

## STOODY® 965 AP-G

### Gas Shielded Flux Cored Wire

Stoody 965 AP-G is a gas shielded, flux cored, all position, general purpose, hardfacing wire. The deposit offers a good balance of impact and abrasion resistance. It can be used in both metal-to-metal and metal-to-earth applications. Deposits are forgeable but not readily machinable. Stoody 965 AP-G has a smooth semi-spray transfer and can be applied to carbon, low alloy, and manganese steels. It is magnetic on carbon and low alloy steels but not on manganese steels. Analysis and properties are similar to Stoody Self Hardening covered electrode.

#### TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Good
2 Layer Hardness, HRC	57 - 62
Deposit Layers	2 Normal, 3 Max
Position	Flat, Horizontal Vertical, Overhead
Magnetic:	
On Low Alloy and Carbon Steel	Yes
On Manganese Steel	No
Surface Cross Checks	No
Machinability	Grind Only

#### ALLOY TYPE

Martensitic Tool Steel

#### TYPICAL APPLICATIONS

- Tillage tools
- Dredge parts
- Sliding metal parts
- Tire shredder knives
- Drag line bucket lips
- Extruder screws
- Tamper feet
- Churn drills
- Muller tires

#### OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

##### 0.045" (1.2 mm)

Current DCEP, amp	140 – 225
Wire Feed Speed, ipm (m/min)	240 – 470 (6.1 – 12)
Voltage (volts)	26 – 29
Wire Extension, in (mm)	1/2 – 3/4 (13 – 19)
Shielding Gas	75 Ar / 25 CO <sub>2</sub>
Position	All

##### 1/16" (1.6 mm)

Current DCEP, amp	170 – 275
Wire Feed Speed, ipm (m/min)	140 – 240 (3.6 – 6.1)
Voltage (volts)	24 – 30
Wire Extension, in (mm)	1/2 – 3/4 (13 – 19)
Shielding Gas	75 Ar / 25 CO <sub>2</sub>
Position	All

#### STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
0.045" (1.2 mm)	10 lb (4.5 kg) Plastic Spool	12023500
0.045" (1.2 mm)	33 lb (15 kg) Wire Basket	11807800
1/16" (1.6 mm)	33 lb (15 kg) Wire Basket	11808600
1/16" (1.6 mm)	200 lb (90.7 kg) Half Pak	11962400

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Revision 3

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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.

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