

STOODY® 110, 110-G, 110-O, 110-MC

Open Arc Welding / Gas Metal Arc Welding Wire

Stoody 110 deposit is a modified chromium, high manganese steel used in the rebuilding of manganese steel parts subject to severe impact loading. This material offers good toughness and wear resistance, and is sometimes used as the final hardfacing layer in extreme impact situations. Deposits cannot be flame cut but are machinable with carbide tools, are non-magnetic, and are not recommended for cast iron. It can be used on carbon, low alloy, and manganese steels. It also offers cavitation resistance in fluid component applications. Stoody 110-G, 110-O, and 110-MC are metal cored wires, producing a very light slag covering, causing no interference in multi-layer welding.

TYPICAL DEPOSIT CHARACTERISTICS

Tensile Strength, Ksi (MPa)	119 (820)
Yield Strength, Ksi (MPa)	76 (524)
Elongation in 2", %	40
Hardness	
- As Deposited, HRC	17
- Work Hardened, HRC	55
Abrasion Resistance	Moderate
Impact Toughness	Good
Cavitation Resistance	Good
Surface Cross Checks	No
Machinable	Yes
Deposit Layers	Multiple

ALLOY TYPE

Austenitic Manganese Steel

TYPICAL APPLICATIONS

- Drive tumblers
- Turbine cones
- Manganese frogs
- Shovel pads
- Wobbler feeders
- Crusher rolls
- Fluid components

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

110-G

0.045" (1.2 mm)	
Current DCEP, amp	135 – 185
Voltage (volts)	18 – 24
Position	Flat
Wire Extension, in (mm)	1/2" – 3/4" (13 – 19)
Shielding Gas	98% Ar/2% O ₂

110-O

1/16" (1.6 mm)	
Current DCEP, amp	150 – 210
Voltage (volts)	22 – 26
Position	Flat
Wire Extension, in (mm)	1/2" – 1" (13 – 25)
Shielding Gas	None or CO ₂

5/64" (2.0 mm)

Current DCEP, amp	200 – 275
Voltage (volts)	24 – 26
Position	Flat
Wire Extension, in (mm)	1" – 1 1/4" (25 – 31)
Shielding Gas	None

110

3/32" (2.4 mm)	
Current DCEP, amp	225 – 300
Voltage (volts)	23 – 27
Position	Flat
Wire Extension, in (mm)	1" – 1 1/2" (25 – 38)
Shielding Gas	None

110, 110-MC

7/64" (2.8 mm)	
Current DCEP, amp	275 – 375
Voltage (volts)	23 – 27
Position	Flat
Wire Extension, in (mm)	1" – 1 1/2" (25 – 38)
Shielding Gas	None

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
0.045" (1.2 mm)	33 lb (15 kg) Wire Basket	11452600
1/16" (1.6 mm)	33 lb (15 kg) Wire Basket	11424400
1/16" (1.6 mm)	50 lb (22.7 kg) Poly Pak	11345000
5/64" (2.0 mm)	33 lb (15 kg) Wire Basket	11994200
3/32" (2.4 mm)	60 lb (27.2 kg) Coil	11214400
7/64" (2.8 mm)	50 lb (22.7 kg) Poly Pak	11985200
7/64" (2.8 mm)	60 lb (27.2 kg) Coil	11000300
7/64" (2.8 mm)	110 lb (50 kg) Quarter Pak	11143400
7/64" (2.8 mm)	200 lb (90.7 kg) Half Pak	11140900
7/64" (2.8 mm)	110-MC, 60 lb (27.2 kg) Coil	11836900
7/64" (2.8 mm)	110-MC, 110 lb (50 kg) Qtr Pak	11836800
7/64" (2.8 mm)	110-MC, 500 lb (226.7 kg) POP	11965000

PDS-MN-W-004
Revision 3
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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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