

STOODY® M7-G

Gas Metal Arc Welding Wire

Stoody M7-G deposit is a molybdenum high speed tool steel similar to AISI M7 grade. This material is characterized by a high hardness (58 to 66 HRC) and excellent wear resistance. It can be used at elevated temperatures up to 1000°F (538°C), under conditions of moderate thermal shock.

PREHEAT

Preheat is dependant on base metal requirements. Preheat high speed steels from 750°F (399°C) to 1200°F (649°C). On base metal other than high speed tool steel, preheat and post heat accordingly. Maintain temperature during welding.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Good
Deposit Layers	2 – 3
Hardness, HRC	58 – 66

ALLOY TYPE

High Speed M7 Tool Steel

TYPICAL APPLICATIONS

- Hot and cold dies
- Blanking dies
- Piercing dies
- Tire shredders
- Cutting and shaving knives
- Shear blades
- Excellent for cladding high wear areas on equipment and also for building composite dies and tools.

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

0.045" (1.2 mm)

Current DCEP, amp	125 – 180
Voltage (volts)	18 – 20
Wire Extension, in (mm)	1/2 (12)
Shielding Gas	75% Ar / 25% CO ₂

1/16" (1.6 mm)

Current DCEP, amp	200 – 300
Voltage (volts)	24 – 28
Wire Extension, in (mm)	1/2 – 3/4 (12 – 19)
Shielding Gas	75% Ar / 25% CO ₂

5/64" (2.0 mm)

Current DCEP, amp	250 – 350
Voltage (volts)	25 – 29
Wire Extension, in (mm)	1/2 – 3/4 (12 – 19)
Shielding Gas	75% Ar / 25% CO ₂

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
0.045" (1.2 mm)	33 lb (15 kg) Wire Basket	11810800
0.045" (1.2 mm)	50 lb (22.6 kg) Poly Pak	11849400
1/16" (1.6 mm)	33 lb (15 kg) Wire Basket	11868500
1/16" (1.6 mm)	50 lb (22.6 kg) Poly Pak	11834200
1/16" (1.6 mm)	200 lb (90.7 kg) Half Pak	11917900
1/16" (1.6 mm)	400 lb (181.4 kg) NTP Drum	11925500
5/64" (2.0 mm)	33 lb (15 kg) Wire Basket	11916500

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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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