

STOODY® 102-O

Open Arc Welding Wire

Stoody 102-O deposit has a composition and physical properties that are similar to those of H-12 tool steel. Weldability is very good and the wire can be applied out-of-position. Stoody 102-O requires carbide tools for machining. It is good for hot wear applications up to 1100°F. Multiple layers can be applied without difficulty when proper preheat and interpass temperatures are maintained.

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

1/16" (1.6 mm)	
Current DCEP, amp	225 – 275
Voltage (volts)	25 – 27
Position	Flat and Horizontal
Shielding Gas	None
Wire Extension, in (mm)	1/2" - 1 (12 - 25)

TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Good
Impact Resistance	Moderate
Compressive Strength	Good
Hardness on 0.2% Carbon Steel	HRC 48 - 53
Deposit Layers	Multiple
Magnetic	Yes
Surface Cross Checks	No
Machinability	Using Carbide Tools
Hot Wear Applications	Up to 1100°F

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/16" (1.6 mm)	33 lb (15 kg) Wire Basket	11426700
1/16" (1.6 mm)	50 lb (22.67 kg) Poly Pak	11426800

ALLOY TYPE

H-12 Tool Steel

TYPICAL APPLICATIONS

- Cable sheaves
- Forging dies
- Crane wheels
- Hot and cold shear blades
- Drillpipe hardbanding
- Hot work extrusion rolls

PDS-CS-W-005
Revision 5
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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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