



Gas Shielded Wire for
Semi-Automatic and Automatic Robotic Welding

EnD0tec®
DO*10

- Exceptional resistance to severe abrasion under high pressure
- Excellent out-of-position weldability
- Higher deposition rates for reduced labor costs
- More versatile welding parameters than the competition

EnDOTec® DO*10

EnDOTec® DO*10 is engineered to resist severe abrasion under high pressure, with low to moderate impact. It offers excellent out-of-position weldability. Its low fuming and minimal spatter make it exceptionally user friendly, producing smooth weld deposits at a rapid rate.

TECHNICAL DATA

Typical Values	
Typical Hardness 2 passes:	HRC 52-56
Current & Polarity:	DC (+) electrode positive
Power Source Type:	Constant voltage & Integrated Wire Drive
Shielding Gases:	Ar 98% + 2% O ₂ (1st) Ar 90% + 10% CO ₂ (2nd) Short Arc 100% CO ₂
Shielding Gas Flow Rate:	30-40 SCFH 16-19 L/min

0.045" (1.2MM)	VOLTS	AMPS	STICK-OUT
Spray Arc	28-31	175-200 (Large parts)	5/8" ± 1/8" (Short nozzle)
Short Arc	25-29	100-175 (Lighter parts)	5/8" ± 1/8" (Long nozzle)
1/16" (1.6MM)	VOLTS	AMPS	STICK-OUT
Spray Arc	25-30	230-290 (Large parts)	5/8" ± 1/8" (Short nozzle)
Short Arc	25-30	185-250 (Lighter parts)	5/8" ± 1/8" (Long nozzle)

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.

PROCEDURE FOR USE

Caution: Although a 2-roll wire drive assembly will work the optimum for maintaining arc voltage stability and consistent & 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*10 is 2 pass maximum. It is often field practice to deposit a base-coat depending on the type of wear, severity and the total amount of build-up required.

Note: When re-building 12-14% Mn steels use EnDOTec DO*05 as a cushion layer, and for other alloy steels, EnDOTec DO*68S is recommended. A 2-pass minimum is advised when less-thick deposits are required.

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

Note: Do not heat high manganese steels such as Hadfield Castings!

Step 4: After checking that the welding conditions are optimal by testing on scrap metal, position the gun head at a 70-80° angle and use a "push" technique for downhand welding. For fully automated welding such as hardfacing cylindrical parts, the wire should exit at about a 10° lagging angle from top dead center. Using this technique will assure a smooth and regular weld deposit profile with the optimum level of fusion.

Note: If welding is interrupted and the part being welded cools to room temperature, make sure to reheat to the original preheat temperature. For hardenable steels slow cooling is advised using silicone blankets, vermiculite, or other environmentally suitable heat-retardant material.

Step 5: For most applications, other than a superficial grind, finishing is not required. If some level of profiling is needed, grinding can be used for more precise shaping.

TYPICAL APPLICATIONS

APPLICATIONS

- Dragline Buckets - Shovel Buckets
- Cutter Heads - Brick Augers
- Muller Plows - Tamper Bar Ends
- Feed Rolls - Conveyor Chains
- Gyrotory Crushers
- Extruder Screws - Pug Mill Augers

INDUSTRY

- Cement, Mining
- Quarries
- Quarries, Mining
- Material Processing
- Power, Cement
- Cement, Power



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