

DESCRIPTION

Stoody 101HC deposit is a high chromium-carbon, iron based, 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. 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

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

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

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

	101HC-G	101HC-O	
Diameter, In. (mm)	0.035 (0.9)	0.045 (1.2)	
Current, Amp. DCRP	80 – 140	150 – 200	
Voltage	15 – 20	22 – 26	
Wire Extension	1/2" – 5/8"	1/2" – 3/4"	
Shielding Gas	75/25, CO ₂ , or 98/2	98 % Ar/ 2% O ₂	
Position	Flat or Horizontal	Flat or Horizontal	
	101HC-O	101HC-O	101HC
Diameter, In. (mm)	1/16 (1.6)	5/64 (2.0)	7/64 (2.8)
Current, Amp. DCRP	200 – 260	225 – 375	350 – 450
Voltage	24 – 28	24 – 28	27 – 29
Wire Extension	1/2" – 1"	3/4" – 1 1/4"	1 1/4" – 1 1/2"
Shielding Gas	None	None	None
Position	Flat or Horizontal	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.035" (0.9mm)	5# Plastic Spool - LLW	11929200
.045" (1.2mm)	10# Plastic Spool	11440300
.045" (1.2mm)	33# Wire Basket	11436300
.045" (1.2mm)	50# Poly Pak	11874600
.045" (1.2mm)	300# NTP Drum	11891500
1/16" (1.6mm)	10# Plastic Spool	11421000
1/16" (1.6mm)	33# Wire Basket	11304700
1/16" (1.6mm)	50# Poly Pak	11304800
5/64" (2.0mm)	33# Wire Basket	11865500
5/64" (2.0mm)	50# Poly Pak	11325200
5/64" (2.0mm)	110# Quarter Pak	11849200
7/64" (2.8mm)	60# Coil	11862500
7/64" (2.8mm)	200# Half Pak	11861300
7/64" (2.8mm)	500# POP	11873200

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