

STOODY® 101AP

Open Arc Welding Wire

Stoody 101AP open arc wire is a high chromium carbide iron base tubular wire. The higher chromium content aims at a minimum of 25% chromium (as well as a maximum of 0.18 g ASTM G65 weight loss) in a two layer weld deposit. Stoody 101AP was specially formulated to improve out of position horizontal welding when compared to other chrome carbide welding wires. The unique formulation is recommended for application subject to severe abrasion. The weld deposits develop a tight cross-checking pattern (3/8" - 1/2"). The cracking is some times referred to as relief cracking. It can be applied to carbon, low alloy, or manganese steels and can be used in hot wear applications up to 900°F (482°C). Deposits can not be machined or forged.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Medium
Hardness, 2 Layers on 1020 Carbon Steel, HRC	60 – 64
Surface Cross Checks	Yes
Magnetic	Yes
Hot Wear Application	Up to 900°F (482°C)

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

- Pipe ID cladding
- Pipe flange faces
- Copper smelter ladles overlay
- Sugar mill roll underlay
- Scraper sides, cutter, and blades
- Shovel bucket tooth adapters
- Crushing and grinding equipment
- Ripper shanks and teeth
- Bucket sides and lips
- Conveyors and screws
- Fan blades

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

0.045" (1.2 mm)

Current DCEP, amp	175 – 225
Voltage (volts)	23 – 27
Wire Extension, in (mm)	1/2 – 3/4 (13 – 19)

1/16" (1.6 mm)

Current DCEP, amp	225 – 275
Voltage (volts)	24 – 28
Wire Extension, in (mm)	1/2 – 1 (13 – 25)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
0.045" (1.2 mm)	33 lb (15 kg) Wire Basket	12055000
1/16" (1.6 mm)	33 lb (15 kg) Wire Basket	12040800

PDS-CRC-W-037
Revision 2
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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 including the Warning Labels on the products and the Safety Data Sheets ("SDS"). The SDS and additional safety information may be found on materials or links at: Stoody.com.