

## STOODY® 121, 121-G, 121-O

### Open Arc/Gas Shielded Welding Wire

Stoody 121 deposit consists of uniformly distributed chromium carbides in a semi-austenitic matrix. It is recommended for applications involving severe abrasion and moderate impact. This product provides excellent service on a wide variety of heavy equipment and earth engaging tools. It typically has cross checking and not machinable. Stoody 121 can be applied to carbon, low alloy, and manganese steels. Deposits should be limited to two layers.

#### TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Hardness	
1 Layer, HRC	40 - 44
2 Layers, HRC	47 - 51
Deposit Layers	2
Magnetic:	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes

#### ALLOY TYPE

Chromium Carbides in a Semi-Austenitic Matrix

#### TYPICAL APPLICATIONS

- Scraper sides and cutters
- Pug mill paddles
- Vibratory ditcher shanks
- Augers
- Tamper tools

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

	121-G	121-O
Diameter, in (mm)	<b>0.045" (1.2 mm)</b>	<b>1/16" (1.6 mm)</b>
Current DCEP, amp	170 - 200	205 - 255
Voltage (volts)	22 - 26	24 - 28
Wire Extension, in (mm)	1/2 - 3/4 (13 - 19)	1/2 - 1 (13 - 25)
Shielding Gas	98/2 or 75/25	None
Position	Flat	Flat

	121	
Diameter, in (mm)	<b>3/32" (2.4 mm)</b>	<b>7/64" (2.8 mm)</b>
Current DCEP, amp	250 - 350	300 - 400
Voltage (volts)	24 - 28	24 - 28
Wire Extension, in (mm)	3/4 - 1 1/4 (19 - 32)	3/4 - 1 1/4 (19 - 32)
Shielding Gas	None	None
Position	Flat	Flat

#### STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
0.045" (1.2 mm)	33 lb (15 kg) Coil	11423200
0.045" (1.2 mm)	300 lb (136 kg) No Twist Drum	11996600
1/16" (1.6 mm)	33 lb (15 kg) Coil	11408300
1/16" (1.6 mm)	50 lb (22.7 kg) Poly Pak	11420600
1/16" (1.6 mm)	200 lb (90.7 kg) Half Pak	11997200
1/16" (1.6 mm)	300 lb (136 kg) No Twist Drum	11999300
3/32" (2.4 mm)	60 lb (27.2 kg) Coil	11086600
3/32" (2.4 mm)	200 lb (90.7 kg) Half Pak	11087700
7/64" (2.8 mm)	60 lb (27.2 kg) Coil	11000500
7/64" (2.8 mm)	110 lb (50 kg) Quarter Pak	11143700
7/64" (2.8 mm)	200 lb (90.7 kg) Half Pak	11864400

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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](http://Stoody.com).