4

**Typical Wire Analysis:**
- C: 0.012%
- Mn: 1.60%
- Si: 0.44%
- Cr: 22.80%
- Ni: 8.63%
- Mo: 3.10%
- N: 0.14%
- P: 0.018%
- S: 0.007%
- Cu: 0.06%
- Fe: Balance

**Ferrite Number:**
40-50 FN (procedure dependent)

**Typical All Weld Metal Mechanical Properties:**
- Welding Grade CO2:
  - 0.2% Proof Stress: 670 MPa
  - Tensile Strength: 850 MPa
  - Elongation: 26%
  - CVN Impact Value: 60J av @ -40°C

**Recommended Shielding Gas:**
Ar + 20-25% CO₂

Stoody 625 & 625LI

- Clads sides of joints in steels clad with Nickel-Chromium-Molybdenum weld metal.
- Surfacing steel with Nickel-Chromium-Molybdenum weld metal.
- Joining steels to Nickel based alloys.
- Joining 9% Nickel Steel for cryogenic applications.

**Classification:**
A5.34-2007 ENiCrMo3T1-1/4

**Typical Wire Analysis (625):**
- C: 0.03%
- Mn: 0.4%
- Si: 0.3%
- Cr: 22.0%
- Mo: 9.2%
- Ni: 3.8%
- Fe: 0.3%
- Nb: 3.0%
- S: 0.002%
- P: 0.010%
- Ni: Balance

*For 625LI the typical Fe content is 0.3%

**Recommended Shielding Gas:**
75% Ar + 25% CO₂

**Typical All Weld Metal Mechanical Properties:**
- Tensile Strength: 820 MPa
- Yield Strength: 510 MPa
- Elongation: 34%
- CVN Impact Value: 67J av @ -196°C
- Lateral Expansion: 0.89mm
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- Blowpipes, Cutters and Consumables
- Comet Gas Equipment Accessories

Welding Consumables
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- Electrodes, Rods & Fluxes
- Hardfacing Electrodes and Wires

Safety, MIG Gun & Accessories
- Plasma Cutting Equipment
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- Welding Torches, Consumables and Accessories

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