



Premium Metal Cored, Gas Shielded,
Wire for Cladding Cast Iron

EnD0tec®
DO *325



- For the build-up and protection of most weldable cast irons
- Crack-free weld deposits
- Tolerant of thermal cycle stresses

EnDOTec® DO*325

EnDOTec DO*325 is designed for build-up of a wide range of cast iron. This gas shielded, metal cored alloy wire is ideal for maintenance and repair applications or batch manufacturing where the highest integrity welding, efficiency and productivity are required.

Deposits provide an excellent mechanical property match on a wide range of cast irons. Weld deposits are also highly tolerant of the expansion and contraction stresses caused by the heat of welding. EnDOTec DO*325 is formulated to be a crack-free, anti-wear protective coating on cast irons.

TECHNICAL DATA

Typical Values	
Hardness 2 Passes:	35-39 HRB
Current & Polarity:	DC (+) electrode positive
Power Source Type:	Constant Voltage & Integrated Wire Drive
Shielding Gases:	Argon 98% + 2% Oxygen

1/16" (1.6mm)	VOLTAGE	AMPERAGE	STICK-OUT	GAS FLOW
Spray Arc	25-30	200-275 (Large parts)	5/8" ± 1/8" (Short nozzle)	30-45 scfh
Short Arc	23-26	100-200 (Lighter parts)	9/16" ± 1/8" (Long nozzle)	30-45 scfh

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*325 can be used for build-up.

Step 3: With difficult-to-weld base metals and complex work-pieces, slight preheating to about 400°F (200°C) or higher will minimize the risk of cracking in the transition zone. Slow cool following welding.

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

Cast Iron Rolls
Machine Bases
Pump Housings - Nash Pumps
Gear Boxes
Dies - Closed Impression Dies
Cast Iron Foundry Defects

INDUSTRY

Cement Works
Iron and Steel Works
Pulp and Paper
Open Cast Mining
Automotive
Foundry

