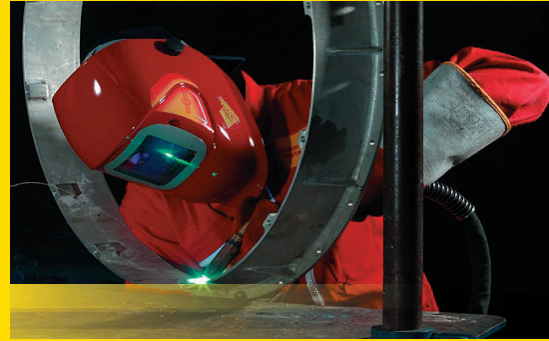


Seamless, Metal Cored, Gas-Shielded, Hardfacing Wire

EnD0tec® D0*358



WIRES

- Maximum hardness (58 HRC) deposit, without cross-checking
- Excellent resistance against abrasion combined with impact and pressure
- Forgeable deposit can be heat treated or nitrided
- Superior wire feeding characteristics and low contact tip wear
- Especially suited for automated welding
- Out-of-position capability



DESCRIPTION:

Eutectic's EnDOTec DO*358 is a seamless, metal cored, general purpose, hardfacing wire designed to resist wear in applications involving a combination of abrasion, impact, and pressure. The wire exhibits excellent weldability and deposition efficiency compared to solid wires. The weld deposits do not exhibit cross-checking.

The advantages of seamless-cored wires are reduced contact tip wear, constant wire-positioning accuracy, reduced wire feeding force, and no moisture pick-up.

TYPICAL APPLICATIONS

- Cutting tools
- Bucket teeth
- Agricultural equipment
- Construction equipment
- Conveyor screws
- Grizzly bars
- Cable drums
- Knife rotors

TECHNICAL DATA:

Typical Hardness: 58 HRC

Power Source: Constant voltage & integrated wire drive

Current & Polarity: DC (+) electrode positive

Shielding Gas Options:

1st Choice) 90% Argon + 10% Carbon Dioxide

2nd Choice) 98% Argon + 2% Oxygen

3rd Choice) 75% Argon + 25% Carbon Dioxide

Shielding Gas Flow Rate: 30-40 SCFH (14-19 l/min.)

Positions: Horizontal and Vertical Down*

*Please contact Technical Services for optimum out-of-position parameters.

TYPICAL WELDING PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE
0.045"	20-32	120-300
1/16"	22-34	180-400

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.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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