



**High Performance Hardfacing Seamless
Cored Wire for Abrasion Resistance**

EnD0tec®
D0*361

- Maximum arc stability & metal transfer
- Increased current density for faster weld deposition rates
- Superior weld metal recovery to 98%
- Cu coated wire for smooth feeding without lubricants
- Improved service life of torch contact tips

EnDOTec® DO*361

Exclusive, gas shielded, seamless, metal cored alloy wire, ideal for maintenance and repair applications or batch manufacturing where highest integrity welding, efficiency and productivity are required.

The Cr-C-Fe rich alloy deposit is characterized by a high concentration of hard Cr carbides integrated within a tough austenitic matrix for good service performance up to 932°F (500°C). The smooth, slag free, rust resistant welds provide excellent wear resistance to high abrasion combined with moderate impact.

TECHNICAL DATA

Typical Values	
Typical Hardness:	≈61 HRC as welded
Welding Polarity:	DCEP (+)
Power Source:	Constant voltage & integrated wire drive
Shielding Gas Flow Rate:	30-40 SCFH 16-18 l/min.
Positions:	Flat and Horizontal

DIAMETER	VOLTS	AMPS	SHIELD GAS
1/16" (1.6mm)	16-40	60-420	75% Ar / 25% CO ₂

PROCEDURE FOR USE

EQUIPMENT

EnDOTec continuous electrodes are compatible with most conventional, constant voltage power sources. A 4-roll drive assembly with smooth V- or U-grooves is recommended for maintaining arc voltage stability and consistent, smooth wire feeding.

PREPARATION

Remove old welding deposits and worn metal completely with ChamferTrode®.

PREHEATING

Preheating depends on the steel's carbon equivalent and the workpiece size, thickness and geometry. 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 multi-pass, downhand coating push the electrode down the workpiece at an angle of 70/80° to ensure optimum fusion.

FINISHING

The weld deposit is machinable by grinding. Arc or plasma cutting equipment may also be used.

TYPICAL APPLICATIONS

Generally most machine parts subjected to abrasion combined with moderate impact and corrosion.

- Grinders
- Crushers
- Excavation Buckets
- Ripper Teeth
- Bulldozer Blades
- Scrapers

