

STOODY® 2134

Shielded Metal Arc Welding Electrode

Stoody 2134 exhibits excellent abrasion resistance in fine, sandy soils and bonds well with carbon, low alloy, and manganese steels. It is a tubular electrode containing granular alloying elements. The coating is graphitic. Surface checks which occur relieve stress and reduce warpage. Deposits are not machinable or forgeable. Stoody 2134 can be used in hot wear applications up to 950°F (510°C).

TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Hardness:	
- On Carbon Steel (as welded 2 layers weave bead on 1045 plate), HRC	56 – 60
- On Manganese Steel (quenched from 1750°F (954°C), HRC	63 – 65
- On Manganese Steel	45 – 50
Magnetic:	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	2
Hot Wear Applications	Up to 950°F (510°C)

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

- Crusher rolls
- Bucket teeth
- Mill hammers
- Impactor bars (final pass)

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

1/8" (3.2 mm)	
Current, amp	100 – 150
Position	Flat
Length, in (mm)	14 (355)
5/32" (4.0 mm)	
Current, amp	110 – 170
Position	Flat
Length, in (mm)	14 (355)
3/16" (4.8 mm)	
Current, amp	150 – 210
Position	Flat
Length, in (mm)	14 (355)
1/4" (6.4 mm)	
Current, amp	180 – 300
Position	Flat
Length, in (mm)	14 (355)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2 mm)	10 lb (4.5 kg) Box	11276700
5/32" (4.0 mm)	10 lb (4.5 kg) Box	11276800
5/32" (4.0 mm)	60 lb (27.2 kg) Bulk Pak	10208300
3/16" (4.8 mm)	10 lb (4.5 kg) Box	11276700
3/16" (4.8 mm)	60 lb (27.2 kg) Bulk Pak	10208400
1/4" (6.4 mm)	60 lb (27.2 kg) Bulk Pak	10208500

PDS-CRC-E-010

Revision 4

November 13, 2015

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.