

HOT PROCESS METAL SPRAY / POWDER

*** STOODY**

“The Leader in Hardfacing”™



The manual power torch enables the operator to apply build-up or hardfacing alloys to extend the life of common tools. Through the simple application of general Oxy-Acetylene Surfacing practices, smooth dense coatings can be achieved. Power applications and fusion are incorporated in one easy operation. The powder flow rate and movement of the torch controls the thickness.

Designed to mate with your existing oxy-Acetylene source equipment, the manual powder torch comes complete with torch handle, elbow assembly, 3 different size heating tips, a 1 lb. bottle of each of the most commonly used build-up and hardfacing powders and a “how to” video. Additional powders are available for more demanding applications where greater surface hardness is required. Choose a Rockwell hardness from RC 19 to RC 64.

The simple, maintenance free design makes the manual powder torch easy to set up even easier to use. Operation is so easy, even a novice welder can repair broken cast iron parts, apply wear resistant coatings to thin parts, or replace metal worn by erosion or abrasion all with superior metallurgical bonds.

JS-100 JET-SPRAY TORCH
for the application of powdered metal.

JS-100 Jet Spray Torch Kit

Part No. 122-11-100 \$324.60 Ea

Includes:

QTY DESCRIPTION

- 1 Torch Handle (100 Series)
- 1 Powder Hopper Assembly
- 1 Elbow Assembly
- 3 Heating Tips
(#3 TE, #4 TE, #6 TEMF)
- 1 1 lb. Bottle of Stoody 63 T. G.
(Build-Up Powder)
- 1 1 lb. Bottle of Stoody 85 T. G.
(Wear Prevention Powder)
- 1 “How to” Video

TORCH GRADE SPRAY POWER SELECTION

Stoody’s torch grade spray powders are specifically designed for enhanced wetting characteristics in hand-held torch applications.

STOODY 60 T.G. 5lb Bottle #11020500 \$212.50 Ea

A nickel-base alloy with outstanding resistance to abrasion, corrosion and high heat: impact resistance is good. Low coefficient of friction, Used for pump components, shaft sleeves, thrust collars, guides, bushings. Finish by grinding.

C	SI	Cr	B	WC	Fe	Ni	Normal Hardness
.7	4.4	15.0	3.1	-	4.2	Bal.	59 Rc

STOODY 63 T.G. 1lb Bottle #11174500 \$48.50 Ea
5lb Bottle #11020600 \$212.50 Ea

A nickel-base alloy with high ductility and workability. Deposits can be hand ground. Used primarily in the glass industry to protect mold rebuilding against abrasion, heat and corrosion. Can be used for joining cast iron

C	SI	Cr	B	WC	Fe	Ni	Normal Hardness
.02	2.8	-	1.6	-	.4	Bal.	19 Rc

STOODY 64 T.G. 5lb Bottle #11020700 \$212.50 Ea

A nickel-base alloy recommended for application to parts requiring precise finish machining. Can also be ground. Deposits provide excellent corrosion and heat resistance: very good impact resistance. Used on pump parts, shafts, valves, dies.

C	SI	Cr	B	WC	Fe	Ni	Normal Hardness
.03	3.5	8.8	1.8	-	2.8	Bal.	39 Rc

Spray Powder Application

1. **Surface Preparation:** The surface to be sprayed should be degreased and free of oxides and other contaminants. Rough blast or grind to clean white metal for best results.
2. **Preheat & Pre-spray:** Evenly preheat part to 600°F to 800°F (Steel at this temperature turns from blue to white metal when the flame is wiped across the surface). Pre-spray a thin layer of powder over the entire surface to be coated.
3. **Fusion:** Starting at one end of the pre-sprayed part, continue to preheat until surface temperature is approximately 1900°F or until the pre-sprayed powder becomes molten, at which time it is ready for complete fusion. Begin power spray to evenly coat the part. If a thicker coating is required, evenly spray additional powder to the desired thickness.
4. **Standard Mesh Size:** All powders are 140 x 400 except for 65 T.G. (which is 140 x 325).

* Stoody Industrial & Welding Supply, Inc. (SIWS) is not sponsored, affiliated or in any way related to “STOODY COMPANY”, a division of THERMADYNE INDUSTRIES, INC.

These hardfacing powers cover a broad range of wear resistance needs

STOODY 65 T.G. 5lb Bottle #11020800 \$212.50 Ea

A Nickel-base alloy with greater ductility than Stoody 60. Deposits can be machined with carbide tools or ground. Used for for pump parts, dies, extrusion screws and wear rings.

C	SI	Cr	B	WC	Fe	Ni	Normal Hardness
.45	.0	11.9	2.1	-	3.5	Bal.	51 Rc

STOODY 85 T.G. 1lb Bottle #11302100 \$58.50 Ea
5lb Bottle #11020900 \$265.75 Ea

A nickel-base tungsten carbide powder. Micro-structures exhibit dense deposits of undissolved tungsten carbides embedded in high strength matrix. This material provides excellent wear resistance and is ideal for such applications as tillage tools, small mill hammers, bits, and augers, etc. Stoody 85 T.g. is not recommended for metal to metal mating parts

C	SI	Cr	B	WC	Fe	Ni	Normal Hardness
2.2	2.5	8.3	1.7	43.0	2.6	Bal.	64 Rc Matrix

STOODY 87 T.G. 5lb Bottle #11334600 \$265.75 Ea

A nickel-base tungsten carbide powder. Micro-structures exhibit dense deposits of undissolved tungsten carbides embedded in high strength matrix. Similar to 85 T.G. but has a maximum amount of tungsten to provide the ultimate in wear resistance. Not recommended for metal to metal wear.

C	SI	Cr	B	WC	Fe	Ni	Normal Hardness
2.8	1.7	5.3	1.1	61.7	1.8	Bal.	64 Rc Matrix