

Gas Shielded, Peripheral Continuous Electrode for Semi-Automatic  
and Automatic Robotic Welding

# EnDotec® DO\*11



## WIRE

- High density of cast tungsten carbide particles evenly distributed in a nickel matrix
- Extremely abrasion resistant even in corrosive media
- Higher deposition rates for reduced labor costs
- More versatile welding parameters than the competition



## DESCRIPTION:

Exclusive, gas shielded, metal cored alloy wire ideal for maintenance and repair applications or batch manufacturing where the highest integrity welding, efficiency and productivity are required.

The slag-free deposit features a high density of Cast Tungsten Carbide particles evenly distributed in a nickel matrix. This gives exceptional resistance to abrasive and erosive particles with moderate impact and is specifically for applications in hot or corrosive environments.

## TECHNICAL DATA:

Typical Matrix Hardness: 55 HRC  
Micro Hardness of Carbide: 2200 HV  
Machinability: Grind Only  
Shielding Gas: 98% Ar / 2%O<sub>2</sub>  
Diameter of Wire: 1/16" (1.6mm)  
Polarity: DCEP(+)  
Weight: 33 Lb Spool  
G65 20.5 mm<sup>3</sup> Volume Loss

## TYPICAL WELDING PARAMETERS

1/16" (1.6MM)	TRANSFER	VOLTAGE	AMPERAGE	STICK-OUT	GAS FLOW
Typical	Short-Arc	18 - 22	140 MAX	½" - ¾"	25-35 SCFH
Optimum	Short-Arc	20	110-120	½" - ¾"	30 SCFH

## PROCEDURE FOR USE:

Remove old welding deposits and worn metal with ChamferTrode. Degrease and remove all contaminant's. Pre-heating temperatures are determined by base metal. Push or pull the electrode at an angle of 70-80° to ensure optimal fusion. If required, a second pass should only be deposited while the weld is still hot.

## TYPICAL APPLICATIONS

Designed for anti-wear coatings on carbon steel, alloy steels, stainless steels and nickel alloys.

Typical industries include agriculture, food and beverage, oil drilling operations, pulp and paper and chemical processing.

- High speed fan blades
- Ash handling systems
- Brick and tile extruders
- Sintering parts
- Slag breakers
- Screw conveyers
- Press rolls
- Mixers & paddles
- Stabilizers
- Transfer chutes

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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