



DESCRIPTION

Stoody[®] 31 is the most general purpose hardfacing electrode in Stoody's product line. It offers an excellent balance of abrasion resistance and impact strength, making it very versatile. Stoody 31 is a tubular electrode with an extruded coating. Deposits have a low coefficient of friction and provide good resistance to corrosion and heat. The deposits are not machinable or forgeable. Weldability is excellent with slag coverage that is virtually self-removing. Stoody 31 can be applied to carbon, low alloy, and manganese steels.

TYPICAL APPLICATIONS

- Bucket Arms
- Chain Links
- Buckets
- Scrapers
- Rolling Mill Guides, Pulleys
- Blades
- Hammers
- Crusher Parts

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good Moderate
Hardness	HRC 45 – 49
Magnetic	
on Carbon steel	Slightly
on Manganese steel	No
Surface Cross Checks	Yes
Deposit Layers	2
Machinable	No
Hot Wear Applications	Up to 950 ⁰ F

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm) Current, Amp. DC+, AC Position	1/8 (3.2) 100 – 120 Flat / Horizontal	5/32 (4.0) 120 – 180 Flat
Diameter, In. (mm)	3/16 (4.8)	1∕ ₄ (6.4)
Current, Amp. DC+, AC	170 – 240	250 – 325
Position	Flat	Flat

ALLOY TYPE

Chromium Carbides in an Austenitic Matrix

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Vac Pak	10206300
5/32" (4.0mm)	10# Vac Pak	10206400
3/16" (4.8mm)	10# Vac Pak	10206500
1/4" (6.4mm)	10# Vac Pak	10206600

Stoody Company

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NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data.

procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data. PROTECT YOURSELF AND OTHERS - Users should read and follow all recommended guidance on health and safety from their employer, the supplier, the manufacturer, and government authorities. These, at a minimum including the Warning Labels on the products and the Material Safety Data Sheets ("MSDS"). The MSDS and additional safety information may be found on materials or links at: www.stoody.com.