

DESCRIPTION

Stoody 2134 exhibits excellent abrasion resistance in fine, sandy soils, and bonds well with carbon, low alloy, and manganese steels. It is tubular electrode containing granular alloying elements. The coating is graphitic. Deposits are not machinable or forgeable. Stoody 2134 can be used in hot wear applications up to 950°F.

TYPICAL APPLICATIONS

Typical applications include:

- Crusher Rolls
- Bucket Teeth
- Mill Hammers
- Impactor Bars (final pass)

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Hardness	
- On Carbon Steel (as welded 2 layers weave bead on 1045 plate)	HRC 56 – 60
- On Carbon Steel (quenched from 1750°F)	HRC 63 – 65
- On Manganese Steel	HRC 45 – 50
Magnetic	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	2
Hot Wear Applications	Up to 950°F

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	100 – 150	110 – 170
Position	Flat	Flat
Diameter, In. (mm)	3/16 (4.8)	¼ (6.4)
Current, Amp. DCRP	150 – 210	180 – 300
Position	Flat	Flat

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
1/8" (3.2mm)	10# Box	11276700
5/32" (4.0mm)	10# Box	11276800
5/32" (4.0mm)	60# Bulk Pak	10208300
3/16" (4.8mm)	10# Box	11276700
3/16" (4.8mm)	60# Bulk Pak	10208400
¼" (6.4mm)	60# Bulk Pak	10208500

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix