

STOODY SUPER BUILDUP-G
HV₃₀
400

DC+


- ▲ Gas (-G) Tubular Hardfacing Wires.
- ▲ Tough, Machinable Low Carbon Martensitic Steel Deposit.
- ▲ Recommended for the build-up and surfacing of steel track rolls, idler wheels, track pads, drive sprockets, pins, links and other components subject to abrasion and/or metal-to-metal wear.
- ▲ 1.2mm and 1.6mm sizes can be used for vertical surfacing by depositing overlapping horizontal stringer passes.
- ▲ 1.2mm and 1.6mm wires are B5 type wires which require a shielding gas.

Classifications:

	1.2mm & 1.6mm
AS/NZS 2576:	1435-B5
W.T.I.A. Tech Note 4:	1435-B5

Description and Applications:

Stoody Super Buildup-G is a tubular hard surfacing wire designed for the re-building or surfacing of steel components subjected to metal-to-metal wear and compressive loading.

1.2mm Stoody Super Buildup-G is ideal for all positional surfacing applications with Transmig 250 and 275 power plants.

Depositing a tough, air hardening low carbon martensitic steel weld deposit, Stoody Super Buildup-G is recommended for the semi-automatic build-up and surfacing of steel track rolls, idler wheels, track pads, drive sprockets, pins, links and other components subjected to abrasion and/or metal-to-metal wear.

TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

C: 0.20%	Mn: 1.5%	Si: 0.4%
Cr: 2.0%	Mo: 0.5%	Fe: balance

TYPICAL WELD DEPOSIT HARDNESS:

	HR _C	HV ₃₀
Single Layer on Mild Steel	30	300
All Weld Metal Deposit	40	390

FINISHING RECOMMENDATIONS:

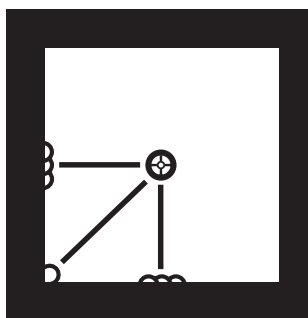
Machinable. Carbide tools recommended.

RECOMMENDED SHIELDING GAS:

- Ar + 1-3% O₂ ISO14175: M13
- Ar + 18-25% CO₂ or equivalent ISO14175: M21

COMPARABLE CIGWELD PRODUCTS:

Cobalarc 350 extruded electrode
 AS/NZS 2576: 1435-A4



Downhand & Horizontal build-up applications:-
 1.2mm and 1.6mm sizes can be used for vertical surfacing by depositing overlapping horizontal stringer passes.

Packaging and Operating Data:
DC Electrode Positive.

Wire Dia. 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	11423600
1.6	140-250	23-26	15-25	Spool	15kg	11946200