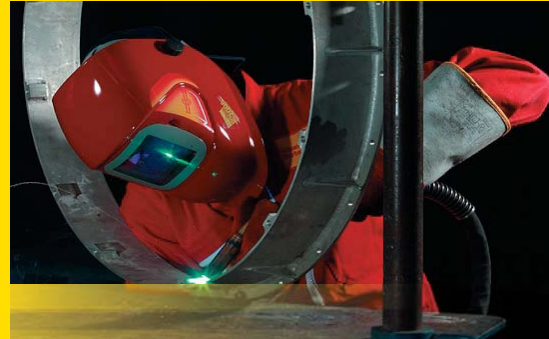


Premium Metal Cored, Gas Shielded, Wire for Cladding Cast Iron

# EnD0tec® D0\*325



## WIRE

- For the build-up and protection of most weldable cast irons
- Crack-free weld deposits
- Tolerant of thermal cycle stresses



## DESCRIPTION:

EnDOTec DO\*325 is designed for build-up of a wide range of cast iron. This gas shielded, metal cored alloy wire is ideal for maintenance and repair applications or batch manufacturing where the highest integrity welding, efficiency and productivity are required.

Deposits provide an excellent mechanical property match on a wide range of cast irons. Weld deposits are also highly tolerant of the expansion and contraction stresses caused by the heat of welding. EnDOTec DO\*325 is formulated to be a crack-free, anti-wear protective coating on cast irons.

## TECHNICAL DATA:

Typical Hardness 2 Passes: HRC 35-39  
Power Source Type: Constant voltage & Integrated Wire Drive  
Current & Polarity: DC (+) electrode positive  
Shielding Gas: Argon 98% + 2% Oxygen

## TYPICAL ANTI-WEAR APPLICATIONS & INDUSTRIES:

### APPLICATIONS

Cast Iron Rolls  
Machine Bases  
Pump Housings - Nash Pumps  
Gear Boxes  
Dies - Closed Impression Dies  
Cast Iron Foundry Defects

### INDUSTRY

Cement Works  
Iron and Steel Works  
Pulp and Paper  
Open Cast Mining  
Automotive  
Foundry

## WELDING PARAMETERS

1/16" (1.6MM)	VOLTAGE	AMPERAGE	STICK-OUT	GAS FLOW
Spray Arc	25-30	200-275 (Large parts)	5/8" ± 1/8" (Short nozzle)	30-45 scfh
Short Arc	23-26	100-200 (Lighter parts)	9/16" ± 1/8" (Long nozzle)	30-45 scfh

*Note: Parameter adjustments will be needed depending on the size, weight, and shape of the part to be welded. For optimum wear resistance keep to the low end of the amperage & voltage ranges.*

## PROCEDURE FOR USE:

**Caution:** Although a 2-roll wire drive assembly will work the optimum for maintaining arc voltage stability and consistent and smooth wire feeding is a serrated 4-roll drive assembly. Smooth drive rolls are not recommended!

Step 1: Remove all "old" cracked or spalled weld metal down to a sound base.

Step 2: EnDOTec DO\*325 can be used for build-up.

Step 3: With difficult-to-weld base metals and complex work-pieces, slight preheating to about 400°F (200°C) or higher will minimize the risk of cracking in the transition zone. Slow cool following welding.

**Note:** If welding is interrupted and the part being welded cools to room temperature, make sure to reheat to the original preheat temperature. Slow cooling is advised using silicone blankets, vermiculite, or other environmentally suitable heat-retardant material.

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