

Stoody 160FC deposit consists of tungsten carbide particles in a nickel silicon boron matrix. Due to higher tungsten carbide content, Stoody 160FC is an ideal hardfacing overlay with a microstructure that delivers superior toughness and resistance to corrosion and fine particle erosion in slurry type applications. It also provides improved weldability through enhanced wetting, tie-in and arc stability.

Typical Deposit Characteristics

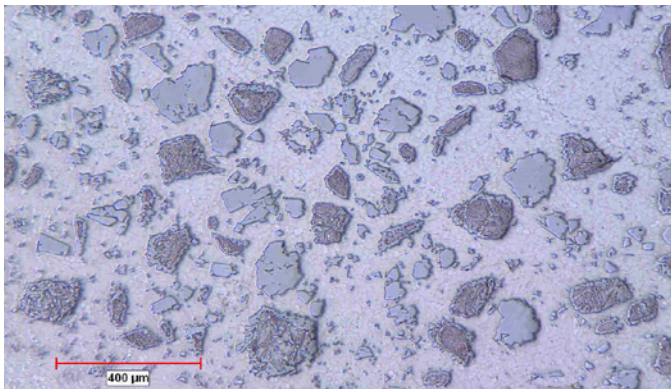
Abrasion Resistance	Excellent
Matrix Hardness Single Layer, HRC	38 – 45
Matrix Hardness Two Layer, HRC	40 – 50
Deposit Layers	2 Maximum
Surface Cross Check	Depends on application
Machinability	No

Typical Applications

- Dredge rotary cutter heads
- Drill bits & stabilizers
- Pipe ID & filtering screens
- Hardbanding (Open-Hole)

Standard Sizes & Packaging

Diameter	Packaging	Part #
1/16" (1.6 mm)	33 lb (15 kg) WB	12022500



Microstructure 50x - Tungsten Carbides in a Nickel-Silicon-Boron Matrix.

* Microstructures are parameter sensitive. Use lowest possible heat input.

Operational Characteristics/Welding Parameters*

GMAW

Diameter, in (mm)	1/16 (1.6)
Current, Amp DCEP	130 – 200
Voltage	16 – 18
Shielding Gas	75 – 80% Ar, Bal. CO ₂
Wire Extension, in (mm)	1/2 – 5/8 (12 – 16)
WFS, in/min (m/min)	110 – 170 (2.8 – 4.3)
Welding Position(s)	



AWS: 1G
EN: PA

GMAW

Diameter, in (mm)	3/32 (1.6)
Current, Amp DCEP	130 – 200
Voltage	16 – 18
Shielding Gas	75 – 80% Ar, Bal. CO ₂
Wire Extension, in (mm)	1/2 – 5/8 (12 – 16)
WFS, in/min (m/min)	110 – 170 (2.8 – 4.3)
Welding Position(s)	



AWS: 1G
EN: PA

DIN EN 14700: TNi20 DIN 8555: MF 21.55.CG ISO/TR 13393: T-H-W-Ni

PDS-WC-W-008
Revision 3
October 30, 2014

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.