

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 |

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