

STOODY® 105B Submerged Arc Welding Wire

Stoody 105B deposit has very good resistance to metal-to-metal wear. The deposits are readily machinable with carbide tools. Multiple layer, crack-free deposits can be obtained. When more than 4 layers are required, and underlay of Stoody 104 is recommended. Deposits are difficult to flame cut.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Very Good
Impact Resistance	Good
Compressive Strength	Good
Hardness, HRC	43
Surface Cross Checks	No
Magnetic	Yes
Deposit Layers	4
Machinability	Yes

ALLOY TYPE

Low Alloy Steel

TYPICAL APPLICATIONS

- Rollers
- Mine car wheels
- Charging car wheels
- Idlers
- Arch wheels
- Tractor rails

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

1/8" (3.2 mm)	
Current DCEP, amp	350 – 400
Voltage (volts)	28 – 30
Position	Flat
Wire Extension, in (mm)	1" – 1 1/2" (25 – 38)
Flux Type	Stoody "S"

5/32" (4.0 mm)	
Current DCEP, amp	425 – 475
Voltage (volts)	28 – 30
Position	Flat
Wire Extension, in (mm)	1" – 1 1/2" (25 – 38)
Flux Type	Stoody "S"

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2 mm)	60 lb (27.2 kg) Coil	11987400
1/8" (3.2 mm)	200 lb (90.7 kg) Half Pak	11041600
1/8" (3.2 mm)	500 lb (226.7 kg) POP	11040100
1/8" (3.2 mm)	750 lb (340 kg) POP	11902600
5/32" (4.0 mm)	500 lb (226.7 kg) POP	11112500
5/32" (4.0 mm)	750 lb (340 kg) POP	12014900

PDS-SAW-007
Revision 4
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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.