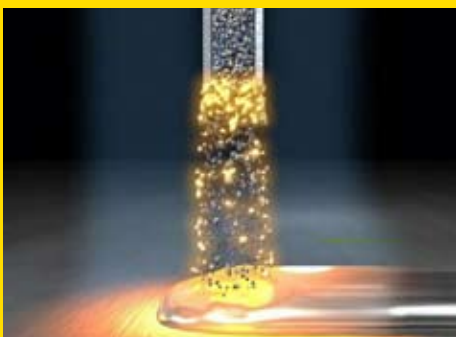


Gas shielded welding cored wire technology for wear protection & repair

EnDotec® DO*23



- Tough nickel-iron matrix dispersed with fine spheroidal graphite
- Low heat input reduces Heat Affected Zone
- Highest resistance to hot & cold cracking
- Dissimilar joining capability between cast irons & steel

WELDING





Wheel hub wearfaced with DO*23



Drive sprocket protected against friction combined with pressure

Features & Benefits

Alloy type	Microstructure	Properties
Ni-FeMn	Austenitic + SG	Tensile strength ~470 MPa Yield strength ~350 MPa Elongation ~15% Hardness ~190 HV

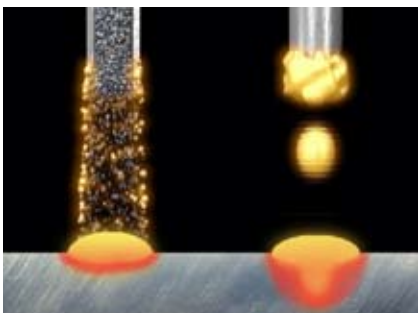
- Tough nickel-iron matrix dispersed with fine spheroidal graphite
- Low heat input reduces Heat Affected Zone
- Preheating & Postheating normally not required
- Highest resistance to hot & cold cracking
- Dissimilar joining capability between cast irons & steel
- Reduced residual stresses allow thick welds (~3cm)
- Slag free, machinable deposits
- Rust resistant welds
- Deposits can be chromium plated

Higher weld deposition rates

EnDOTec®'s composite cross sectional design, automatically produces a higher current density in the electrode's metallic periphery over solid MIG/MAG wires of the same diameter using the same welding amperage. This ensures over 30% faster electrode fusion without sacrificing weld quality giving record

weld deposition rates over MIG/MAG and Manual Metal Arc processes.

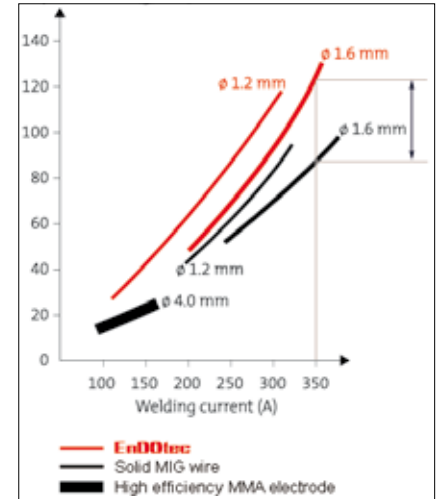
Peripheric cool arc concept



Thanks to EnDOTec®'s intrinsic higher current density, a cored wire can always be welded at lower amperages than a solid wire whilst keeping a stable metal transfer across the arc due to ionising elements in the core. Lower heat input means that EnDOTec® welds have better bond-

Applications

For semi-automatic & robotic welding applications. Weld repair of cracks / joining Spheroidal Graphite, malleable & grey flake cast iron castings to low carbon steels. Modification or rebuilding machining errors or worn cast iron tools & dies, pump & valve casings, engine blocks in automotive, machine workshops, foundry, textile industries.



ing, lower dilution, superior microstructure properties and minimal heat affected zones for maximum service performance.

Your resource for protection, repair and joining solutions

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