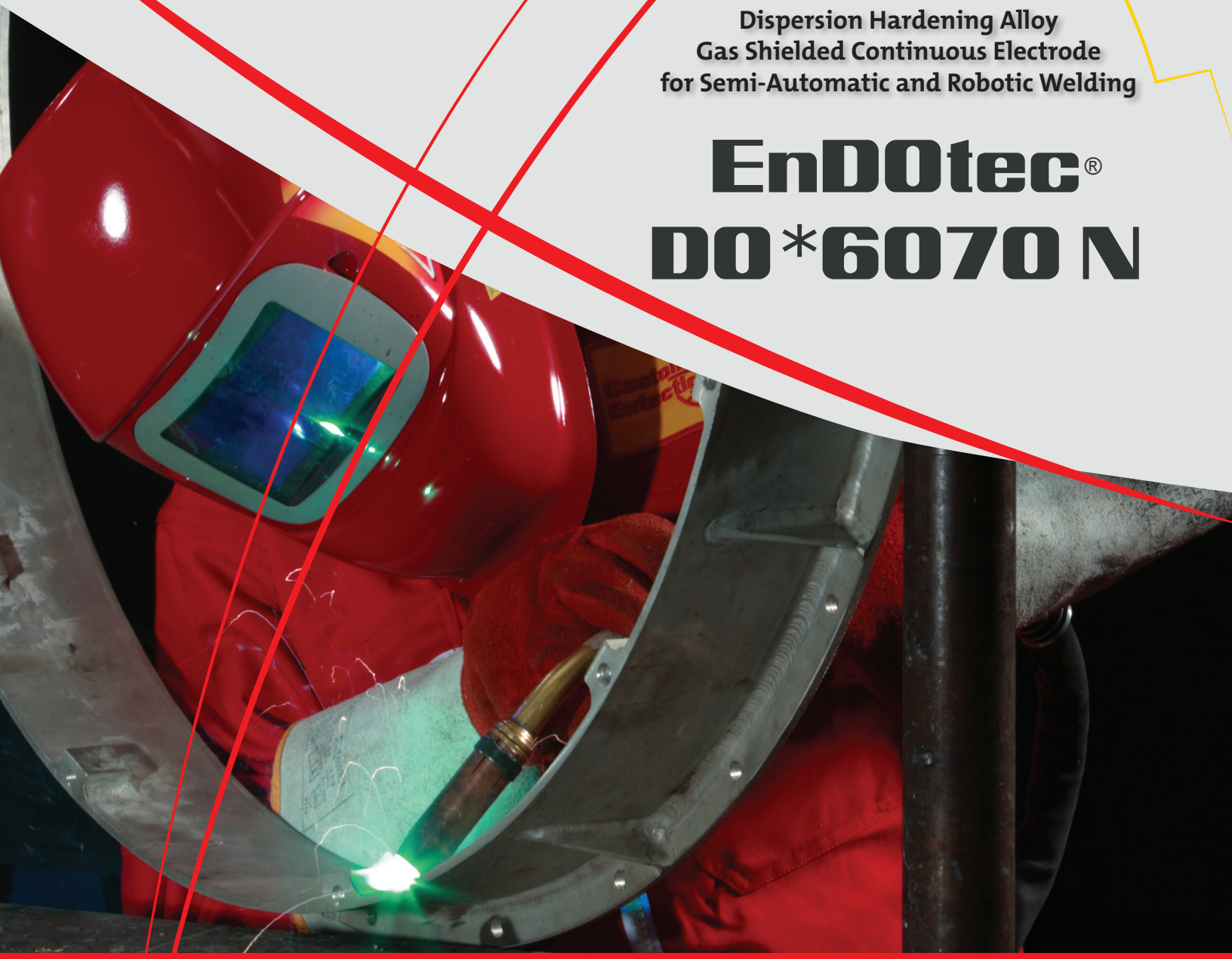
Castolin Eutectic®
Eutectic Castolin

Dispersion Hardening Alloy
Gas Shielded Continuous Electrode
for Semi-Automatic and Robotic Welding

EnDOtec®
DO*6070 N



- Slag free deposit with high volume fraction of ultra hard complex carbides
- Highest hardness retention at high temperature
- Superior oxidation resistance at elevated service temperature
- Fine microstructure gives premium abrasion resistance to both fine and coarse particles

EnDOtec® DO*6070 N

This proprietary alloy produces an iron matrix with 50% of fine and uniformly orientated complex carbides resistant against both fine and coarse particles. It is specially good when high temperatures are part of the process (58 HRC at 1112°F; 42 HRC at 1472°F). It is ideal for both maintenance and repair and production applications where welds of utmost reliability, performance and productivity are required.

TECHNICAL DATA

Typical Values	
Hardness	69 HRC
Polarity:	DCEP
Shielding Gas (optional):	75% Ar + 25% CO_2
Flow Rate:	35 cfh
Voltage:	16-31
Amperage:	75-250
Welding Positions:	Flat, Horizontal & Vertical Down

DIAMETER	AMPS	VOLTS
1/16" (1.6mm)	75-250	16-31

PROCEDURE FOR USE

EQUIPMENT: EnDOtec continuous electrodes are compatible with most conventional, constant voltage power sources. Models with programmable pulsed arc metal transfer functions offer optimum performance. Castolin Eutectic recommends the use of wire drive systems fitted with 4 feed rollers: smooth rollers for 01.2 and knurled for 01.6mm.

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

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

Castolin 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 single or multi-pass, downhand coating pull the electrode down the workpiece at an angle of 70/80° to ensure optimum fusion. When required, additional passes should only be executed while the weld is still hot.

TYPICAL APPLICATIONS

Designed for protection against abrasion and erosion, especially where both fine and coarse grain mineral particles are present. Suitable for a wide range of steels including medium carbon steels, low alloy steels and manganese steels.

- Cement: Fuller Plates & Cyclones
- Steel: Sinter Crushers & Furnace Chutes
- Agriculture: Impellers
- Conveyors
- Vanes & Scrapers

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Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent, Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca

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