

DESCRIPTION

Stoody 965 deposit is a general purpose hardfacing alloy that offers a good balance of impact and abrasion resistance. It can be used in both metal-to-metal and metal-to-earth applications. Deposits are martensitic and forgeable but not readily machinable. It can be applied to carbon, low alloy, and manganese steels. It is magnetic on carbon and low alloy steels. Analysis and properties are similar to Stoody Self Hardening covered electrode.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Good
Hardness on .2 Carbon Steel	HRC 56 – 60
Deposit Layers	2
Magnetic	
On Low Alloy and Carbon Steel	Yes
On Manganese Steel	No
Surface Cross Checks	No

ALLOY TYPE

Martensitic Tool Steel

TYPICAL APPLICATIONS

- Tillage Tools
- Drag Line Bucket Lips
- Tamper Feet
- Dredge Parts
- Extruder Screws
- Muller Tires

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

	965-G	
Diameter, In. (mm)	.035 (0.9)	.045 (1.2)
Current, Amp. DCRP	80 – 130	150 – 200
Voltage	15 – 20	25 – 29
Wire Extension	1/2" – 5/8"	1/2" – 3/4"
Shielding Gas	75/25, CO ₂ , or 98/2	98/2 or 75/25
Position	All	Flat or Horizontal

	965-G	965-O
Diameter, In. (mm)	1/16 (1.6)	1/16 (1.6)
Current, Amp. DCRP	200 – 250	200 – 250
Voltage	27 – 31	27 – 31
Wire Extension	3/4" – 1"	3/4" – 1 1/4"
Shielding Gas	98/2 or 75/25	None or CO ₂
Position	Flat or Horizontal	Flat or Horizontal

STANDARD SIZES & PACKAGING

965-G		
Diameter	Packaging	Part #
.035" (0.9mm)	5# PS-LLW	11929300
.045" (1.2mm)	10# PS	11142300
.045" (1.2mm)	33# WB	11423100
1/16" (1.6mm)	33# WB	11501500
1/16" (1.6mm)	50# PP	11823900
1/16" (1.6mm)	200# HP	11864500
1/16" (1.6mm)	400# NTP Drum	11875500

965-O		
Diameter	Packaging	Part #
1/16" (1.6mm)	10# PS	11427200
1/16" (1.6mm)	33# WB	11427100
1/16" (1.6mm)	50# PP	11427000

Stoody Company

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