

## Stoody XHC

Stoody XHC combines excellent weldability with a high deposition rate. It is a solid core electrode with an extruded graphitic coating containing the alloying elements. Deposits are highly resistant to both sliding and grinding abrasion, but they are not machinable or forgeable. Stoody XHC retains good wear resistance up to 1000°F (538°C) and it bonds well with carbon, low alloy, and manganese steels.

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Primary Chromium Carbides in an Austenitic Matrix

Typical Weld Metal Analysis %				
C	Mn	Si	Cr	Mo
5.4	2.4	1.3	24.0	0.5

Deposition Data		
Diameter	Current	Deposition Type
3.2 mm ( 1/8 in. )	100-150 A	Full Range
4.0 mm ( 5/32 in. )	125-250 A	Full Range
4.8 mm ( 3/16 in. )	150-300 A	Full Range