

STOODY® 35

Shielded Metal Arc Welding Electrode

Primary applications for Stooddy 35 involve severe abrasion with moderate to heavy impact. It is normally used for earth-to-metal wear or wear due to abrasion of other particulate material. Stooddy 35 is a solid core electrode with a heavy extruded coating that contains the alloying elements. The 1/8" size can be applied out of position. Deposits are uniform with excellent bead appearance and slag removal. Stooddy 35 bonds readily to carbon, low alloy, and manganese steel. It develops surface checks and is not machinable or forgeable. Compressive strength is very high.

TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Compressive Strength	Very High
Hardness:	
- On Carbon Steel, HRC	53 – 57
- On Manganese Steel, HRC	50 – 53
- Deposits May Work Harden to, HRC	58 – 60
Magnetic:	
On Carbon Steel	Slightly
On Manganese Steel	No
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	2

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

1/8" (3.2 mm)	
Current, amp	125 – 175
Position	Flat or Horizontal
Length, in (mm)	14 (355)
5/32" (4.0 mm)	
Current, amp	175 – 250
Position	Flat
Length, in (mm)	14 (355)
3/16" (4.8 mm)	
Current, amp	225 – 300
Position	Flat
Length, in (mm)	14 (355)
1/4" (6.4 mm)	
Current, amp	275 – 350
Position	Flat
Length, in (mm)	18 (457)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2 mm)	10 lb (4.5 kg) Vacuum Pak	11322900
5/32" (4.0 mm)	10 lb (4.5 kg) Vacuum Pak	11318200
3/16" (4.8 mm)	10 lb (4.5 kg) Vacuum Pak	11318300
1/4" (6.4 mm)	10 lb (4.5 kg) Vacuum Pak	11318400

ALLOY TYPE

Primary Chromium Carbides in an Austenitic Matrix

TYPICAL APPLICATIONS

- Bucket teeth
- Augers and screws (earth gouging)
- Crushing equipment
- Tile mixer paddles
- Mill hammers

PDS-CRC-E-011
Revision 2
January 5, 2016

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 Stooddy products are used in accordance with internal Stooddy procedures. Other tests and procedures may produce differing results. Stooddy 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: Stooddy.com.