

STOODY® 965-G, 965-O

Open Arc/Gas Metal Arc Welding Wire

Stoody 965 deposit is a general purpose hardfacing alloy that offers a good balance of impact and abrasion resistance. It can be used in both metal-to-metal and metal-to-earth applications. Deposits are martensitic and forgeable but not readily machinable. It can be applied to carbon, low alloy, and manganese steels. It is magnetic on carbon and low alloy steels. Analysis and properties are similar to Stoody Self Hardening covered electrode.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Good
Hardness on 0.2 Carbon Steel, HRC	56 - 60
Deposit Layers	2
Magnetic:	
On Low Alloy and Carbon Steel	Yes
On Manganese Steel	No
Surface Cross Checks	No

ALLOY TYPE

Martensitic Tool Steel

TYPICAL APPLICATIONS

- Tillage tools
- Drag line bucket lips
- Tamper feet
- Dredge parts
- Extruder screws
- Muller tires

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

	965-G	
	0.035" (0.9 mm)	0.045" (1.2 mm)
Diameter, in (mm)	0.035" (0.9 mm)	0.045" (1.2 mm)
Current DCEP, amp	80 - 130	150 - 200
Voltage (volts)	15 - 20	25 - 29
Wire Extension, in (mm)	1/2 - 5/8 (13 - 16)	1/2 - 3/4 (13 - 19)
Shielding Gas	75/25, CO ₂ , or 98/2	98/2 or 75/25
Position	All	Flat or Horizontal

	965-G	965-O
Diameter, in (mm)	1/16" (1.6 mm)	1/16" (1.6 mm)
Current DCEP, amp	200 - 250	200 - 250
Voltage (volts)	27 - 31	27 - 31
Wire Extension, in (mm)	3/4 - 1 (19 - 25)	3/4 - 1 1/4 (13 - 32)
Shielding Gas	98/2 or 75/25	None or CO ₂
Position	Flat or Horizontal	Flat or Horizontal

	965-O	
	3/32" (2.4 mm)	7/64" (2.8 mm)
Diameter, in (mm)	3/32" (2.4 mm)	7/64" (2.8 mm)
Current DCEP, amp	300 - 350	425 - 475
Voltage (volts)	25 - 28	28 - 30
Wire Extension, in (mm)	1 1/4 - 1 1/2 (32 - 38)	1 1/4 - 1 1/2 (32 - 38)
Shielding Gas	None or CO ₂	None or CO ₂
Position	Flat or Horizontal	Flat or Horizontal

STANDARD SIZES & PACKAGING

965-G		
Diameter	Packaging	Part #
0.035" (0.9 mm)	5 lb (2.3 kg) Plastic Spool	11929300
0.035" (0.9 mm)	25 lb (11.3 kg) Plastic Spool	11933300
0.045" (1.2 mm)	10 lb (4.5 kg) Plastic Spool	11423000
0.045" (1.2 mm)	33 lb (15 kg) Coil	11423100
1/16" (1.6 mm)	33 lb (15 kg) Coil	11501500
1/16" (1.6 mm)	50 lb (22.7 kg) Poly Pak	11823900
1/16" (1.6 mm)	200 lb (90.7 kg) Half Pak	11864500
1/16" (1.6 mm)	200 lb (90.7 kg) No Twist Drum	11933500
1/16" (1.6 mm)	400 lb (181.4 kg) No Twist Drum	11875500

965-O		
Diameter	Packaging	Part #
1/16" (1.6 mm)	33 lb (15 kg) Coil	11427100
1/16" (1.6 mm)	50 lb (22.7 kg) Poly Pak	11427000
1/16" (1.6 mm)	200 lb (90.7 kg) Half Pak	11956000
1/16" (1.6 mm)	500 lb (226.8 kg) POP	11956100
3/32" (2.4 mm)	60 lb (27.2 kg) Coil	11946100
7/64" (2.8 mm)	60 lb (27.2 kg) Coil	11987200

PDS-CRC-W-001
Revision 4
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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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