

## STOODY 965-G/O

### PRODUCT DATA SHEET



### GAS (-G) AND SELF SHIELDED (-O), TUBULAR HARDFACING WIRES



### COBALARC AND STOODY HARDFACING CONSUMABLES

#### STOODY 965-G/O

- Air Hardening, Crack Free, Martensitic Steel Deposit.
- Resistant to Hard Particle Abrasion and Moderate Impact Loading.
- Typical applications include the surfacing of agricultural points, shares and tynes, sand dredge cutter heads, dredge rollers and tumblers, conveyor screws, bucket lips, etc.
- 1.2mm and 1.6mm sizes can be used for vertical surfacing by depositing overlapping horizontal stringer passes.
- 1.2mm and 1.6mm wires are B5 type wires which require a shielding gas. 2.0mm and 2.4mm size are B7 type open arc wires which require no shielding gas.

#### CLASSIFICATIONS:

	1.2mm & 1.6mm	2.0mm & 2.4mm*
AS/NZS 2576:	1855-B5	1855-B7
W.T.I.A. Tech Note 4:	1855-B5	1855-B7

\* - 1.2mm and 1.6mm Stoody 965-G wires are B5 type wires which require a shielding gas. 2.0 and 2.4mm Stoody 965-O are B7 type open arc wires which require no shielding gas.

#### TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

C:	0.60%
Mn:	1.70%
Si:	1.40%
Cr:	6.20%
Fe:	Balance

#### TYPICAL WELD DEPOSIT HARDNESS:

	HR <sub>c</sub> :	HV <sub>30</sub> :
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	58	640

#### FINISHING RECOMMENDATIONS:

Not Machinable. Grinding only.

## RECOMMENDED SHIELDING GASES:

1.2mm & 1.6mm 965-G	Ar + 1-3% O2 or equivalent ISO14175: M13
2.0mm & 2.4mm 965-0	Open arc or welding grade C02 ISO14175: C1

## DESCRIPTION AND APPLICATIONS:

Stoody 965-G/0 is a tubular hard surfacing wire for surfacing components subjected to wet or dry hard particle abrasion and low to moderate impact loading. The air hardening martensitic steel weld deposit of Stoody 965-G/0 remains crack free on most steels under normal welding conditions and is therefore recommended for the surfacing of components subject to flexing during service. 1.2mm Stoody 965-G/0 is ideal for all positional surfacing applications with the Transmig 225, 255 and 350 power sources.

Typical applications include the surfacing of agricultural points, shares and tynes, sand dredge cutter heads, dredge rollers and tumblers, conveyor screws, bucket lips, etc.

## PACKAGING AND OPERATING DATA:

DC Electrode Negative.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	RECOMMENDED STICKOUT (ESO) MM	PARCK TYPE	PACK WEIGHT	PART NO
1.2	120-220	18-24	15-20	Spool	4.5kg	11423000
1.2	120-220	18-24	15-20	Spool	15kg	11423100
1.6	140-250	23-26	20-25	Spool	15kg	11501500
2.0	180-300	24-28	20-30	Coil	27kg	11962600*
2.4	200-350	24-28	20-30	Coil	27kg	11946100*

\*Available with a lead time.

## COMPARABLE CIGWELD PRODUCTS:

Cobalarc 650 extruded electrode  
AS/NZS 2576: 1855-A4

## WELDING POSITIONS:

Downhand and Horizontal build-up applications:

- 1.2mm and 1.6mm sizes can be used for vertical surfacing by depositing overlapping horizontal stringer passes.

