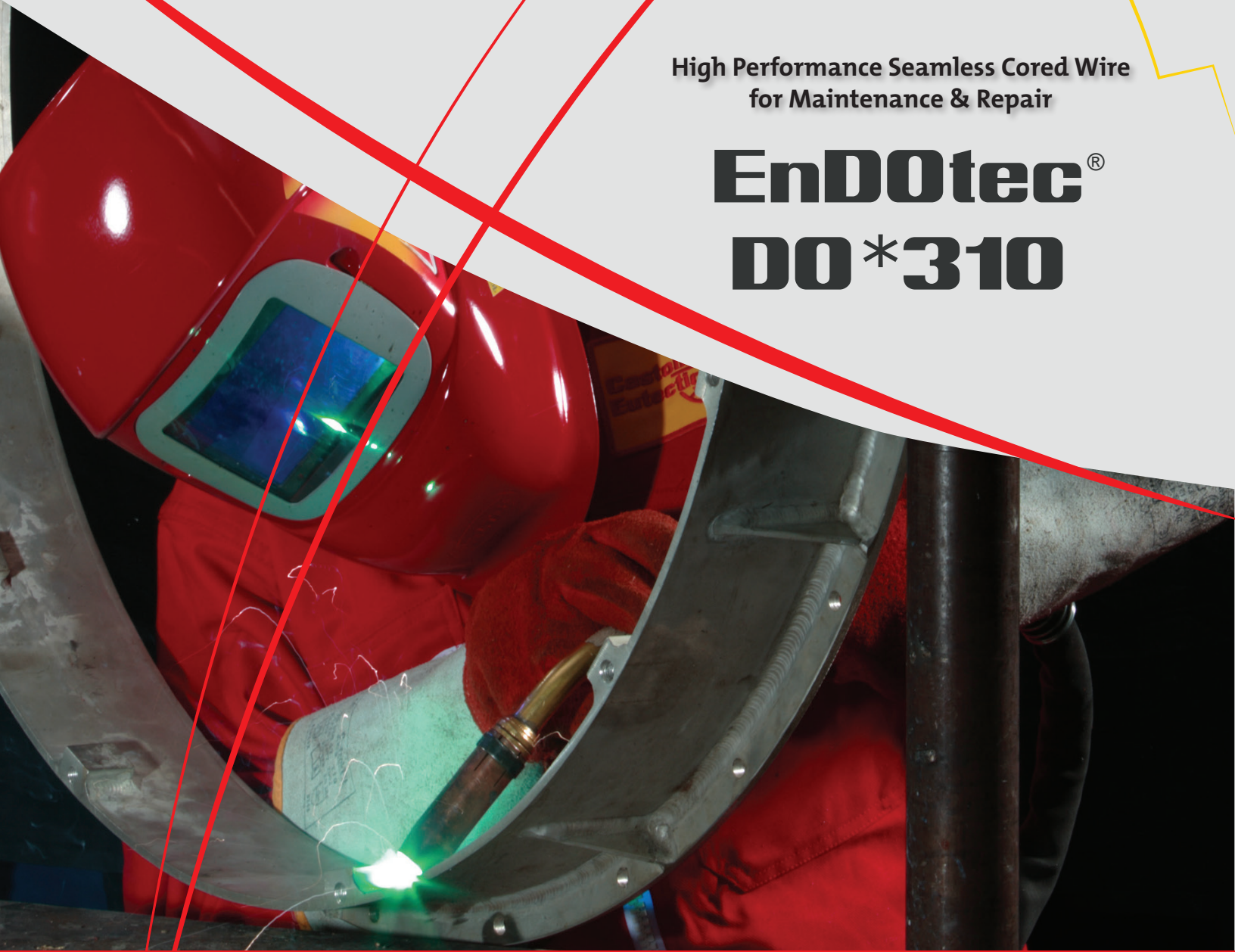




High Performance Seamless Cored Wire
for Maintenance & Repair

EnD0tec®

DO *310



- Good resistance to compression and plastic deformation
- Multi-pass deposit capability
- Readily machinable
- Regular bead profile, virtually spatter free
- Versatile usage over wide parameter range

EnD0tec® DO*310

Seamless, gas shielded, metal cored alloy wire, ideal for batch manufacturing or maintenance and repair applications where highest integrity welding, efficiency and productivity are required.

General purpose, low alloy Cr-C-Mn-Fe weld deposits for thick multipass deposition without cracks. Ideal for rebuilding worn cast steel sections, medium carbon steel parts and buttering layers for wearfacing applications.

TECHNICAL DATA

Typical Values	
Typical Hardness	38 HRC
Power Source:	Constant voltage & integrated wire drive
Current polarity:	(+) positive polarity
Shielding Gas Flow Rate:	30-40 SCFH (16 l/min.)
Positions:	Flat, Horizontal and Horizontal Vertical

* Please contact Technical Services for optimum out-of-position parameters.

DIAMETER	AMPS	VOLTS	SHIELDING GAS
0.045" (1.2mm)	100-320	16-35	1st Choice: 90% Ar + 10% CO ₂ 2rd Choice: 75% Ar + 25% CO ₂
1/16" (1.6mm)	130-420	19-38	

PROCEDURE FOR USE

EQUIPMENT: EnD0tec continuous electrodes are compatible with most conventional, constant voltage power sources. A 4-roll drive assembly with smooth V- or U-grooves is recommended for maintaining arc voltage stability and consistent, smooth wire feeding.

PREPARATION: Remove old welding deposits and worn metal completely with ChamferTrode®.

PRE-HEATING: Preheating depends on the steel's carbon equivalent and the workpiece size, thickness and geometry. Eutectic recommends...

CE<0.2: Preheat not necessary

CE 0.2-0.4: Preheat 210° - 390°F (100-200°C)

CE 0.4-0.8: Preheat 390° - 660°F (200-350°C)

NOTE that 12-14% Mn steels should never be preheated and the workpiece temperature during welding should be kept below 480°F (250°C).

WELDING TECHNIQUE: For multi-pass, down-hand coating push the electrode down the workpiece at an angle of 70/80° to ensure optimum fusion.

FINISHING: The deposit is machinable by normal cutting tools. Grinding, arc, oxyacetylene or plasma cutting equipment may also be used.

TYPICAL APPLICATIONS

Designed specifically to provide protective coating against wear caused by adhesion (metal-metal friction), pressure and impact.

- Chain Sprockets
- Guide Rolls
- Pulleys
- Worn Parts on Bulldozers,
- Rebuilding of large, severely worn steel castings

