

## STOODY® 100HC

### Open Arc Welding Wire

Stoody 100HC deposit is a high chromium-iron alloy recommended for application subject to severe abrasion and moderate impact and heat. It develops a tight (3/8" - 1/2") cross checking pattern and is frequently used in crushing applications. It is generally limited to two layers. In the rebuilding of coal pulverizer rolls, however, multiple layers can be applied using specific welding procedures. It can be applied to carbon, low alloy, and manganese steels. Deposits are not machinable or forgeable and can be used in hot wear applications up to 900°F (482°C).

#### TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Deposit Layers	2
Hardness	
On Carbon Steel, HRC	58 – 62
On Manganese Steel, HRC	51 – 55
Surface Cross Checks	Yes
Machinability	No
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Hot Wear Application	Up to 900°F (482°C)

#### ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

#### TYPICAL APPLICATIONS

- Gyratory mantles
- Scrubbers
- Large bucket lips and teeth
- Impactor bars
- Cage pins
- Crusher rolls
- Wear plates

#### OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

<b>3/32" (2.4 mm)</b>	
Current DCEP, amp	200 – 350
Voltage (volts)	25 – 28
Wire Extension, in (mm)	1 1/4 – 1 1/2 (32 – 38)
Shielding Gas	None
Position	Flat

<b>7/64" (2.8 mm)</b>	
Current DCEP, amp	200 – 400
Voltage (volts)	25 – 31
Wire Extension, in (mm)	1 1/4 – 1 1/2 (32 – 38)
Shielding Gas	None
Position	Flat

<b>1/8" (3.2 mm)</b>	
Current DCEP, amp	400 – 550
Voltage (volts)	31 – 34
Wire Extension, in (mm)	1 1/4 – 1 1/2 (32 – 38)
Shielding Gas	None
Position	Flat

#### STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
3/32" (2.4 mm)	25 lb (11.3 kg) Plastic Spool	11249700
3/32" (2.4 mm)	60 lb (27.2 kg) Coil	11313400
3/32" (2.4 mm)	200 lb (90.7 kg) Half Pak	12022200
7/64" (2.8 mm)	60 lb (27.2 kg) Coil	11001000
7/64" (2.8 mm)	110 lb (50 kg) Quarter Pak	11144100
7/64" (2.8 mm)	200 lb (90.7 kg) Half Pak	11141700
7/64" (2.8 mm)	500 lb (226.8 kg) POP	11235400
7/64" (2.8 mm)	750 lb (340 kg) POP	11976900
1/8" (3.2 mm)	110 lb (50 kg) Quarter Pak	11867100
1/8" (3.2 mm)	500 lb (226.8 kg) POP	11807700

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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.

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