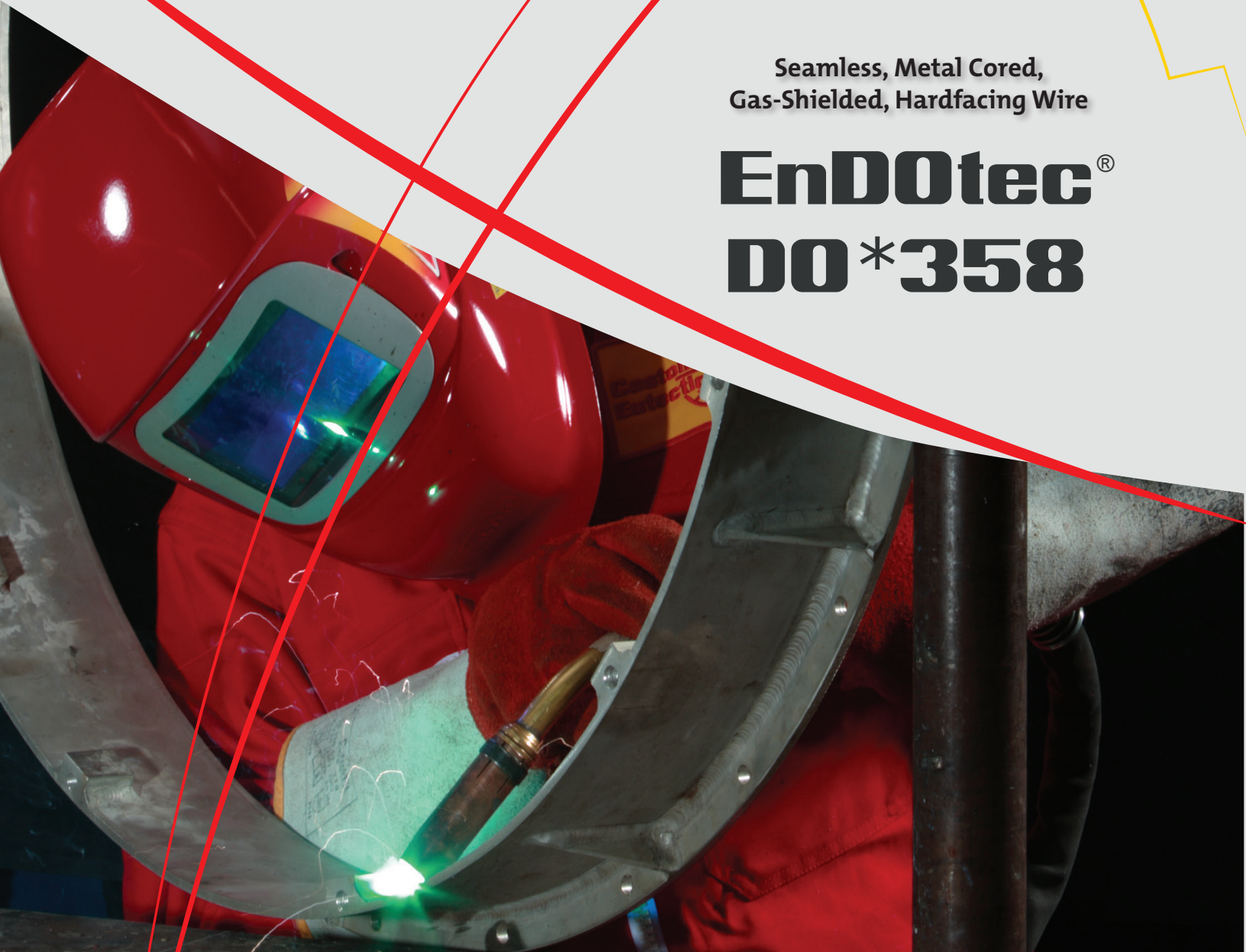




Seamless, Metal Cored,
Gas-Shielded, Hardfacing Wire

EnD0tec®

DO *358



- Maximum hardness (57-62 HRC) deposit, without cross-checking
- Excellent resistance against abrasion combined with impact and pressure
- Forgeable deposit can be heat treated or nitrided
- Superior wire feeding characteristics and low contact tip wear
- Especially suited for automated welding
- Out-of-position capability

EnD0tec® DO*358

EnD0tec® DO*358 is a seamless, metal cored, general purpose, hardfacing wire designed to resist wear in applications involving a combination of abrasion, impact, and pressure. The wire exhibits excellent weldability and deposition efficiency compared to solid wires. The weld deposits do not exhibit cross-checking.

The advantages of seamless-cored wires are reduced contact tip wear, constant wire-positioning accuracy, reduced wire feeding force, and no moisture pick-up.

TECHNICAL DATA

| Typical Values | |
|--------------------------|--|
| Typical Hardness | 57-62 HRC |
| Power Source: | Constant voltage & integrated wire drive |
| Current polarity: | DCEP (+) |
| Shielding Gas Flow Rate: | 30-40 SCFH (14-19 l/min.) |
| Positions: | Horizontal & Vertical Down* |

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

| DIAMETER | AMPS | VOLTS | SHIELDING GAS |
|----------------|---------|-------|--|
| 0.045" (1.2mm) | 120-300 | 20-32 | 1st Choice: 90% Ar + 10% CO ₂ 2nd Choice: 98% Ar + 2% O ₂ |
| 1/16" (1.6mm) | 180-420 | 22-34 | 3rd Choice: 75% Ar + 25% CO ₂ |

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.

TYPICAL APPLICATIONS

- Cutting tools
- Bucket teeth
- Agricultural equipment
- Construction equipment
- Conveyor screws
- Grizzly bars
- Cable drums
- Casing-Friendly Hardbanding

