

## DESCRIPTION

Stoody Build-Up LH deposit is a low alloy steel designed for low severity metal-to-metal wear. The electrode has a special low hydrogen coating which provides a high strength fusion bond on carbon and low alloy steels. As a base alloy for hardsurfacing overlays or for restoring parts to original dimensions, it provides a weld deposit with excellent compressive strength capable of absorbing heavy impact and/or compressive loads. It can be applied in multiple layers without cracking, spalling, or mushrooming. It is machinable in the as-welded condition with reasonable procedural care and can be forged at red heat. It is not recommended for manganese steel or cast iron and does not work harden. It should not be used for joining.

## TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Low
Impact Resistance	Good
Hardness on Carbon Steel	
1 Layer	HRC 27
2 Layers	HRC 29
3 Layers	HRC 31
Tensile Strength	118,000 psi
Yield Strength	113,000 psi
Elongation	6%
Deposit Layers	Unlimited

## ALLOY TYPE

Low Alloy Steel

## TYPICAL APPLICATIONS

Typical applications include:

- Tractor Rollers
- Tractor and Shovel Idlers
- Machine Shafts
- Clevis Pins
- Steel Shovel Pads
- Gear Teeth
- Sprockets

## OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	<b>1/8 (3.2)</b>	<b>5/32 (4.0)</b>
Current, Amp. DCRP	100 – 185	140 – 250
Position	All	All
Length	14"	14"
Diameter, In. (mm)	<b>3/16 (4.8)</b>	<b>¼ (6.4)</b>
Current, Amp. DCRP	180 – 310	200 – 360
Position	Flat	Flat
Length	14"	18"

## STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Vac Pak	11414100
5/32" (4.0mm)	10# Vac Pak	11412900
3/16" (4.8mm)	10# Vac Pak	11413000
¼ " (6.4mm)	10# Vac Pak	11413100

**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.  
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 include 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](http://www.stoody.com).