High Performance Seamless Cored Wire for Maintenance & Repair

EnDOtec® DO *310

WIRE

An Ultimate Welding Solution For Hardfacing Applications

- Good resistance to compression and plastic deformation
- Multi-pass deposit capability
- Readily machinable
- Regular bead profile, virtually spatter free
- Versatile usage over wide parameter range

Castolin Eutectic®
Eutectic Castolin

DESCRIPTION:

Seamless, gas shielded, metal cored alloy wire, ideal for batch manufacturing or maintenance and repair applications where highest integrity welding, efficiency and productivity are re-quired.

General purpose, low alloy Cr-C-Mn-Fe weld deposits for thick multipass deposition without cracks. Ideal for rebuilding worn cast steel sections, medium carbon steel parts and buttering layers for wearfacing applications.

TECHNICAL DATA:

Typical Hardness: 38 HRC
Power Source: Constant voltage & integrated wire drive
Current & Polarity: = (+) positive polarity
Shielding Gas: 1) 90% Ar + 10% CO_2
2) 75% Ar + 25% CO_2
Shielding Gas Flow Rate: 30-40 SCFH (16 l/min).
Positions: Flat, Horizontal and Horizontal Vertical

TYPICAL WELDING PARAMETERS:

DIAMETER	AMPS	VOLTS
0.045" (1.2 mm)	100-320	16-35
1/16" (1.6mm)	130-420	19-38

APPLICATIONS:

Designed specifically to provide protective coating against wear caused by adhesion (metal-metal friction), pressure and impact.

- Chain Sprockets
- Guide Rolls
- Pulleys
- Worn Parts on Bulldozers,
- Rebuilding of large, severely worn steel castings

PROCEDURE FOR USE:

EQUIPMENT
EnDOtec continuous electrodes are compatible with most conventional, constant voltage power sources. A 4-roll drive assembly with smooth V- or U-grooves is recommended for maintaining arc voltage stability and consistent, smooth wire feeding.

PREPARATION
Remove old welding deposits and worn metal completely with ChamferTrode®.

PREHEATING
Preheating depends on the steel's carbon equivalent and the workpiece size, thickness and geometry. Eutectic recommends...
CE<0.2: Preheat not necessary
CE 0.2-0.4: Preheat 210° - 390°F (100-200°C)
CE 0.4-0.8: Preheat 390° - 660°F (200-350°C)
NOTE that 12-14% Mn steels should never be preheated and the workpiece temperature during welding should be kept below 480°F (250°C).

WELDING TECHNIQUE
For multi-pass, downhand coating push the electrode down the workpiece at an angle of 70/80° to ensure optimum fusion.

FINISHING
The deposit is machinable by normal cutting tools. Grinding, arc, oxyacetylene or plasma cutting equipment may also be used.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS

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