

50870

STOODY
A THERMADYNE Company

Stoody® Build Up, -G, -O
Gas Shielded / Open Arc Wire

DESCRIPTION

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 underbase 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 DEPOSIT CHARACTERISTICS

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

ALLOY TYPE

Low Alloy Steel

TYPICAL APPLICATIONS

Typical applications include:

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

Stoody Company

5557 Nashville Road • Bowling Green, KY 42101
1-800-227-9333

PDS-CS-W-001

Revision 2
07/23/02

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, in. (mm)	.045 (1.2)	1/16 (1.6)
Current, Amp.	175 – 225	200 – 300
DCEP		
Voltage	18 – 24	24 – 26
Position	Flat & Horizontal	Flat
Shielding Gas	98% Ar, 2% O ₂	None or CO ₂
Wire Extension	½" – ¾"	½" – 1"
Diameter, in. (mm)	3/32 (2.4)	7/64 (2.8)
Current, Amp.	300 – 400	350 – 450
DCEP		
Voltage	26 – 28	26 – 28
Position	Flat	Flat
Shielding Gas	None	None
Wire Extension	¾" – 1 ¼"	¾" – 1 ¼"

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
7/64" (2.8mm)	60# Coil	11000100
7/64" (2.8mm)	110# Quarter Pak	11142800
7/64" (2.8mm)	200# Half Pak	11813100
7/64" (2.8mm)	500# POP	11869900
3/32" (2.4mm)	60# Coil	11183600
1/16" (1.6mm)	10# Plastic Spool	11420000
1/16" (1.6mm)	33# Wire Basket	11304900
1/16" (1.6mm)	50# Poly Pak	11258300
.045" (1.2mm)	10# Plastic Spool	11423900
.045" (1.2mm)	33# Wire Basket	11423800

Notice: The information contained or otherwise referenced herein is presented only as 'typical', without guarantee or warranty. Stoody expressly disclaims any liability from any reliance thereon. Typical data are those obtained when welded and tested in accordance with Stoody's internal procedures. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Stoody.

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Diameter, in. (mm)	3/32 (2.4)	7/64 (2.8)
Current, Amp.	300 – 400	350 – 450
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Shielding Gas	None	None
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