



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

EnD0tec®

DO*11



- High density of cast tungsten carbide particles evenly distributed in a nickel-alloy matrix
- Extremely abrasion resistant even in corrosive media
- Higher deposition rates for reduced labor costs
- More versatile welding parameters than the competition

EnDOTec® DO*11

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 nickel-alloy matrix. This gives exceptional resistance to abrasive and erosive particles with moderate impact and is specifically for applications in hot or corrosive environments.

TECHNICAL DATA

Typical Values	
Diameter of Wire:	1/16" (1.6mm)
Typical Matrix Hardness:	HRC 55
Micro Hardness of Carbide:	2200 HV
G65 volume loss:	20.1 mm ³
Machinability:	Grind Only
Shielding Gas:	98% Ar / 2% O ₂ @ 30 SCFH
Current polarity:	DCEP (+)
Stick-Out:	1/2" - 3/4"

TYPICAL WELDING PARAMETERS

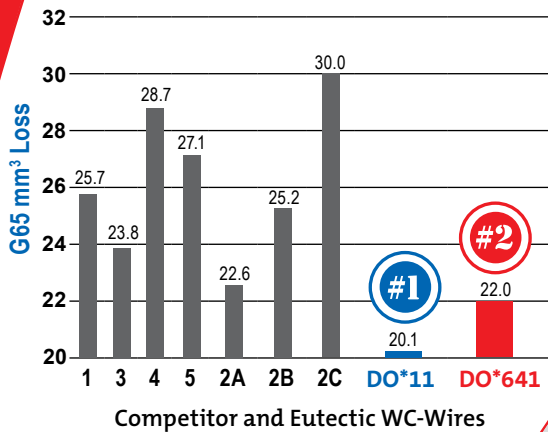
VOLTAGE	WIRE FEED (ipm)	AMPERAGE
18	80	115
22	138	140

PROCEDURE FOR USE.

PREPARATION: Remove old welding deposits and worn metal with ChamferTrode. Degrease and remove all contaminants. Pre-heating temperatures are determined by base metal.

TECHNIQUE: 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.

G65 Eutectic vs Competitors



TYPICAL APPLICATIONS

Designed for anti-wear coatings on carbon steel, alloy steels, stainless steels and nickel alloys.

Typical industries include agriculture, food and beverage, oil drilling components, pulp and paper and chemical processing.

- High speed fan blades
- Ash handling systems
- Brick and tile extruders
- Sintering parts
- Slag breakers
- Screw conveyers
- Press rolls
- Mixers & paddles
- Stabilizers
- Transfer chutes
- Tool joints



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