

STOODY® BUILD UP, -G, -O

Gas Shielded / Open Arc Wire

Stoody Build Up deposit is a low alloy steel that has excellent compressive strength and resistance to plastic deformation. This is an ideal alloy for use as an underlay for subsequent hardfacing. Several diameters are available for use both with and without gas shielding. Build Up has good machinability in the as-welded condition using carbide tools, and it can be forged at red heat. It is recommended for use on carbon and low alloy steels, but not on manganese steels or cast iron. It does not work harden and should not be used for joining.

TYPICAL MECHANICAL PROPERTIES

Compressive Strength	Excellent
Resistance to Plastic Deformation	Excellent
Abrasion Resistance	Low
Impact Resistance	Moderate
Hardness	HRC 29
Magnetic	Yes
Deposit Layers	Multiple
Surface Cross Check	No
Machinability	Good

ALLOY TYPE

Low Alloy Steel

TYPICAL APPLICATIONS

- Hammers
- Pump parts
- Rolls
- Steel mill wobblers and slip joints
- Carbon steel shovel pads
- Shafting
- Wheels burns
- Repairing battered rail

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

0.045" (1.2 mm)	
Current, amp	175 – 225
Voltage, volts	18 – 24
Shielding Gas	98% Ar, 2% O ₂
Wire Extension, in (mm)	1/2 - 3/4 (12 - 19)
Position	Flat and Horizontal

1/16" (1.6 mm)	
Current, amp	200 – 300
Voltage, volts	24 – 26
Shielding Gas	None or CO ₂
Wire Extension, in (mm)	1/2 - 1 (12 - 25)
Position	Flat

5/64" (2.0 mm)	
Current, amp	250 – 350
Voltage, volts	24 – 26
Shielding Gas	None
Wire Extension, in	1 - 1 1/4 (25 - 31)
Position	Flat

3/32" (2.4 mm)	
Current, amp	300 – 400
Voltage, volts	26 – 28
Shielding Gas	None
Wire Extension, in	3/4 - 1 1/4 (19 - 31)
Position	Flat

7/64" (2.8 mm)	
Current, amp	350 – 450
Voltage, volts	26 – 28
Shielding Gas	None
Wire Extension, in	3/4 - 1 1/4 (19 - 31)
Position	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
0.045" (1.2 mm)	10 lb (4.53 kg) Plastic Spool	11423900
0.045" (1.2 mm)	25 lb (11.33 kg) Plastic Spool	11988200
0.045" (1.2 mm)	33 lb (15 kg) Wire Basket	11423800
1/16" (1.6 mm)	10 lb (4.53 kg) Plastic Spool	11420000
1/16" (1.6 mm)	33 lb (15 kg) Wire Basket	11304900
1/16" (1.6 mm)	50 lb (22.67 kg) Poly Pak	11258300
5/64" (2.0 mm)	33 lb (15 kg) Wire Basket	11893800
3/32" (2.4 mm)	60 lb (27.21 kg) Coil	11183600
7/64" (2.8 mm)	60 lb (27.21 kg) Coil	11000100
7/64" (2.8 mm)	110 lb (49.89 kg) Quarter Pak	11142800
7/64" (2.8 mm)	200 lb (90.71 kg) Half Pak	11813100
7/64" (2.8 mm)	500 lb 226.79 kg) POP	11869900

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