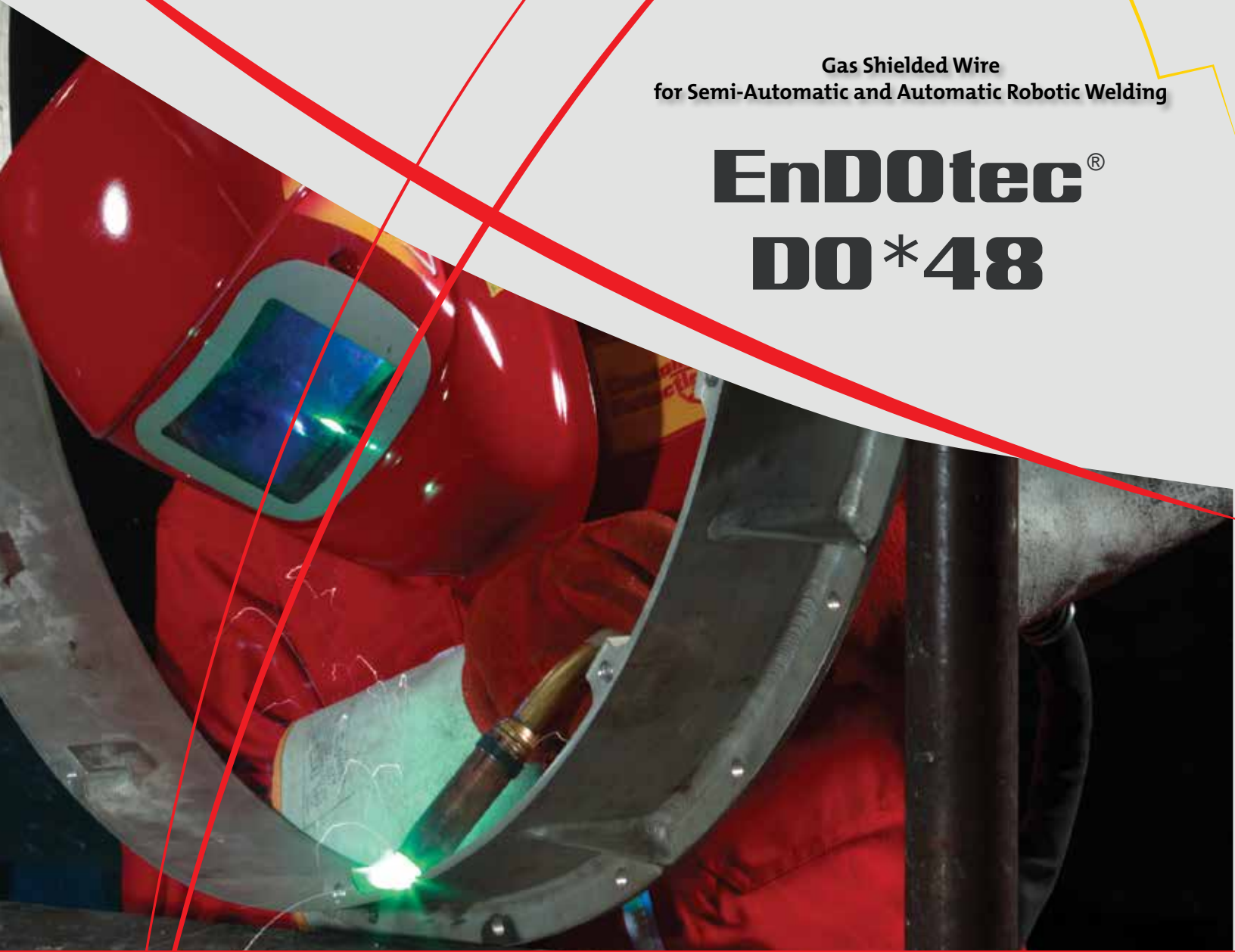




Gas Shielded Wire
for Semi-Automatic and Automatic Robotic Welding

EnD0tec®

DO*48



- Severe abrasion and erosion resistant graded tungsten carbide alloy
- Ferrous matrix reinforced with dispersed, tenacious recrystallised phases
- Full properties with single pass
- Deposits very resistant to grinding

EnD0tec® DO*48

EnD0tec® DO*48 is an 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 Tungsten Carbide particles evenly distributed in a ironbased matrix. This gives exceptional resistance to abrasive and erosive particles with moderate impact.

TECHNICAL DATA

Typical Values	
Typical Matrix Hardness:	55 HRC
Micro Hardness of Carbide:	2200 HV
Machinability:	Grind only
Current polarity:	DCEP (+)
Shielding Gas:	98% Ar / 2%O ₂

1/16" (1.6MM)	TRANSFER	AMPS	VOLTS	STICK-OUT	GAS FLOW
Typical	Short-Arc	140 max	18-22	3/4" - 1 1/4"	25-35 SCFH
Optimum		110-120	20	1"	30 SCFH

PROCEDURE FOR USE

Remove old welding deposits and worn metal with ChamferTrode. Degrease and remove all contaminant's. Pre-heating temperatures are determined by base metal.

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.

TYPICAL APPLICATIONS

For semi-automatic and robotic welding applications. Protective coating of parts particularly in the following industries: Mining, Quarries, Drilling, Tunneling, Public Works.

Used for:

- Extrusion press parts
- Transport screws
- Conveyors
- Pump rotors and bodies
- Cylinder crushers
- Mixer paddles

