STOODY®

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FCAW

STOODY 101 HC-G/O

PRODUCT DATA SHEET

HIGH ALLOY, TUBULAR HARDFACING WIRE

COBALARC AND STOODY HARDFACING CONUSMABLES

STOODY 101 HC-G/O

- High Alloy, Tubular Hardfacing Wire.
- High Chromium - Carbide Iron Deposit. For Ground Engaging Applications.
- Resistant to Severe Abrasion and Low to Moderate Impact Loading.
- Typical applications include the hard surfacing of crusher cones and mantles, swing hammers, earthmoving buckets, scarifier points and sugar harvesting and milling equipment.

CLASSIFICATIONS:

	1.2mm*	1.6mm*
ISO AS/NZS 2576:	**2360-B5**	**2360-B7**
W.T.I.A. Tech Note 4:	**2360-B5**	**2360-B7**

* 1.2mm 101 HC-G is a B5 type wire which requires a shielding gas.
1.6mm 101 HC-O is a B7 type wire which requires no shielding gas.

TYPICAL WELD DEPOSIT ANALYSIS:

SINGLE LAYER ON MILD STEEL:	
C:	**4.0%**
Mn:	**0.7%**
Si:	**0.7%**
Cr:	**14.0%**

ALL WELD METAL DEPOSIT:	
C:	**5.2%**
Mn:	**0.7%**
Si:	**0.7%**
Cr:	**19.0%**

CIGWELD Data Sheet **STOODY 101 HC-G/O V1-2024**
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V1-2024

DESCRIPTION AND APPLICATIONS:

Stoody 101 HC-G/O is a high alloy tubular hardfacing wire depositing a high chromium carbide iron particularly resistant to severe coarse (large particle) abrasion. The weld deposit of Stoody 101 HC-G/O produces a high level of primary chromium carbides resistant to coarse abrasion (in particular gouging abrasion) at temperatures up to 650°C.

Weld deposits can be finished by grinding and relief checking is normal. Typical applications of Stoody 101 HC-G/O include the hard surfacing of crusher cones and mantles, swing hammers, earthmoving buckets, scarifier points and sugar harvesting and milling equipment. For high impact applications Stoody 101 HC-G/O deposits should be restricted to one layer.

WELD DEPOSIT MICROSTRUCTURE:

Two layers of Stoody 101 HC-G/O onto a mild steel component will produce approximately 25 - 30% primary chromium iron carbides in a carbide-ferrite matrix ideal for severe abrasion and low to moderate impact applications.

TYPICAL WELD DEPOSIT HARDNESS:

	HR_C:	**HV_{30}:**
Single Layer on Mild Steel	**55**	**600**
All Weld Metal Deposit	**60**	**700**

Deposits contain Chromium Carbides with hardness up to 1,500 HV (80 HRc).

FINISHING RECOMMENDATIONS:

Grinding only.

PACKAGING AND OPERATING DATA:

DC Electrode Positive.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	RECOMMENDED STICKOUT (ESO) MM	PARCK TYPE	PACK WEIGHT	PART NO
1.2	150-200	22-26	12-20	Spool	15kg	11436300
1.6	200-260	24-28	15-25	Spool	15kg	11304700

RECOMMENDED SHIELDING GAS:

1.2MM 101 HC-G	**AR+ 1-3% O_2 OR EQUIVALENT ISO14175: M13**
1.6MM 101 HC-O	**OPEN ARC OR WELDING GRADE CO_2 ISO14175: C1**

COMPARABLE CIGWELD PRODUCTS:

Cobalarc CR70 extruded electrode
AS/NZS 2576: 2355-A4

WELDING POSITIONS:

Downhandand Horizontal surfacing applications:

- 1.2mm size is suitable for vertical-up surfacing using a wide weaving technique.