Welding Cored Wire Technology for Protection, Repair & Joining Solutions.

Enduring Performance...

Stronger, with Castolin Eutectic

Complete range of small diameter cored wires for unique alloy wearfacing, repair & joining solutions

*Peripheric arc principle ensures:*

- Cooler arc-welding process
- Faster welding speeds
- Increased safety & service life
- Greater cost savings & productivity
**EnDote® Cored Welding Wires**

EnDote® is a gas shielded metal arc welding process (GMAW) using specially formulated cored wires which provide industry with wear protection, repair and joining solutions.

Primary **EnDote®** advantages & benefits are:
- ✓ Higher weld deposition rates
- ✓ Peripheric cool-arc concept
- ✓ Unique anti-wear alloys
- ✓ Easier weldability
- ✓ Increased cost savings

Custom made, welding alloy formulations are feasible with cored wires to optimise performance for wear protection, repair & joining applications.

**Higher Weld Deposition Rates**

EnDote®’s composite cross sectional design, automatically produces a higher current density in the electrode’s metallic periphery over solid MIG/MAG wires of the same diameter using the same welding amperage.

This ensures over 30% faster electrode fusion without sacrificing weld quality giving record weld deposition rates over MIG/MAG and Manual Metal Arc processes.

**Peripheric Cool Arc Concept**

Thanks to EnDote®’s intrinsic higher current density, a cored wire can always be welded at lower amperages than a solid wire whilst keeping a stable metal transfer across the arc due to ionising elements in the core. Lower heat input means that EnDote® welds have better bonding, lower dilution, superior microstructure properties and minimal heat affected zones for maximum service performance.
**UNIQUE ANTI-WEAR ALLOYS**

Solid MIG/MAG wires can only be manufactured in metallurgical alloys which can be cast and easily drawn down to final diameters. The **EnDOtec®** cored wire concept completely overcomes such limitations and unique metallurgical alloys are formulated with high density, ultra-hard micro constituents in Fe, Ni, Co based matrices. Thus **EnDOtec®**'s wide alloy range provides cost effective solutions for most wear problems found in industry.

**EASIER WELDABILITY**

**EnDOtec®** cored wires are easy to use in most positions for repair or joining either in semi-automatic or robotic modes especially with new Dual Pulse systems. Three standard shielding gases cover all application needs. Precision welds at low currents or rapid weld coatings are significantly facilitated for semi-skilled operators.

**INCREASED COST SAVINGS**

Numerous industry studies show that labour is the biggest single cost in welding. As skilled welder rates continue to rise inexorably, CUT your welding costs back to size with **EnDOtec®** systems.

**EnDOtec®** systems significantly increase cost savings and productivity over both MIG/MAG & MMA processes due to faster welding speeds, superior performance and longer service life.
WEAR PROTECTIVE COATINGS TO PROLONG SERVICE LIFE

Classic wear types that occur in industry are:

- Abrasion
- Erosion
- Impact
- Friction
- Heat
- Corrosion
- Cavitation

At Castolin Eutectic we take the time to study industry specific types of wear because until the nature of the wear is fully understood, the correct solution cannot be identified.

Damage caused by these wear groups costs money, especially in downtime and lost production, replacement parts, repair and ongoing maintenance.

Castolin Eutectic has proved for more than a century that a preventive maintenance welding program can extend the life of critical machine parts by as much as 500%. Castolin Eutectic has the «know-how» to identify the most serious wear problems and «show how» to avoid them. Castolin Eutectic can greatly increase your plant efficiency and profits.

PROVEN WEARFACING APPLICATIONS

- Petrochemical OEM weld protected gate valve for corrosion resistance
- Wearfacing for hot abrasion in coke ovens
- Frictional wear of wagon wheel flanges in railways
# WEARFACING APPLICATIONS

<table>
<thead>
<tr>
<th>Type</th>
<th>Main Application</th>
<th>Technical Data</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>DO*02</strong> Fe</td>
<td>Buffer layers &amp; build-ups subject to heavy impact, pressure, metal/metal wear, oxidation up to 600°C</td>
<td>Hardness as welded 190HV30 Hardness work hardened 320HV30</td>
</tr>
<tr>
<td><strong>DO*04</strong> Fe</td>
<td>Wearfacing resistant to metal/metal friction, corrosion and scaling at high temperature</td>
<td>Hardness as welded 50HRC</td>
</tr>
<tr>
<td><strong>DO*05</strong> Fe</td>
<td>Rebuilding and wearfacing of rolling parts subject to pressure, metal/metal friction &amp; severe impact</td>
<td>Hardness as welded 250HV30 Hardness work hardened 380HV30</td>
</tr>
<tr>
<td><strong>DO*06</strong> Fe</td>
<td>High Speed Steel type alloy, retaining high cutting edge hardness &amp; scaling resistance to red heat</td>
<td>Hardness as welded 63HRC</td>
</tr>
<tr>
<td><strong>DO*11</strong> Ni</td>
<td>Tungsten carbides in nickel based matrix for maximum abrasion resistance in corrosive media</td>
<td>Matrix hardness 52HRC Carbide hardness 2400HV</td>
</tr>
<tr>
<td><strong>DO*13</strong> Fe</td>
<td>Good all round resistance to combined wear by moderate impact, pressure, abrasion, friction</td>
<td>Hardness as welded 58HRC</td>
</tr>
<tr>
<td><strong>DO*15</strong> Fe</td>
<td>Wearfacing resistant to tempering, abrasion under low pressure and impact. Fully heat treatable.</td>
<td>Hardness as welded 58HRC Annealed 230HV30</td>
</tr>
<tr>
<td><strong>DO*16</strong> Fe</td>
<td>Wearfacing of hot working tools and die parts subject to high pressure. Suitable for nitridding</td>
<td>Hardness as welded 48HRC Annealed 240HV30</td>
</tr>
<tr>
<td><strong>DO*26</strong> Fe</td>
<td>Machinable build-ups, buttering layers, casting defects on cast iron stamping / forming tools.</td>
<td>Hardness as welded (3rd layer on cast iron) 180HV30</td>
</tr>
<tr>
<td><strong>DO*30</strong> Fe</td>
<td>Wearfacing resistant to fine particle abrasion &amp; erosion. Ferrous matrix with embedded borides.</td>
<td>Hardness as welded 68HRC</td>
</tr>
<tr>
<td><strong>DO*31</strong> Fe</td>
<td>High resistance to abrasion combined with moderate impact, corrosion and heat.</td>
<td>Hardness as welded 55HRC</td>
</tr>
<tr>
<td><strong>DO*322</strong> Fe</td>
<td>Deposit resistant to low stress abrasion &amp; erosion with moderate impact at ambient temperatures.</td>
<td>Hardness as welded 65HRC</td>
</tr>
<tr>
<td><strong>DO*325</strong> Fe</td>
<td>Rebuilding and buttering cast iron tools or casting defects. Crack free deposit.</td>
<td>Hardness as welded (3rd layer on cast iron) 33HRC</td>
</tr>
<tr>
<td><strong>DO*326</strong> Fe</td>
<td>Cold multipass deposits on cast iron for crack resistant cutting edges without any buffer layer.</td>
<td>Hardness as welded 51HRC</td>
</tr>
<tr>
<td><strong>DO*327</strong> Fe</td>
<td>Deposit resistant to combined heavy impact with abrasion, erosion and high pressure.</td>
<td>Hardness as welded 58HRC</td>
</tr>
<tr>
<td><strong>DO*329</strong> Fe</td>
<td>Good resistance to tempering, thermal and mechanical fatigue (up to 500°C)</td>
<td>Hardness as welded 54HRC</td>
</tr>
<tr>
<td><strong>DO*33</strong> Fe</td>
<td>High resistance to severe abrasion, corrosion, oxidation at high temperatures up to 650°C.</td>
<td>Hardness as welded 68HRC (2nd layer)</td>
</tr>
<tr>
<td><strong>DO*332</strong> Fe</td>
<td>Multipass deposits resistant to pressure, abrasion with moderate impact, corrosion &amp; scaling.</td>
<td>Hardness as welded 60HRC</td>
</tr>
<tr>
<td><strong>DO*390N (patented)</strong> Fe</td>
<td>Latest Nano technology, mesomorphic alloy for maximum abrasion resistance up to 750°C</td>
<td>Hardness as welded 71HRC</td>
</tr>
<tr>
<td><strong>DO*411 (patented)</strong> Co</td>
<td>Tungsten carbides in cobalt based matrix for maximum abrasion &amp; oxidation resistance to 850°C</td>
<td>Matrix hardness 52HRC Carbide hardness 2400HV</td>
</tr>
<tr>
<td><strong>DO*48</strong> Fe</td>
<td>Tungsten carbides in ferrous based matrix for maximum abrasion &amp; erosion resistance in service</td>
<td>Matrix hardness 55HRC Carbide hardness 2400HV</td>
</tr>
<tr>
<td><strong>DO*53 S</strong> Fe</td>
<td>Multipass, heat treatable deposits resistant to cavitation, erosion and corrosion.</td>
<td>Hardness as welded 420HV30 Hardness (annealed) 280HV30</td>
</tr>
<tr>
<td><strong>DO*55</strong> Fe</td>
<td>Age hardening alloy for tools and dies. Excellent results on plastic &amp; aluminium injection moulds.</td>
<td>Hardness as welded 35HRC Hardness (aged) 58HRC</td>
</tr>
<tr>
<td><strong>DO*60</strong> Co</td>
<td>Co based alloy resistant to tempering, corrosion, cavitation and erosion at high temperatures</td>
<td>Hardness as welded 41HRC</td>
</tr>
<tr>
<td><strong>DO*70</strong> Co</td>
<td>Co based alloy resistant to tempering, abrasion, friction and corrosion at high temperatures</td>
<td>Hardness as welded 48HRC</td>
</tr>
<tr>
<td><strong>DO*80</strong> Co</td>
<td>Machinable Co based alloy resistant to tempering, corrosion and scaling at high temperatures</td>
<td>Hardness as welded 340HV30 Hardness work hardened 450HV30</td>
</tr>
<tr>
<td><strong>DO*84</strong> Ni</td>
<td>High resistance to corrosion, scaling, thermal cycles up to 1200°C. Hot working tools.</td>
<td>Hardness as welded 230HV30 Hardness work hardened 390HV30</td>
</tr>
<tr>
<td><strong>DO*85</strong> Co</td>
<td>Machinable Co based alloy resistant to pressure, impact, corrosion &amp; thermal fatigue up to 950°C</td>
<td>Hardness as welded 250HV30 Hardness work hardened 380HV30</td>
</tr>
<tr>
<td><strong>CaviTec GMA</strong> Fe</td>
<td>Patented alloy for highest cavitation resistance on stainless steel, carbon steel hydro-turbines, pumps.</td>
<td>Hardness as welded 280HV30 Hardness work hardened 390HV30</td>
</tr>
</tbody>
</table>

**Main application**

**Secondary application**
**Repairs & Joining with Maximum Safety Margin**

**Endo Tec® with or without slag**

The double protection by the shielding gas and light, self releasing slags produced by special fluxing ingredients within the cored wire, provide consistent premium quality welds combining higher mechanical properties and greater reliability over solid MIG/MAG wires:

- Refined weld structures
- Reduced oxide contents
- Improved degassing
- Superior wetting & bonding
- Less risk of cold lap defects
- Easier positional welding
- Slower even cooling rates
- Smooth flat fine rippled beads

**Cleaner, purer welds = Increased safety & reliability**

**Proven Repair & Joining Applications**

**Endo Tec® 33% less joint angle**

Endo Tec® metal cored wires reduce standard 60° joint angles to 40°.

Savings in preparation:
- less machining
- less filler metal
- less welding time
- less defects
- less distortion & stresses

= More cost savings!
## EnDOtec® MANUFACTURING FACILITIES

The EnDOtec® range of high performance cored wires are formulated, developed and manufactured in Castolin Eutectic’s own plants using specially designed production equipment and procedures in accordance with ISO 9001 and EN 29001 quality assurance standards.

Each EnDOtec® batch is welded and fully tested for consistent chemistry, properties & operability before precision spiral spooling and protective packaging for stock.

### Technical Data

<table>
<thead>
<tr>
<th>EnDOtec®</th>
<th>Formula</th>
<th>Main Application</th>
<th>Secondary Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>DO*265S</td>
<td>Fe</td>
<td>Good weldability, premium quality for joining &amp; fabrication of mild, low alloy &amp; fine grain steels. Basic flux for impact strength down to –40°C</td>
<td>Tensile strength (Rm) &gt;510 MPa Elongation (A5) &gt;22% Impact value (Av) 80J</td>
</tr>
<tr>
<td>DO*266S</td>
<td>Fe</td>
<td>Good weldability, premium quality for joining &amp; fabrication of mild, low alloy &amp; fine grain steels. Rutile flux for all positional welds, easy deslagging</td>
<td>Tensile strength (Rm) &gt;510 MPa Elongation (A5) &gt;22%</td>
</tr>
<tr>
<td>DO*267</td>
<td>Fe</td>
<td>Good weldability, premium quality for joining &amp; fabrication of mild, low alloy &amp; fine grain steels. Metal cored type for slag-free, high welding speeds</td>
<td>Tensile strength (Rm) &gt;510 MPa Elongation (A5) &gt;22%</td>
</tr>
<tr>
<td>DO*02</td>
<td>Fe</td>
<td>Joining and crack repairs on high thickness parts, dissimilar steel combinations and buffer layer before wearfacing</td>
<td>Tensile strength (Rm) 650 MPa Elongation (A5) 35%</td>
</tr>
<tr>
<td>DO*09 S</td>
<td>Fe</td>
<td>Joining and crack repairs on Super Duplex stainless steels, austenitic stainless steels and excellent dissimilar steel welding capabilities</td>
<td>Tensile strength (Rm) 850 MPa Elongation (A5) 23% Pitting Resistance Equivalent &gt;40</td>
</tr>
<tr>
<td>DO*22 Ni</td>
<td>Ni</td>
<td>Joining and crack repairs on difficult to weld steels in thick sections, dissimilar steel welding and nickel alloys. Low residual stresses avoid PWHT.</td>
<td>Tensile strength (Rm) 650 MPa Elongation (A5) 40%</td>
</tr>
<tr>
<td>DO*23 Ni</td>
<td>Ni</td>
<td>Joining and crack repairs on ductile and grey cast irons, dissimilar welding cast iron / steel. High crack resistance with good machinability.</td>
<td>Tensile strength (Rm) 470 MPa Elongation (A5) 15%</td>
</tr>
<tr>
<td>DO*24 S</td>
<td>Fe</td>
<td>Joining &amp; crack repairs on alloy steels, difficult to weld steels, high carbon and manganese steels. Buffer layer before wearfacing</td>
<td>Tensile strength (Rm) 580 MPa Elongation (A5) 35%</td>
</tr>
<tr>
<td>DO*25 S</td>
<td>Fe</td>
<td>Joining and crack repairs on Duplex stainless steels, austenitic stainless steels and dissimilar steel welding capabilities</td>
<td>Tensile strength (Rm) 800 MPa Elongation (A5) 25%</td>
</tr>
<tr>
<td>DO*28 S</td>
<td>Fe</td>
<td>Joining, fabrication and crack repairs on low carbon or stabilised 18/8 &amp; 18/8/3 austenitic stainless steels to combat intergranular &amp; pitting corrosion.</td>
<td>Tensile strength (Rm) 570 MPa Elongation (A5) 40%</td>
</tr>
<tr>
<td>DO*53 S</td>
<td>Fe</td>
<td>Joining &amp; fabrication of 13Cr 4Ni stainless steels used in hydro-turbine equipment where positional weldability and heat treatment are requirements.</td>
<td>Tensile strength (Rm) 870 MPa Elongation (A5) 18%</td>
</tr>
<tr>
<td>DO*66 S</td>
<td>Fe</td>
<td>Easy positional weldability, premium quality for joining &amp; fabrication of low alloy, galvanised, free machining steels. Basic flux gives self lifting slag.</td>
<td>Tensile strength (Rm) 540 MPa Elongation (A5) 22% Impact value (Av) 80J</td>
</tr>
<tr>
<td>DO*69 S</td>
<td>Fe</td>
<td>Joining &amp; crack repairs on alloy steels, difficult to weld steels, stainless steels, dissimilar steels. Buffer layer before wearfacing</td>
<td>Tensile strength (Rm) 760 MPa Elongation (A5) 32%</td>
</tr>
<tr>
<td>DO*636</td>
<td>Fe</td>
<td>Joining, rebuilding ductile and grey cast irons, dissimilar welding cast iron / steel. Low shrinkage stresses provide resistance to cracking.</td>
<td>Hardness as welded 140-160 HB</td>
</tr>
</tbody>
</table>
EnDOTec® Welding Equipment Systems

State of the art welding equipment
Complete range of wear resistant alloys
Superior welding performance
Higher weld deposition rates
Faster welding speeds
Increased welding productivity

Wire Feeders

Wire feeders are specially designed with four precision profiled roll drives for smooth and trouble free use of the entire EnDOTec® cored wire range.

Dual Pulse Technology

Integrated Dual Pulse technology enables perfect positional welds even with more difficult alloy systems.

Welding Programs

<table>
<thead>
<tr>
<th>EnDOTec®</th>
<th>Gas</th>
<th>Program</th>
</tr>
</thead>
<tbody>
<tr>
<td>DO*02</td>
<td>Ø 1.2 Ar + 2.5% CO2</td>
<td>37</td>
</tr>
<tr>
<td></td>
<td>Ø 1.6</td>
<td>38</td>
</tr>
<tr>
<td>DO*11</td>
<td>Ø 1.6 Ar + 2.5% CO2</td>
<td>39</td>
</tr>
<tr>
<td>DO*15</td>
<td>Ø 1.2 Ar + 2.5% CO2</td>
<td>40</td>
</tr>
<tr>
<td></td>
<td>Ø 1.6</td>
<td>41</td>
</tr>
<tr>
<td>DO*23</td>
<td>Ø 1.2 Ar + 18% CO2</td>
<td>42</td>
</tr>
<tr>
<td>DO*28</td>
<td>Ø 0.9 Ar + 18% CO2</td>
<td>43</td>
</tr>
<tr>
<td></td>
<td>Ø 1.2</td>
<td>44</td>
</tr>
<tr>
<td></td>
<td>Ø 1.6</td>
<td>45</td>
</tr>
<tr>
<td>DO*29</td>
<td>Ø 1.2 Ar + 2.5% CO2</td>
<td>46</td>
</tr>
<tr>
<td></td>
<td>Ø 1.6</td>
<td>47</td>
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<tr>
<td>DO*30</td>
<td>Ø 1.2 Ar + 2.5% CO2</td>
<td>48</td>
</tr>
<tr>
<td></td>
<td>Ø 1.6</td>
<td>49</td>
</tr>
<tr>
<td>DO*48</td>
<td>Ø 1.6 Ar + 2.5% CO2</td>
<td>50</td>
</tr>
<tr>
<td>DO*55</td>
<td>Ø 1.6 Ar + 2.5% CO2</td>
<td>51</td>
</tr>
<tr>
<td>DO*60</td>
<td>Ø 1.2 Ar 100%</td>
<td>52</td>
</tr>
<tr>
<td></td>
<td>Ø 1.6</td>
<td></td>
</tr>
<tr>
<td>DO*65</td>
<td>Ø 1.2 Ar + 18% CO2</td>
<td>53</td>
</tr>
<tr>
<td>DO*66</td>
<td>Ø 1.2 Ar + 18% CO2</td>
<td>54</td>
</tr>
<tr>
<td>DO*80</td>
<td>Ø 1.2 Ar 100%</td>
<td>57</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cavitec</td>
<td>Ø 1.2 Ar 100%</td>
<td>58</td>
</tr>
</tbody>
</table>

Torches

User friendly range of gas cooled or water cooled ergonomic torches for perfect results and increased savings.

Cored Wire + Welding Program + Dedicated Equipment

Guarantee of professional results everytime...

....even with semi-professional welders!

Castolin Eutectic has developed a complete range of welding program parameters which are specifically optimised for each EnDOTec® cored wire alloy.

These digital synergetic programs have been integrated into EnDOTec® high duty welding equipment systems so that superior performance, productivity and perfect results are assured everytime even when highly skilled welders are not available.
Castolin Eutectic CastoLabs are located in Germany, Belgium, Holland, Spain, Austria, Poland, Czech Republic and the United Kingdom, and are best contacted through Castolin Eutectic via our website (www.castolin.com). In countries without CastoLabs, Castolin Eutectic collaborates with approved workshops who are in close contact with Castolin Eutectic's specialists and technologies.

Fan Protected with Powder Coated Wear Plates

Fan built with wear resistant CDP

Thermal Spraying

Arc Wire Spraying

Remachining

Workshop Maintenance

In Situ Maintenance

Industry Partner

A century at the forefront of protective materials technology has positioned Castolin Eutectic as the world's premier industrial partner. Our comprehensive know-how is unrivalled, and our industry partnerships continue to thrive. We provide solutions to all of the major companies operating in industry with global industrial programs for steel, cement, automotive, power, oil, waste & recycling,...
The unique Terolink database of Castolin Eutectic contains almost 6,000 fully documented approved applications from around the globe. The case studies include photographs, technical data, detailed descriptions and cost-saving analyses.

Together with our sister company, the Messer Group, we can offer our customers a very powerful range of products and services. Being «Part of the Messer World» means:

- Investing €420 million before 2008
- More than 6,000 motivated employees
- Over 100 factories to meet the needs of customers
- Technical sales support in over 120 countries
- 2,000 technical sales people in the field with our customers every day

To increase customer know-how in wear technology and repair techniques, we have developed a full line of seminars and training programs, teaching all relevant personnel from welders and engineers to sales teams and managing directors.
**History of Castolin Eutectic**

1906: Foundation of Castolin in Lausanne, Switzerland by Jean-Pierre Wasserman. His stroke of genius: to discover a way of welding cast iron at low temperature; in the following years, this innovation was further developed for all industrial metals including aluminium alloys.

1940: Foundation of Eutectic Welding Alloys Corporation in New York

1952: Foundation of Castolin France

1959: Foundation of Eutectic Japan Ltd

1962: Foundation of Eutectic India Ltd.

1960's: International consolidation under Castolin Eutectic

1970's: Creation of training centers for Maintenance & Repair technologies

1978: Establishment of World Head Quarters in St-Sulpice, Switzerland

2000: Merger with Messer Cutting & Welding and creation of the MEC Group - Messer Eutectic Castolin

2005: Part of the Messer World

2006: 100 years of innovation, service and quality.

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  +41-(0)21 694 1111

**Your resource for protection, repair and joining solutions**

For further information,
please visit our homepages:

www.castolin.com  www.eutectic.com
Stronger, with...
Castolin Eutectic
WEAR & FUSION TECHNOLOGY

Ask for a demonstration from our Application Specialists.

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-> www.eutectic.com <<<