

High Performance Seamless Cored Wire for Abrasion Resistance

# EnDotec® DO\*361



## WIRE

*An Ultimate Welding Solution For Hardfacing Applications*

- Maximum arc stability & metal transfer
- Increased current density for faster weld deposition rates
- Superior weld metal recovery to 98%
- Cu coated wire for smooth feeding without lubricants
- Improved service life of torch contact tips



## DESCRIPTION:

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

The Cr-C-Fe rich alloy deposit is characterized by a high concentration of hard Cr carbides integrated within a tough austenitic matrix for good service performance up to 932° F (500°C). The smooth, slag free, rust resistant welds provide excellent wear resistance to high abrasion combined with moderate impact.

## TECHNICAL DATA:

Typical Hardness: approx 61 HRC as welded  
Power Source: Constant voltage & integrated wire drive  
Current & Polarity: = (+) positive polarity  
Shielding Gas: Argon + 5% - 25% CO<sub>2</sub>  
Shielding Gas Flow Rate: 30-40 SCFH 16-18 l/min.  
Positions: Flat and Horizontal

## TYPICAL WELDING PARAMETERS:

DIAMETER	AMPS	VOLTS
1/16" (1.6mm)	60-420	16-40

## APPLICATIONS:

Generally most machine parts subjected to abrasion combined with moderate impact and corrosion.

- Grinders
- Crushers
- Excavation Buckets
- Ripper Teeth
- Bulldozer Blades
- Scrapers

## 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 weld deposit is machinable by grinding. Arc or plasma cutting equipment may also be used.

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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