

## STOODY® BUILD-UP LH Shielded Metal Arc Welding Electrode

Stoody Build-Up LH deposit is a low alloy steel designed for low severity metal-to-metal wear. The electrode has a special low hydrogen coating which provides a high strength fusion bond on carbon and low alloy steels. As a base alloy for hardsurfacing overlays or for restoring parts to original dimensions, it provides a weld deposit with excellent compressive strength capable of absorbing heavy impact and/or compressive loads. It can be applied in multiple layers without cracking, spalling, or mushrooming. It is machinable in the as-welded condition with reasonable procedural care and can be forged at red heat. It is not recommended for manganese steel or cast iron and does not work harden. It should not be used for joining.

### TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Low
Impact Resistance	Good
Hardness on Carbon Steel	
1 Layer, HRC	27
2 Layers, HRC	29
3 Layers, HRC	31
Tensile Strength, ksi (MPa)	118 (815)
Yield Strength, ksi (MPa)	113 (780)
Elongation %	6
Deposit Layers	Unlimited

### ALLOY TYPE

Low Alloy Steel

### TYPICAL APPLICATIONS

- Tractor rollers
- Tractor and shovel idlers
- Machine shafts
- Clevis pins
- Steel shovel pads
- Gear teeth
- Sprockets

### OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

<b>1/8" (3.2 mm)</b>	
Current, amp	100 – 185
Position	All
Length, in (mm)	14 (355)
<b>5/32" (4.0 mm)</b>	
Current DCEP, amp	140 – 250
Position	All
Length, in (mm)	14 (355)
<b>3/16" (4.8 mm)</b>	
Current DCEP, amp	180 – 310
Position	All
Length, in (mm)	14 (355)
<b>1/4" (6.4 mm)</b>	
Current DCEP, amp	200 – 360
Position	All
Length, in (mm)	18 (455)

### STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2 mm)	10 lb (4.5 kg) Vacuum Pak	11414100
5/32" (4.0 mm)	10 lb (4.5 kg) Vacuum Pak	11412900
3/16" (4.8 mm)	10 lb (4.5 kg) Vacuum Pak	11413000
1/4" (6.4 mm)	10 lb (4.5 kg) Vacuum Pak	11413100

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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).