

STOODY® 102-G Gas Metal Arc Welding Wire

Stoody 102-G deposit has a composition and physical properties that are similar to those of H-12 tool steel. Weldability is very good and the wire can be applied out-of-position. Stoody 102-G requires carbide tools for machining. It is good for hot wear applications up to 1100°F. Multiple layers can be applied without difficulty when proper preheat and interpass temperatures are maintained.

TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Good
Impact Resistance	Moderate
Compressive Strength	Good
Harness on 0.2% Carbon Steel	HRC 48 - 53
Deposit Layers	Multiple
Magnetic	Yes
Surface Cross Checks	No
Machinability	Using Carbide Tools
Hot Wear Applications	Up to 1100°F

ALLOY TYPE

H-12 Tool Steel

TYPICAL APPLICATIONS

- Cable sheaves
- Forging dies
- Crane wheels
- Hot and cold shear blades
- Hot work extrusion rolls

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

0.045" (1.2 mm)

Current DCEP, amp	135 – 185
Voltage (volts)	18 – 24
Position	Flat & Horizontal
Shielding Gas	98% Ar - 2% O ₂
Wire Extension, in (mm)	1/2" - 3/4" (12 - 19)

1/16" (1.6 mm)

Current DCEP, amp	225 – 275
Voltage (volts)	25 – 27
Position	Flat & Horizontal
Shielding Gas	98% Ar - 2% O ₂
Wire Extension, in (mm)	1/2" - 1" (12 - 25)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
0.045" (1.2 mm)	10 lb (4.53 kg) Plastic Spool	11422400
0.045" (1.2 mm)	33 lb (15 kg) Wire Basket	11422300
1/16" (1.6 mm)	50 lb (22.68 kg) Poly Pak	11422000

PDS-CS-W-009
Revision 1
July 17, 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.

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