

# STOODY®

AN ESAB® BRAND

FCAW

## STOODY 850-0

### PRODUCT DATA SHEET



### SELF SHIELDED (-0), TUBULAR HARDFACING WIRE



### COBALARC AND STOODY HARDFACING CONSUMABLES

#### STOODY 850-0

- Self Shielded (-0), Tubular Hardfacing Wire.
- Air Hardening, Crack Prone High Carbon, Martensitic Steel Deposit.
- Resistant to Severe Abrasion and Low Impact Loading.
- Typical applications include the hard surfacing of agricultural, mining and materials handling equipment including tynes, points, conveyor screws, dredge buckets, cane harvester cutters/elevators and sugar mill scraper plates.
- 1.2mm size can be used for vertical surfacing by depositing overlapping horizontal stringer passes.

#### CLASSIFICATIONS:

ISO AS/NZS 2576:	1865-B7
W.T.I.A. Tech Note 4:	1865-B7

#### TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

C:	0.95%
Mn:	0.6%
Si:	0.9%
Cr:	6.5%
Mo:	3.5%
B:	1.5%

#### TYPICAL WELD DEPOSIT HARDNESS:

	HR <sub>c</sub> :	HV <sub>30</sub> :
Single Layer on Mild Steel	62	750
All Weld Metal Deposit	65	830

DESCRIPTION AND APPLICATIONS:

Stoody 850-0 is a self shielded (or open arc) hard surfacing wire which deposits a high carbon martensitic steel for excellent resistance to severe, fine (wet or dry) abrasion and low impact loading.

Weld deposits are air hardening and prone to fine relief checking. Stoody 850-0 should not be used in applications involving heavy impact or shock loading. 1.2mm Stoody 850-0 is ideal for all positional surfacing applications with the Transmig 250 and 275 power plant.

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FINISHING RECOMMENDATIONS:

Grinding only.

RECOMMENDED SHIELDING GAS:

OPEN ARC OR WELDING GRADE CO<sub>2</sub>  
ISO14175: C1

PACKAGING AND OPERATING DATA:

C Electrode Positive.

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	15kg	11945500

COMPARABLE CIGWELD PRODUCTS:

Cobalarc 750.

WELDING POSITIONS:

Downhandand Horizontal surfacing applications:

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

