Premium Metal Cored, Gas Shielded, Joining Wire

EnDOtec® DO *66

WIRE

- For welding and joining plain carbon steels, construction grade and low alloy steels
- Ideal cushion layer for low-carbon steels
- Easy-to-use wire with low fuming and minimal spatter
- Exhibits exceptional toughness, ductility and strength for low alloy steels

Castolin Eutectic®
Eutectic Castolin

DESCRIPTION:

EnDOtec DO*66 is designed for joining and build-up of plain carbon steel, construction grade and low alloy steels. It is also ideal as a cushion layer on low carbon steels. Its low fuming and minimal spatter make it exceptionally user-friendly. DO*66 produces sound, ductile, high strength deposits.

TYPICAL ANTI-WEAR APPLICATIONS & INDUSTRIES:

APPLICATIONS	INDUSTRY
Bucket Parts, Bulldozers	Quarries, Mining
Cranes, Ore Cars, Loaders	Quarries, Mining
Conveyors, Augers	Cement, Power
Machine Bases	Tool & Die, Stamping
Mixer Blades, Flanges, Cranes	Paper, Power, Cement
Re-building, Low Alloy Steels	Manufacturing, Repair

TECHNICAL DATA:

Hardness as-deposited: HRB 100
Power Source Type: Constant voltage & Integrated Wire Drive
Current & Polarity: DCEP (electrode positive)
Shielding Gas: 1st.) Argon 98% + 2% Oxygen
2nd.) CO_2 100%
Typical Tensile Strength: 85,000 psi

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*66 can be used for both joining and build-up.

Note 2: When re-building 12-14% Mn steels use EnDOtec DO*05 as a cushion layer.

Step 3: Preheat the part to be built-up depending on its air hardenabilty potential and/or carbon level. For most constructional steels a nominal preheat of 150ºF is suggested and for medium alloy steels, ~250°F .

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.

	CURRENT RANGE (A)		VOLTAGE RANGE (V)		WIRE EXTENSION (CONTACT TIP)	
Diameter (in) (mm)	**Short Arc**	**Spray Arc**	**Short Arc**	**Spray Arc**	**Short Arc**	**Spray Arc**
0.045" (1.2)	125-200	180-250	21-26	23-38	9/16" ± 1/8"	5/8" ± 1/8"
1/16" (1.6)	145-230	220-275	23-27	25-30	9/16" ± 1/8"	1/2" ± 1/8"

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.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS

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