

## STOODY® 101HC, 101HC-G, 101HC-O

### Open Arc/Gas Shielded Welding Wire

Stoody 101HC is a high chromium-carbon, iron based alloy tubular wire recommended for metal-to-earth applications subject to severe abrasion. It develops a tight cross-checking pattern (3/8" - 1/2") and is frequently used in crushing and construction applications. It can be applied to carbon, low alloy, or manganese steels and can be used in hot wear applications up to 900°F (482°C). Deposits cannot be machined or forged.

#### TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Strength	Low
Hardness, HRC	56 - 64
Machinability	No
Deposit Layers	2
Surface Cross Checks	Yes
Hot Wear Applications	Up to 900°F (482°C)

#### ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

#### TYPICAL APPLICATIONS

- Scraper sides, cutters, and blades
- Shovel bucket tooth adapters
- Tillage tools, and auger flights
- Crushing and grinding equipment
- Ripper shanks and teeth
- Bucket sides and lips
- Conveyor screws

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

	101HC-G	101HC-G
Diameter, in (mm)	<b>0.035" (0.9 mm)</b>	<b>0.045" (1.2 mm)</b>
Current DCEP, amp	80 – 185	150 – 200
Voltage (volts)	15 – 24	22 – 26
Wire Extension, in (mm)	1/2 – 5/8 (13 – 16)	1/2 – 3/4 (13 – 19)
Shielding Gas	75/25, CO <sub>2</sub> , or 98/2	75/25, CO <sub>2</sub> , or 98/2
Position	Flat or Horizontal	Flat or Horizontal

	101HC-O	101HC-O
Diameter, in (mm)	<b>1/16" (1.6 mm)</b>	<b>5/64" (2.0 mm)</b>
Current DCEP, amp	200 – 260	225 – 375
Voltage (volts)	24 – 28	24 – 28
Wire Extension, in (mm)	1/2 – 1 (13 – 25)	3/4 – 1 1/4 (13 – 32)
Shielding Gas	None	None
Position	Flat or Horizontal	Flat

	101HC
Diameter, in (mm)	<b>7/64" (2.8 mm)</b>
Current DCEP, amp	350 – 450
Voltage (volts)	27 – 29
Wire Extension, in (mm)	1 1/4 – 1 1/2 (32 – 38)
Shielding Gas	None
Position	Flat

#### STANDARD SIZES & PACKAGING

101HC-G		
Diameter	Packaging	Part #
0.035" (0.9 mm)	5 lb (2.3 kg) Plastic Spool	11929200
0.035" (0.9 mm)	25 lb (11.3 kg) Plastic Spool	11933400
0.045" (1.2 mm)	10 lb (4.5 kg) Plastic Spool	11440300
0.045" (1.2 mm)	33 lb (15 kg) Coil	11436300
0.045" (1.2 mm)	50 lb (22.7 kg) Poly Pak	11874600
0.045" (1.2 mm)	200 lb (90.7) No Twist Drum	12038300
0.045" (1.2 mm)	300 lb (136 kg) No Twist Drum	11891500

101HC-O, 101HC		
Diameter	Packaging	Part #
1/16" (1.6 mm)	10 lb (4.5 kg) Plastic Spool	11421000
1/16" (1.6 mm)	33 lb (15 kg) Coil	11304700
1/16" (1.6 mm)	50 lb (22.7 kg) Poly Pak	11304800
1/16" (1.6 mm)	200 lb (90.7 kg) Half Pak	11948100
1/16" (1.6 mm)	200 lb (90.7) No Twist Drum	12025400
1/16" (1.6 mm)	400 lb (181.4 kg) No Twist Drum	11898700
1/16" (1.6 mm)	500 lb (226.8 kg) POP	11956200
5/64" (2.0 mm)	33 lb (15 kg) Coil	11865500
5/64" (2.0 mm)	50 lb (22.7 kg) Poly Pak	11325200
5/64" (2.0 mm)	110 lb (50 kg) Quarter Pak	11849200
5/64" (2.0 mm)	200 lb (90.7 kg) Half Pak	11866900
5/64" (2.0 mm)	500 lb (226.8 kg) POP	11901700
7/64" (2.8 mm)	60 lb (27.2 kg) Coil	11862500
7/64" (2.8 mm)	200 lb (90.7 kg) Half Pak	11861300
7/64" (2.8 mm)	500 lb (226.8 kg) POP	11873200

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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](http://Stoody.com).