

*** STOODY** Shielded Metal Arc Welding (Stick) Electrodes



GROUP 1 - Build-Up and Joining Alloys – Iron Base

Build-up LH Low Alloy (4.5%) - Chromium, Molybdenum, Manganese, Silicon, Carbon

Part No	Price Per Pack	Size (dia) x (lgth)	Packaging	Amperage Range/Position	Description	Typical Deposit Characteristics	Typical Applications
11414100	\$49.95	1/8" x 14"	10lb. Vac	100 - 185 All	This electrode has a special low hydrogen coating which provides a high strength fusion bond on carbon and low alloy steels. As a base alloy for hardsurfacing overlays or for restoring parts to original dimensions, it provides a weld deposit with excellent compressive strength capable of absorbing heavy impact and/or compressive loads. It can be applied in multiple layers without cracking, spalling, or mushrooming. It is machinable in the as-welded condition with reasonable procedural care and can be forged at red heat. It is not recommended for manganese steel or cast iron and does not work harden. It should not be used for joining.	Abrasion Resistance: Low Impact Resistance: Good Hardness on Carbon Steel: 1 LayerHRC 27 2 LayersHRC 29 3 LayersHRC 31 Tensile Strength: 118,000 psi Yield Strength: 113,000 psi Elongation: 6% Deposit Layers:Unlimited Magnetic: Yes Machinability:Poor	<ul style="list-style-type: none"> Tractor Rollers Tractor and Shovel Idlers Machine Shafts Clevis Pins Steel Shovel Pads Gear Teeth Sprockets
11414100-1	\$8.95	1/8" x 14"	1lb.	100 - 185 All			
11412900	\$39.40	5/32" x 14"	10lb. Vac	140 - 250 All			
11412900-1	\$7.95	5/32" x 14"	1lb.	140 - 250 All			
11413000	\$37.50	3/16" x 14"	10lb. Vac	180 - 310 Flat			
11413100	\$37.50	1/4" x 18"	10lb. Vac	200 - 360 Flat			
Build-Up Only Of Carbon Steel, AC or DC+							

NicroMang® Austenitic Manganese Steel (Alloy 23%) Manganese, Chromium, Nickel, Carbon, Silicon

Part No	Price Per Pack	Size (dia) x (lgth)	Packaging	Amperage Range/Position	Description	Typical Deposit Characteristics	Typical Applications
45150850	\$297.00	1/8" x 14"	60lb.	100 - 160 Flat / Horiz.	An Austenitic manganese steel electrode with excellent impact strength. It has a high deposition rate and work hardens under impact. Deposits can be flame cut. It is designed for build up and joining of manganese steels and is not recommended for buildup of carbon steels. There is no limit to deposit thickness. When welding, the interpass temperature should not exceed 500°F.	Abrasion Resistance: Moderate Impact Resistance: Excellent Hardness, as Deposited: 200 HB Work Hardened: HRC 52 Tensile Strength: 120,000 psi Yield Strength: 70,000 psi Elongation: 42% Deposit Layers:Unlimited Surface Cross Checks:No Machinability: Poor Magnetic:No	<ul style="list-style-type: none"> Railroad Frogs and Crossings Crusher Equipment Parts Manganese Steel Castings Wobbler Spindles Coupling Boxes
45150810	\$51.10	1/8" x 14"	10lb.	100 - 160 Flat / Horiz.			
45150810-1	\$9.90	1/8" x 14"	1lb.	100 - 160 Flat / Horiz.			
45151050	\$268.00	5/32" x 14"	60lb.	140 - 200 Flat / Horiz.			
45151010	\$49.50	5/32" x 14"	10lb.	140 - 200 Flat / Horiz.			
45151010-1	\$9.50	5/32" x 14"	1lb.	140 - 200 Flat / Horiz.			
45151250	\$232.68	3/16" x 14"	60lb.	170 - 225 Flat			
45151210	\$42.78	3/16" x 14"	10lb.	170 - 225 Flat			
45151650	\$219.36	1/4" x 18"	60lb.	230 - 330 Flat			
11498800	\$40.33	1/4" x 18"	10lb.	230 - 330 Flat			
Build-Up & Joining Of Manganese Steel, AC or DC+							

2110 Austenitic Chromium Manganese Steel (Alloy 31%) Manganese, Chromium, Nickel, Carbon, Silicon

Part No	Price Per Pack	Size (dia) x (lgth)	Packaging	Amperage Range/Position	Description	Typical Deposit Characteristics	Typical Applications
11431300	\$81.60	1/8" x 14"	10lb.	100 - 130 Flat/ Horiz.	A solid core electrode designed for build-up of austenitic manganese parts subject to high impact loading. It is a modified high chromium – high manganese steel that combines toughness and wear resistance. There is no limitation on deposit thickness. Stooddy 2110 is not recommended for cast iron. It can be used on carbon steel or manganese steel base metal.	Abrasion Resistance: Good Impact Resistance: Excellent Hardness, As Deposited: 200 HB Work Hardened: On Manganese Steel ..HRC 50 - 55 Tensile Strength: 119,000 psi Yield Strength: 76,400 psi Elongation: 40% Deposit Layers:Unlimited Surface Cross Checks:No Machinability:With Carbide Tools Magnetic:No	<ul style="list-style-type: none"> Shovel Pads Hammers Grate Bars Switch Points Roll Crushers Shovel Teeth Carbon or Manganese Steel Frogs Manganese Steel Components
11431300-1	\$15.90	1/8" x 14"	1lb.	100 - 130 Flat			
10202800	\$67.67	5/32" x 14"	10lb.	125 - 190 Flat			
10202800-1	\$13.90	5/32" x 14"	1lb.	125 - 190 Flat			
10202900	\$61.50	3/16" x 14"	10lb.	150 - 260 Flat			
10203000	\$60.67	1/4" x 18"	10lb.	240 - 325 Flat			
Build-Up & Joining Of Carbon & Manganese Steel, AC or DC+							

GROUP 2 – Metal-To-Metal Wear – Iron Base

1105 Low Alloy (5%) - Chromium, Manganese, Silicon, Molybdenum, Vanadium, Carbon

Part No	Price Per Pack	Size (dia) x (lgth)	Packaging	Amperage Range/Position	Description	Typical Deposit Characteristics	Typical Applications
11345100	\$63.22	1/8" x 14"	10lb. Vac	80 - 150 Flat	A solid core electrode designed for wear resistance in metal-to-metal applications. It has an extruded coating containing the alloying elements. It provides good weldability and a high deposition rate. It bonds readily to carbon and low alloy steels and is not recommended for manganese steels or cast irons. It is forgeable at red heat. Hot wear applications up to 600°F	Abrasion Resistance: Moderate Impact Resistance: .. Moderate As Deposited: 200 HB Work Hardened: On Manganese Steel ..HRC 50 - 55 Deposit Layers: Up to 4 Surface Cross Checks: No Machinability:With Carbide Tools Magnetic: Yes	<ul style="list-style-type: none"> Tractor Rollers and Idlers Shovel Roller and Idlers Drive Tumblers Charging Car Wheels Arch Wheels Sprockets Churn Drills Wobblers
11345100-1	\$12.95	1/8" x 14"	1lb.	80 - 150 Flat			
11173800	\$53.56	5/32" x 14"	10lb. Vac	140 - 210 Flat			
11173800-1	\$10.95	5/32" x 14"	1lb.	140 - 210 Flat			
11173900	\$52.25	3/16" x 14"	10lb. Vac	165 - 250 Flat			
11173900-1	\$10.50	3/16" x 14"	1lb.	165 - 250 Flat			
Hard Surfacing Of Carbon & Low Alloy Steel, DC+							

GROUP 3 – Metal-To-Earth Moderate and/or Severe Wear – Iron Base

19 Chromium Carbides in an Semi-Austenitic Matrix (26%) - Chromium, Carbon, Molybdenum, Manganese, Silicon

Part No	Price Per Pack	Size (dia) x (lgth)	Packaging	Amperage Range/Position	Description	Typical Deposit Characteristics	Typical Applications
11356000	\$63.25	1/8" x 14"	10lb. Vac	90 - 130 Flat / Horiz	A solid core hardfacing electrode with easy slag removal. It has a moderate alloy content, providing a balanced performance on abrasion resistance and impact. It has an extruded coating containing the alloying elements. Deposits are not machinable or forgeable. Stooddy 19 bonds well with carbon, low alloy, and manganese steels. Deposits are slightly magnetic on carbon and low alloy steels, but not on manganese steels, and will develop crosschecks. A severe water quench should be avoided.	Abrasion Resistance: Good Impact Resistance: .. Moderate Hardness w/2 Layers Deposited on 1045 Steel:HRC 51 - 55 Manganese Steel: HRC 45 - 49 Deposit Layers: Up to 2 Surface Cross Checks: Yes Machinability: No Magnetic: Slightly	<ul style="list-style-type: none"> Crusher Rolls Impact Breaker Bars Dredge Pump Shells and Impellers Scrapers
11356000-1	\$11.95	1/8" x 14"	1lb.	90 - 130 Flat / Horiz			
11356700	\$58.89	5/32" x 14"	10lb. Vac	120 - 160 Flat			
11356700-1	\$10.90	5/32" x 14"	1lb.	120 - 160 Flat			
11356800	\$53.10	3/16" x 14"	10lb. Vac	140 - 220 Flat			
11173100	\$61.00	1/4" x 18"	10lb. Vac.	175 - 300 Flat			
Hard Surfacing & Impact Of Carbon & Alloy Steel, AC or DC+							

21 Eutectic Chromium Carbides in an Austenitic Matrix (23%) - Chromium, Carbon, Silicon, Manganese, Molybdenum

Part No	Price Per Pack	Size (dia) x (lgth)	Packaging	Amperage Range/Position	Description	Typical Deposit Characteristics	Typical Applications
11172700	\$71.67	1/8" x 14"	10lb.	90 - 130 Flat	A tubular electrode with good impact and abrasion characteristics. Deposits are not machinable or forgeable. Stooddy 21 bonds well with carbon, low alloy, and manganese steels. Deposits are slightly magnetic on carbon and low alloy steels, but not on manganese steels, and will develop cross checks. A severe water quench should be avoided.	Abrasion Resistance: Good Impact Resistance: .. Moderate Hardness w/2 Layers Deposited on 1045 Steel:HRC 46-50 Manganese Steel: ..HRC 52-56 Deposit Layers: Up to 2 Surface Cross Checks: Yes Machinability: No Magnetic: Slightly	<ul style="list-style-type: none"> Compactors Mill Hammers Buckets and Bucket Teeth Dredge Pumps
11172700-1	\$13.95	1/8" x 14"	1lb.	90 - 130 Flat			
11172900	\$64.45	5/32" x 14"	10lb.	120 - 160 Flat			
11172900-1	\$11.90	5/32" x 14"	1lb.	120 - 160 Flat			
11173000	\$63.20	3/16" x 14"	10lb.	140 - 220 Flat			
Hard Surfacing & Impact Of Cast Iron, Carbon & Alloy Steel, AC or DC+							

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