

# STOODY® 155FC

## Gas Metal Arc Welding Wire

Stoody® 155FC deposit consists of tungsten carbide particles in a nickel silicon boron matrix. This microstructure gives Stoody 155FC significant abrasion resistance as well as superior toughness and corrosion resistance. Stoody 155FC provides improved weldability through enhanced wetting, tie-in and arc stability. Stoody 155FC is well suited for build up and buffer layers when thicker weld deposits are desired and is the ideal underlay for the higher tungsten carbide content of Stoody 160FC.

### Typical Deposit Characteristics

Abrasion Resistance	Excellent
Matrix Hardness Single Layer	35 - 45 HRC
Matrix Hardness Two Layer	35 - 45 HRC
Deposit Layers	2 Maximum
Surface Cross Check	No
Machinability	No
Grinding	Diamond

### Typical Applications

Typical applications include:

- Process screw flight edges
- Drill bits & stabilizers build-up
- Hardbanding (Open-Hole)

### Standard Sizes & Packaging

Diameter	Packaging	Part #
1/16" (1.6 mm)	33# Wire Basket	12022600

PDS-WC-W-009  
Revision 0  
October 23, 2013

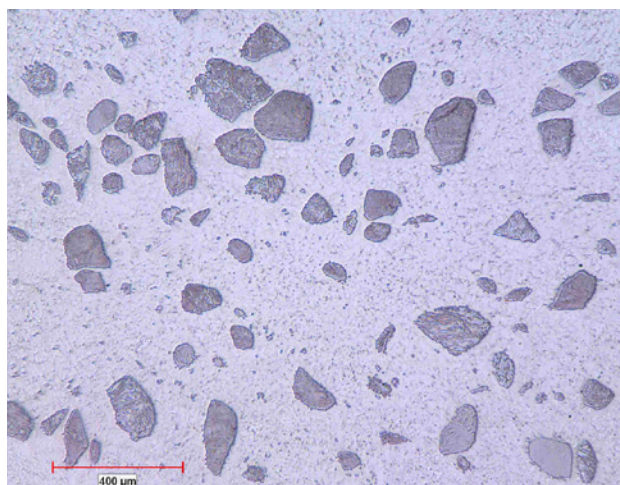
NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products 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 Material Safety Data Sheets ("MSDS"). The MSDS and additional safety information may be found on materials or links at: [www.stoody.com](http://www.stoody.com).

### Operational Characteristics/ Welding Parameters\*

<b>GMAW</b>	
Diameter, in (mm)	<b>1/16 (1.6 mm)</b>
Current, Amp DCEP	130 - 225
Voltage	16 - 18
Shielding Gas	75% Ar / 25% CO <sub>2</sub>
Wire Extension, in (mm)	1/2" - 5/8" (12 mm - 16 mm)
WFS, in/min	110 - 170
(m/min)	(2.8 - 4.3)
Position	Flat / Vertical Up

\* Microstructures are parameter sensitive.  
Use Lowest possible heat input.



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



INNOVATION TO SHAPE THE WORLD™

U.S. Customer Care: 800-426-1888 • Canada Customer Care: 905-827-4515 • International Customer Care: 940-381-1212