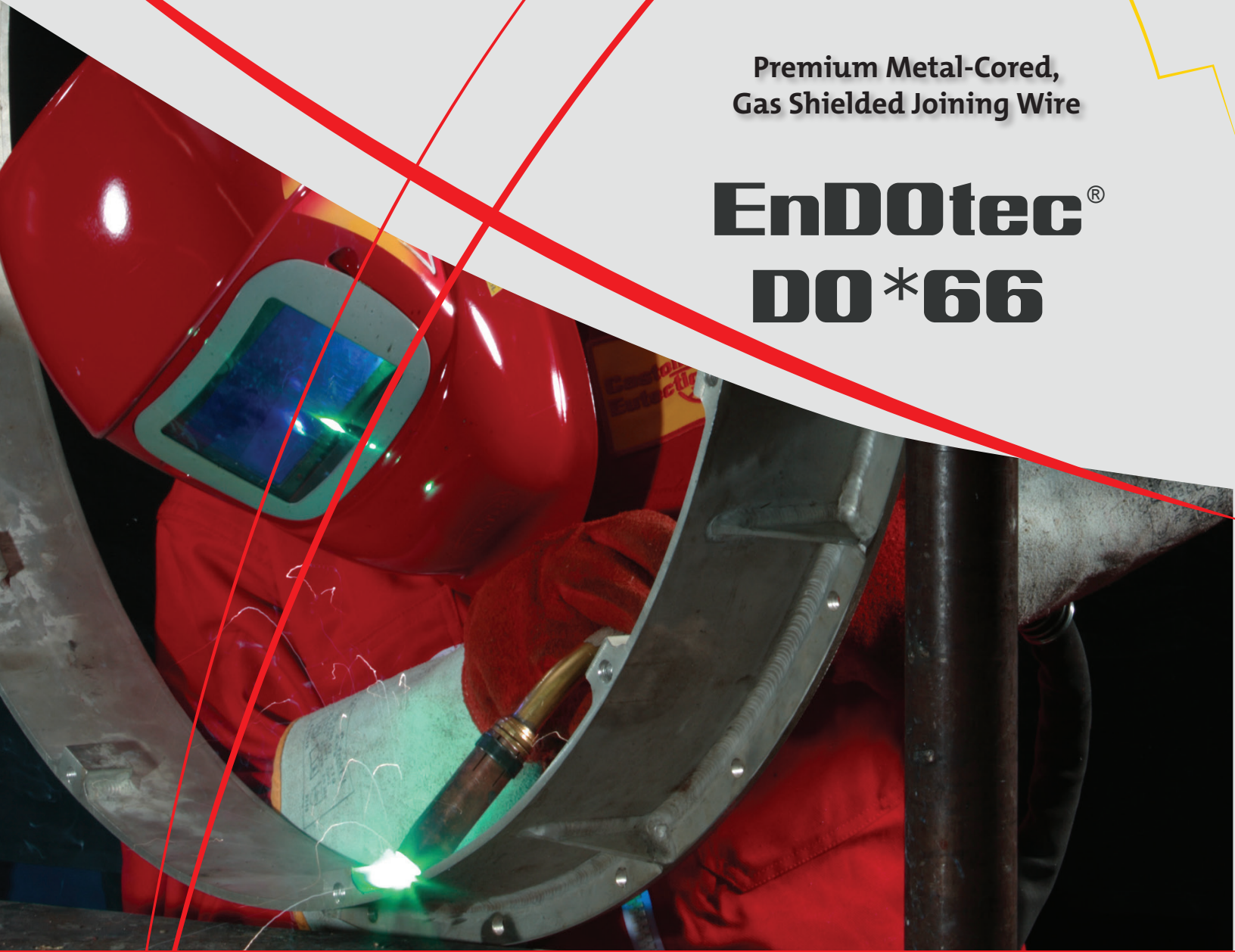




Premium Metal-Cored,
Gas Shielded Joining Wire

EnD0tec®
D0*66



- For welding and joining plain carbon steels, construction grade and low alloy steels
- Ideal cushion layer for low-carbon steels
- Easy-to-use wire with low fuming and minimal spatter
- Exhibits exceptional toughness, ductility and strength for low alloy steels

EnDotec® DO*66

EnDotec DO*66 is designed for joining and build-up of plain carbon steel, construction grade and low alloy steels. It is also ideal as a cushion layer on low carbon steels. Its low fuming and minimal spatter make it exceptionally user-friendly. DO*66 produces sound, ductile, high strength deposits.

TECHNICAL DATA

Typical Values	
hardness as-deposited	HRB 100
Power Source Type	Constant voltage & Integrated Wire Drive
Shielding Gases	(1st) Argon 98% + 2% Oxygen (2nd) CO ₂ 100%
Tensile Strength	85,000 psi
Current & Polarity	DCEP (electrode positive)

Diameter (in) (mm)	CURRENT RANGE (A)		CURRENT RANGE (V)		WIRE EXTENSION (CONTACT TIP)	
	Short Arc	Spray Arc	Short Arc	Spray Arc	Short Arc	Spray Arc
0.045" (1.2)	125-200	180-250	21-26	23-38	9/16" ± 1/8"	5/8" ± 1/8"
1/16" (1.6)	145-230	220-275	23-27	25-30	9/16" ± 1/8"	1/2" ± 1/8"

Note: Parameter adjustments will be needed depending on the size, weight, and shape of the part to be welded. For optimum wear resistance keep to the low end of the amperage & voltage ranges.

PROCEDURE FOR USE

Caution: Although a 2-roll wire drive assembly will work the optimum for maintaining arc voltage stability and consistent and smooth wire feeding is a serrated 4-roll drive assembly. Smooth drive rolls are not recommended!

Step 1: Remove all "old" cracked or spalled weld metal down to a sound base.

Step 2: EnDotec DO*66 can be used for both joining and build-up.

Note 2: When re-building 12-14% Mn steels use EnDotec DO*05 as a cushion layer.

Step 3: Preheat the part to be built-up depending on its air hardenability potential and/or carbon level. For most constructional steels a nominal preheat of 150°F is suggested and for medium alloy steels, ~250°F.

Note: If welding is interrupted and the part being welded cools to room temperature, make sure to reheat to the original preheat temperature. Slow cooling is advised using silicone blankets, vermiculite, or other environmentally suitable heat-retardant material.

TYPICAL APPLICATIONS

APPLICATIONS

Bucket Parts, Bulldozers
Cranes, Ore Cars, Loaders
Conveyors, Augers
Machine Bases
Mixer Blades, Flanges, Cranes
Re-building, Low Alloy Steels

INDUSTRY

Quarries, Mining
Quarries, Mining
Cement, Power
Tool & Die, Stamping
Paper, Power, Cement
Manufacturing, Repair

