

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

# EnD0tec® D0\*48



## WIRE

- Severe abrasion and erosion resistant graded tungsten carbide alloy
- Ferrous matrix reinforced with dispersed, tenacious recrystallised phases
- Full properties with single pass
- Deposits very resistant to grinding



## DESCRIPTION:

EnDOTec DO\*48 is an 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 iron-based matrix. This gives exceptional resistance to abrasive and erosive particles with moderate impact.

## 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: 30 Lb Spool

## TYPICAL WELDING PARAMETERS

1/16" (1.6MM)	TRANSFER	VOLTAGE	AMPERAGE	STICK-OUT	GAS FLOW
Typical	Short-Arc	18 - 22	140 MAX	3/4" - 1 1/4"	25-35 SCFH
Optimum	Short-Arc	20	110-120	1"	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

For semi-automatic and robotic welding applications. Protective coating of parts particularly in the following industries...

Mining, Quarries, Drilling, Tunneling, Public Works

Used for...

- Extrusion press parts
- Transport screws
- Conveyors
- Pump rotors and bodies
- Cylinder crushers
- Mixer paddles

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