

STOODY® 31

Shielded Metal Arc Welding Electrode

Stoody 31 is the most general purpose hardfacing electrode in Stoody's product line. It offers an excellent balance of abrasion resistance and impact strength, making it very versatile. Stoody 31 is a tubular electrode with an extruded coating. Deposits have a low coefficient of friction and provide good resistance to corrosion and heat. The deposits are not machinable or forgeable. Weldability is excellent with slag coverage that is virtually self-removing. Stoody 31 can be applied to carbon, low alloy, and manganese steels.

TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Good
Impact Resistance	Moderate
Hardness, HRC	45 – 49
Magnetic:	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes
Machinable	No
Deposit Layers	2
Hot Wear Applications	Up to 950°F (510°C)

ALLOY TYPE

Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

- Bucket arms
- Chain links
- Buckets
- Scrapers
- Rolling mill guides, pulleys
- Blades
- Hammers
- Crusher parts

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

1/8" (3.2 mm)	
Current, amp	100 – 120
Position	Flat / Horizontal
Length, in (mm)	14 (355)
5/32" (4.0 mm)	
Current, amp	120 – 180
Position	Flat
Length, in (mm)	14 (355)
3/16" (4.8 mm)	
Current, amp	170 – 240
Position	Flat
Length, in (mm)	14 (355)
1/4" (6.4 mm)	
Current, amp	250 – 325
Position	Flat
Length, in (mm)	14 (355)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2 mm)	10 lb (4.5 kg) Vacuum Pak	10206300
5/32" (4.0 mm)	10 lb (4.5 kg) Vacuum Pak	10206400
3/16" (4.8 mm)	10 lb (4.5 kg) Vacuum Pak	10206500
1/4" (6.4 mm)	10 lb (4.5 kg) Vacuum Pak	10206600

PDS-CRC-E-004
Revision 4
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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.

PROTECT YOURSELF AND OTHERS - Users should read and follow all recommended guidance on health and safety from their employer, the supplier, the manufacturer, and government authorities. These, at a minimum including the Warning Labels on the products and the Safety Data Sheets ("SDS"). The SDS and additional safety information may be found on materials or links at: Stoody.com.