



Metal-Cored, Gas Shielded, Wire for  
Semi-Automatic and Automatic  
Hardfacing Applications

# **EnD0tec®**

## **DO\*641**

- High density of cast tungsten carbide particles evenly distributed in a nickel-alloy matrix
- Extremely abrasion resistant even in corrosive media
- Slag-free weld deposit

# EnDOTec® DO\*641

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 especially suited for applications in hot or corrosive environments.

## TECHNICAL DATA

Typical Values	
Diameter of Wire:	1/16" (1.6mm)
Typical Matrix Hardness:	HRC 47
Micro Hardness of Carbide:	2200 HV
Machinability:	Grind Only
Shielding Gas:	98% Ar / 2%O <sub>2</sub> @ 30 SCFH
Current polarity:	DCEP (+)
Stick-Out:	1/2" - 3/4"

## TYPICAL WELDING PARAMETERS

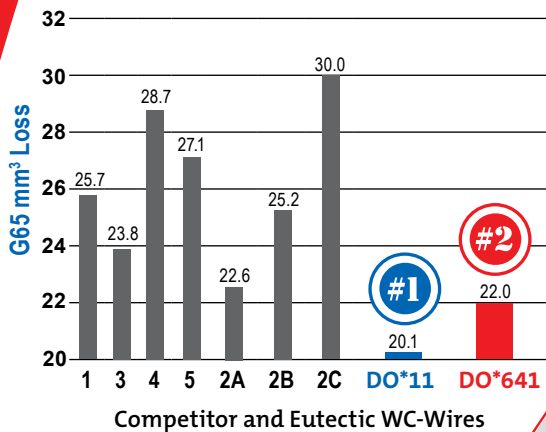
VOLTAGE	WIRE FEED (ipm)	AMPERAGE
18	80	120
21	125	140

## 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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