Signature Products Selection Guide

Wear Mode	Product	Base Metal	General Use	PROCESS GTAW	SMAW	FCAW	GMAW
Build-up & Joining Alloys	Stoody Build-up	Carbon steel	Build-up			●	●
	Stoody Build-up LH	Carbon steel	Build-up		●		
	Nicromang™	Manganese steel	Build-up & Joining		●	●	●
	Versalloy™ Plus	Carbon & Manganese steel	Build-up, repair & joining (Joining Carbon Steel to Stainless steel)		●		
	Stoody 110	Carbon & Manganese steel	Build-up & repair			●	●
	Stoody 2110	Carbon & Manganese steel	Build-up & repair		●		
	Castweld 55	Cast iron	Joining, Build-up & repair		●	●	
	Castweld 99	Cast iron	Joining, Build-up & repair		●		
Metal to Metal Alloy	Stoody 1105	Carbon & Low alloy steel	Metal to Metal wear		●		
	Super Build-up	Carbon & Low alloy steel	Metal to Metal wear			●	●
Metal to Earth Alloy "Moderate Abrasion"	Stoody 19	Carbon & Low alloy, and Manganese steel	Severe abrasion, low impact		●		
	Stoody 965	Carbon & Low alloy, and Manganese steel	Moderate abrasion, high impact			●	●
	Stoody 31	Carbon & Manganese steel	Moderate abrasion, moderate impact		●		
	Stoody 101HC	Carbon & Low alloy and Manganese steel	Severe abrasion, low impact			●	
	Stoody 121	Carbon & Low alloy and Manganese steel	Moderate to severe abrasion, & moderate impact			●	●
Metal to Earth Alloy "Extreme Abrasion"	Stoody 130	Carbon & Low alloy steel	Extreme Abrasion & low impact			●	
	Vancar™	Carbon & Low alloy steel	Extreme Abrasion & low impact		●	●	●
	Acetylene Tube Borium (ATB Bare)	Carbon & Low alloy steel	Extreme Abrasion & low impact	Oxy-Acetylene			
Temperature Abrasion Corrosion	Stoodite 6	Carbon & Low alloy and Stainless Steel	High temperature abrasion & corrosion resistance	●	●		●
	Stoodite 21	Carbon & Low alloy and Stainless Steel	High temperature abrasion & corrosion resistance	●	●		●

See our full line signature products catalog (Form No. 2102A) or visit us on the web at www.stoody.com for more information.
(part numbers, data sheets, etc.)

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AVAILABLE SIZES		APPLICATIONS
Wire	Electrodes	(Partial Listing)
.045", 1/16", 3/32", 7/64"		Hammers, Carbon Steel Shovel Pads, Shaft, Rolls, Pump Parts
	1/8", 5/32", 3/16", 1/4"	Tractor Rollers, Steel Shovel Pads, Tractor Idlers, Sprockets, Shafts
.045", 1/16", 3/32"	1/8", 5/32", 3/16", 1/4"	Dredge Pumps Parts, Crusher Jaws, Impact Breaker Bars, Hammers
	3/32", 1/8", 5/32"	General purpose Stainless, good for joining Stainless to dissimilar metals
.045", 1/16", 3/32", 7/64"		Shovel Teeth, Turbine Cone, Shovel Pads, Crusher Rolls, Drive Tumblers
	1/8", 5/32", 3/16", 1/4"	Steel Frogs, Switch Points, Hammers, Shovel Teeth, Roll Crushers
1/16", 3/32"	3/32", 1/8", 5/32"	Joining build-up, and repair of cast iron parts Pump Impellers, Pump Castings, Housings, Engine blocks and Heads
	3/32", 1/8", 5/32"	Similar applications as Castweld 55 with focus on hairline cracks
	1/8", 5/32", 3/16", 1/4"	Tractor Rollers & Idlers, Idler Sprockets, Drive Tumblers, Churn Drills
.045", 1/16", 7/64"		Gear Teeth, Sprockets, Steel Shovel Pads, Carbon Steel Shafts
	1/8", 5/32", 3/16", 1/4"	Crusher Rolls, Dredge Parts, Pump Shells, Impellers, Impact Breaker Scrappers
.045", 1/16"		Tillage Tools, Dredge Parts, Shedder Knives, Extruder Screws
	1/8", 5/32", 3/16", 1/4"	Bucket Arms, Chain Links, Rolling Mill Guides, Pulley, Scrappers, Blades
.045", 1/16", 5/64"		Bucket Slides & Lips, Blades, Clam Shell bucket, Augers, Scraper Sides
.045", 1/16", 5/64"		Scraper Slides, Scraper Cutters Vibrator Ditcher Shanks, Pot Hole Augers
1/16", 7/64"		Muller Plows, Chisel Plow, Ammonia Injectors, Raymond Mill Plows
1/16", 3/32", 7/64"	5/32", 3/16"	Farm Drill Points, Dry Cement Pump Screws, Drill Pipe Stabilizer, Paddles
	1/8", 5/32", 3/16", 1/4"	Plow Points, Cane Knives, Teeth, Tool Drill Bits
.045", 1/16", 3/32"	1/8", 5/32", 3/16", 1/4", 5/16" (also in bare rod)	Valves Trim, Pump Sleeves, Engine Valves, Pulp Digester Blades, Dies
.045", 1/16"	1/8", 5/32", 3/16", 1/4", 5/16" (also in bare rod)	Cavitation Applications, Hot Working Dies, Turbine Runners, Valve Seat

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Stoody® Hardfacing & Welding Wires

Stoody is the world's leader in the production of welding wires and electrodes used to combat various types of wear and corrosion. Our extensive family of products includes iron, nickel, cobalt, tungsten and vanadium based alloys. Some of the major industries we serve are power generation, mining, construction, railroad, steel, foundry, oil and gas production and exploration as well as the pulp and paper industry.

Stainless Steel Flux Cored Wires

BRILLIANT 410NiMo T-1 AP

Stoody AP stainless steel wires are designed for welding in all positions with Argon/CO2 gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters. AWS classification A5.22-95 410NiMoTI-4.

Stoody 410NiMoT-1 AP wires can be used to join martensitic stainless steels such as 410 used in valve and pump manufacturing. These wires can also be used for the repair and joining of CA-6NM castings.

Typical Composition:
Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum

Typical Deposit Characteristics:

Tensile Strength, Ksi (MPa)	134 (880)
Yield Strength, Ksi (Mpa)	118 (776)
Elongation (%)	19
Charpy V-Notch Toughness @ 32°F (0°C)	25ft-lbs (34 Joules)

Part Number	Packaging	Wire Diameter in.	mm	Shielding Gas	Welding Parameters Amps	Volts
11921000	33# WB, VP	1/16	1.6	75% Ar, 25% CO2	190-250	26-27

BRILLIANT 2209 T-1 AP

Stoody AP stainless steel wires are designed for welding in all positions with either 100% CO2 (X=1) or Argon/CO2 (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody 2209T-1 AP wires can be used to weld duplex stainless steels which contain approximately 22% chromium. The composition is balanced to achieve a microstructure of approximately 50% ferrite and 50% austenite in the weld deposit. AWS classification A5.22-95 E2209TO-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum, Nitrogen

Typical Deposit Characteristics:

Tensile Strength, Ksi (MPa)	122 (842)
Yield Strength, Ksi (Mpa)	101 (670)
Elongation (%)	27.5
Charpy Impact Toughness @ -40°F (-40°C)	33ft-lbs (20 Joules)

Part Number	Packaging	Wire Diameter in.	mm
11892000	33# WB, LLW	.045	1.2
11892100	33# WB, LLW	1/16	1.6

.045" (1.2mm)					
Amps		130[1]	165[1]	190[1]	220[2]
Volts		24	26	26	27
WFS	in/min	227	315	445	565
	(m/min)	(5.8)	(8.7)	(11.3)	(14.4)

.1/16" (1.6mm)					
Amps		170[1]	210[1]	250[1]	300[2]
Volts		25	26	27	28
WFS	in/min	115	195	245	320
	(m/min)	(3.9)	(4.9)	(6.2)	(8.2)

Notes:
Electrical stick-out 1/2" 1. Flat and vertical welding 2. Flat welding only

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308L T-1 AP

Stoody AP stainless steel wires are designed for welding in all positions with either 100% CO2 (X=1) or Argon/CO2 (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody 308LT-1 AP wires can be used to join AISI 301, 302, 304 commonly used in the chemical industry and food processing applications. AWS classification A5.22-95 E308LT1-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel

Typical Deposit Characteristics:	75 AR/25 CO2	100% CO2
Tensile Strength, Ksi (MPa)	88 (610)	86 (600)
Elongation (%)	39	41
Yield Strength, Ksi (Mpa)	63 (435)	60 (415)

Part Number	Packaging	Wire Diameter in.	mm
11953600	25# WB	.035	0.9
11819000	33# WB	.045	1.2
11819100	33# WB	1/16	1.6

.035" (0.9mm)					
Amps		100[1]	120[1]	150[1]	170[2]
Volts		25	26	27	27
WFS	in/min	275	374	480	600
	(m/min)	(6.9)	(9.5)	(12.2)	(15.3)

.045" (1.2mm)					
Amps		130[1]	165[1]	190[1]	220[2]
Volts		24	26	26	27
WFS	in/min	227	315	445	565
	(m/min)	(5.8)	(8.7)	(11.3)	(14.4)

.1/16" (1.6mm)					
Amps		170[1]	210[1]	250[1]	300[2]
Volts		25	26	27	28
WFS	in/min	115	195	245	320
	(m/min)	(3.9)	(4.9)	(6.2)	(8.2)

Notes:
Electrical stick-out 1/2" 1. Flat and vertical welding 2. Flat welding only

308L T-1 FH

Stoody FH stainless steel , flux cored wires are designed for flat and horizontal welding applications, using either 100% CO2 (X=1) or Argon/CO2 (X=4) gas mixtures. These wires exhibit a spray like arc transfer with very low levels of spatter, a slag system that is essentially self-releasing, a smooth evenly ripped bead appearance, and deposition rates which are obtained at lower levels of heat input than competitive products.

Stoody 308LT-1 FH wires can be used to join AISI 301, 302, 304 commonly used in the chemical industry and food processing applications. AWS classification A5.22 E308LT0-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel

Typical Deposit Characteristics:	75 AR/25 CO2	100% CO2
Tensile Strength, Ksi (MPa)	87 (600)	84 (573)
Elongation (%)	37	38
Yield Strength, Ksi (Mpa)	62 (430)	60 (415)

Part Number	Packaging	Wire Diameter in.	mm
11703100	35# WB, VP	.035	0.9
11869400	33# WB, VP	.045	1.2
11869300	33# WB, VP	1/16	1.6

.035" (0.9mm)		Low	Optimum	High
Amps		120	150	180
Volts		24	25/26	28
WFS	in/min	375	460	550
	(m/min)	(9.5)	(11.7)	(14.0)

.045" (1.2mm)		Low	Optimum	High
Amps		135	200	250
Volts		23	26	31
WFS	in/min	200	350	450
	(m/min)	(5.0)	(8.9)	(11.4)

.1/16" (1.6mm)		Low	Optimum	High
Amps		200	250	300
Volts		24/26	26/28	28/30
WFS	in/min	175	250	325
	(m/min)	(4.5)	(6.4)	(8.3)

Notes:
- 3/8" - 1/2" (10-12mm) electrical stickout
- When using Argon / Carbon Dioxide mixtures, voltage may be reduced by up to one volt to improve weldability and bead appearance.

309L T-1 AP

Stoody AP stainless steel wires are designed for welding in all positions with either 100% CO2 (X=1) or Argon/CO2 (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody 309LT-1 AP wires can be used to join AISI 309 steels. It is also used to join AISI 304 to carbon and low alloy steels. AWS classification A5.22 E309LTI-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel

Typical Deposit Characteristics:	75 AR/25 CO2	100% CO2
Tensile Strength, Ksi (MPa)	88 (610)	86 (600)
Elongation (%)	34	38
Yield Strength, Ksi (Mpa)	69 (480)	64 (440)

Part Number	Packaging	Wire Diameter in.	mm
11953400	25# WB	.035	0.9
11819300	33# WB	.045	1.2
11819400	33# WB	1/16	1.6

.035" (0.9mm)					
Amps		100[1]	120[1]	150[1]	170[1]
Volts		25	26	27	27
WFS	in/min	275	374	480	600
	(m/min)	(6.9)	(9.5)	(12.2)	(15.3)

.045" (1.2mm)					
Amps		130[1]	165[1]	190[1]	220[2]
Volts		24	26	26	27
WFS	in/min	227	315	445	565
	(m/min)	(5.8)	(8.7)	(11.3)	(14.4)

.1/16" (1.6mm)					
Amps		170[1]	210[1]	250[2]	300[2]
Volts		25	26	27	28
WFS	in/min	115	195	245	320
	(m/min)	(3.9)	(4.9)	(6.2)	(8.2)

Notes:
3/8" - 1/2" (10 - 12mm) Electrical stick-out.
1. Flat and vertical welding
2. Flat welding only

309L T-1 FH

Stoody FH stainless steel , flux cored wires are designed for flat and horizontal welding applications, using either 100% CO2 (X=1) or Argon/CO2 (X=4) gas mixtures. These wires exhibit a spray like arc transfer with very low levels of spatter, a slag system that is essentially self-releasing, a smooth evenly ripped bead appearance, and deposition rates which are obtained at lower levels of heat input than competitive products.

Stoody 309LT-1 FH wires can be used to join AISI 309 steels. it is also used to join AISI 304 to carbon and low alloy steels. AWS classification A5.22 E308LTO-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel

Typical Deposit Characteristics:	75 AR/25 CO2	100% CO2
Tensile Strength, Ksi (MPa)	84 (585)	83 (580)
Elongation (%)	34	33
Yield Strength, Ksi (Mpa)	61 (420)	61 (420)

Part Number	Packaging	Wire Diameter in.	mm
11703400	25# WB, VP	.035	0.9
11869600	33# WB, VP	.045	1.2
11869500	33# WB, VP	1/16	1.6

.035" (0.9mm)		Low	Optimum	High
Amps		120	150	180
Volts		24	25/26	28
WFS	in/min	375	460	550
	(m/min)	(9.5)	(11.7)	(14.0)

.045" (1.2mm)		Low	Optimum	High
Amps		135	200	250
Volts		23	26	31
WFS	in/min	200	350	450
	(m/min)	(5.0)	(8.9)	(11.4)

.1/16" (1.6mm)		Low	Optimum	High
Amps		200	250	300
Volts		24/26	26/28	28/30
WFS	in/min	175	250	325
	(m/min)	(4.5)	(6.4)	(8.3)

Notes:
- 3/8" - 1/2" (10-12mm) electrical stickout
- When using Argon / Carbon Dioxide mixtures, voltage may be reduced by up to one volt to improve weldability and bead appearance.

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316L T-1 AP

Stoody AP stainless steel wires are designed for welding in all positions with either 100% CO2 (X=1) or Argon/CO2 (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody 316LT-1 AP wires can be used to join AISI 316 and 316L commonly used in the rubber, chemical, petrochemical and dye industries. AWS classification A5.22 E308LTI-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum

Typical Deposit Characteristics:	**75 AR/25 CO2**	**100% CO2**
Tensile Strength, Ksi (MPa)	88 (610)	86 (600)
Elongation (%)	36	39
Yield Strength, Ksi (Mpa)	66 (460)	62 (430)

Part Number	**Packaging**	**Wire Diameter in.**	**mm**
11953500	25# WB	.035	0.9
11819600	33# WB	.045	1.2
11819700	33# WB	1/16	1.6

.035" (0.9mm)					
Amps		100[1]	120[1]	150[1]	170[1]
Volts		25	26	27	27
WFS	in/min	275	374	480	600
	(m/min)	(6.9)	(9.5)	(12.2)	(15.3)

.045" (1.2mm)					
Amps		130[1]	165[1]	190[1]	220[2]
Volts		24	26	26	27
WFS	in/min	227	315	445	565
	(m/min)	(5.8)	(8.7)	(11.3)	(14.4)

.1/16" (1.6mm)					
Amps		170[1]	210[1]	250[2]	300[2]
Volts		25	26	27	28
WFS	in/min	115	195	245	320
	(m/min)	(3.9)	(4.9)	(6.2)	(8.2)

Notes:
1/2" Electrical stick-out. 1. Flat and vertical welding 2. Flat welding only

316L T-1 FH

Stoody FH stainless steel , flux cored wires are designed for flat and horizontal welding applications, using either 100% CO2 (X=1) or Argon/CO2 (X=4) gas mixtures. These wires exhibit a spray like arc transfer with very low levels of spatter, a slag system that is essentially self-releasing, a smooth evenly ripped bead appearance, and deposition rates which are obtained at lower levels of heat input than competitive products.

Stoody 316LT-1 FH wires can be used to join AISI 316 and 316L commonly used in the rubber, chemical, petrochemical and dye industries. AWS classification A5.22 E316LTO-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum

Typical Deposit Characteristics:	**75 AR/25 CO2**	**100% CO2**
Tensile Strength, Ksi (MPa)	88 (610)	82 (570)
Elongation (%)	35	36
Yield Strength, Ksi (Mpa)	65 (450)	60 (415)

Part Number	**Packaging**	**Wire Diameter in.**	**mm**
11703700	25# WB, VP	.035	0.9
11869700	33# WB, VP	.045	1.2
11869800	33# WB, VP	1/16	1.6

.035" (0.9mm)		**Low**	**Optimum**	**High**
Amps		120	150	180
Volts		24	25/26	28
WFS	in/min	375	460	550
	(m/min)	(9.5)	(11.7)	(14.0)

.045" (1.2mm)		**Low**	**Optimum**	**High**
Amps		135	200	250
Volts		23	26	31
WFS	in/min	200	350	450
	(m/min)	(5.0)	(8.9)	(11.4)

.1/16" (1.6mm)		**Low**	**Optimum**	**High**
Amps		200	250	300
Volts		24/26	26/28	28/30
WFS	in/min	175	250	325
	(m/min)	(4.5)	(6.4)	(8.3)

Notes:
- 3/8" - 1/2" (10-12mm) electrical stickout
- When using Argon / Carbon Dioxide mixtures, voltage may be reduced by up to one volt to improve weldability and bead appearance.

Nickel Flux Cored Wires

STOODY 82-T1

Stoody 82-T1 is a gas shielded All Position Flux Cored Wire that meets the requirements of AWS A5.34, Class ENiCr3TX-Y.

Applications: Joining nickel-chromium-iron alloys, Clad side of joints in steels clad with nickel-chromium-iron weld metal, Surfacing steel with nickel-chromium-iron weld metal, Joining Inconel 600, 601 and Incoloy 800 to themselves or to stainless and carbon steels

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Iron, Niobium, Sulfer, Phosphorus, Nickel

Typical Deposit Characteristics:
Tensile Strength .....89 ksi (614 Mpa)
Yield Strength .....58 ksi (400 Mpa)
Elongation. .....26 %

Part Number	Packaging	Wire Diameter in.	mm	Shielding Gas	Welding Parameters Wire Ext.	Amps	Volts
11872700	33# WB	.045	1.2	75% AR-25% CO2 or 100%CO2	1/2	150-200	25-26
11872600	33# WB	1/16	1.6	75% AR-25% CO2 or 100%CO2	1/2	200-250	26-27

STOODY 182-T1

Stoody 182-T1 is a gas shielded All Position Flux Cored Wire that meets the requirements of AWS 5.34 ENiCrFe3TX-Y.

Applications: Joining nickel-chromium-iron alloys, Clad side of joints in steels clad with nickel-chromium-iron weld metal, Surfacing steel with nickel-chromium-iron weld metal, Joining Alloys 600, 601 and Incoloy 800 to themselves or to stainless and carbon steels

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Iron, Niobium, Sulfer, Phosphorus, Nickel

Typical Deposit Characteristics:
Tensile Strength .....94 ksi (649 Mpa)
Yield Strength .....58 ksi (400 Mpa)
Elongation. .....35 %

Part Number	Packaging	Wire Diameter in.	mm	Shielding Gas	Welding Parameters Wire Ext.	Amps	Volts
11916200	33# WB	.045	1.2	75% AR-25% CO2 or 100%CO2	1/2	150-200	25-26
11916100	33# WB	1/16	1.6	75% AR-25% CO2 or 100%CO2	1/2	200-250	26-27

STOODY A-T1

Stoody A-T1 is a gas shielded All Position Flux Cored Wire that meets the requirements of AWS 5.34 ENiCrFe2TX-Y.

Applications: Joining nickel-chromium-iron alloys, Joining nickel steels, Joining Inconel 600, 601 and Icoloy 800 to themselves or to stainless and carbon steels

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Iron, Molybdenum, Niobium, Sulfer, Phosphorus, Nickel

Typical Deposit Characteristics:
Tensile Strength .....89.5 ksi (595 Mpa)
Yield Strength .....51.0 ksi (340 Mpa)
Elongation. .....45 %
Charpy Impact Toughness. .....67 Ft.-lbs. (92 Joules) at -320°F (-196°C)
Lateral Expansion..... 46 mils (1.2mm) at -320°F (-196°C)

Part Number	Packaging	Wire Diameter in.	mm	Shielding Gas	Welding Parameters Wire Ext.	Amps	Volts
11896500	33# WB, LLW	.045	1.2	75% AR-25% CO2 or 100%CO2	1/2	150-200	25-26
11896700	33# WB, LLW	1/16	1.6	75% AR-25% CO2 or 100%CO2	1/2	200-250	26-27

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STOODY 625-T1

Stoody 625-T1 is a gas shielded All Position Flux Cored Wire that meet the requirements of AWS 5.34 ENiCrMo3TX-Y.

Applications: Joining nickel-chromium-molybdenum alloys, Clad side of joints in steels clad with nickel-chromium-molybdenum weld metal, Surfacing steel with nickel-chromium-molybdenum weld metal, Joining steels to nickel based alloys, Joining 9% nickel steel for cryogenic applications

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Molybdenum, Iron*, Noibium, Sulfer, Phosphorus, Nickel

*For Iron <1%, please request Stoody 625LI-T1 (PDS SP-029)

Typical Deposit Characteristics:
Tensile Strength .....112 ksi (773 Mpa)
Yield Strength .....72 ksi (497 Mpa)
Elongation. .....38 %

Part Number	Packaging	Wire Diameter in.	mm	Shielding Gas	Welding Parameters Wire Ext.	Amps	Volts
11872500	33# WB, LLW	.045	1.2	75% AR-25% CO2 or 100%CO2	1/2	150-200	25-26
11872400	33# WB, LLW	1/16	1.6	75% AR-25% CO2 or 100%CO2	1/2	200-250	26-27

STOODY C276-T1

Stoody C276-T1 is a gas shielded All Position Flux Cored Wire that meet the requirements of AWS 5.34 ENiCrMo4TX-Y.

Applications: Joining nickel-chromium-molybdenum alloys, Clad side of joints in steels clad with nickel-chromium-molybdenum weld metal, Surfacing steel with nickel-chromium-molybdenum weld metal, Joining higher molybdenum - high nitrogen containing stainless steels

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Molybdenum, Iron, Tungsten, Sulfer, Phosphorus, Nickel

Typical Deposit Characteristics:
Tensile Strength .....106 ksi (705 Mpa)
Yield Strength .....68 ksi (452 Mpa)
Elongation. .....42 %

Part Number	Packaging	Wire Diameter in.	mm	Shielding Gas	Welding Parameters Wire Ext.	Amps	Volts
11953700	33# WB, LLW	.045	1.2	75% AR-25% CO2 or 100%CO2	1/2	150-200	25-26
	33# WB, LLW	1/16	1.6	75% AR-25% CO2 or 100%CO2	1/2	200-250	26-27

STOODY 622-T1

Stoody 622-T1 is a gas shielded All Position Flux Cored Wire that meet the requirements of AWS 5.34 ENiCrMo10TX-Y.

Applications: Joining nickel-chromium-molybdenum alloys, Clad side of joints in steels clad with nickel-chromium-molybdenum weld metal, Surfacing steel with nickel-chromium-molybdenum weld metal, Joining higher molybdenum - high nitrogen containing stainless steels

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Molybdenum, Iron, Tungsten, Sulfer, Phosphorus, Nickel

Typical Deposit Characteristics:
Tensile Strength .....103 ksi (685 Mpa)
Yield Strength .....70 ksi (470 Mpa)
Elongation. .....27 %

Part Number	Packaging	Wire Diameter in.	mm	Shielding Gas	Welding Parameters Wire Ext.	Amps	Volts
11953800	33# WB, LLW	.045	1.2	75% AR-25% CO2 or 100%CO2	1/2	150-200	25-26
	33# WB, LLW	1/16	1.6	75% AR-25% CO2 or 100%CO2	1/2	200-250	26-27