



Enhanced formula

**EnD0tec® DO\*327**

**Eutectrode® 6327 XHD**  
Welding



**For wearfacing against combined Abrasion and Impact**

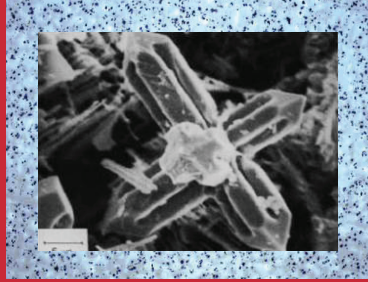
- improved combined abrasion and impact wear resistance
- multiple pass, crack-free coatings up to 15 mm thickness
- sustains hardness up to 550°C
- slag and spatter-free deposit
- thick deposits resistant to stress relief cracking and spalling
- excellent weldability, deposition rate and performance

# EnDotec® DO\*327 & 6327 XHD

## New formula DO\*327 & 6327 XHD

This new advanced DO\*327 & 6327 XHD formula provides the following ADDITIONAL enhanced benefits over other alloys in its category:

- INCREASED precipitation of ultra hard cubic carbide phases finely dispersed within an extremely tough matrix
- INCREASED abrasion resistance substantiated by ASTM G65 and G99 test results
- INCREASED weld resistance to internal stress relief cracking
- INCREASED resistance against spalling caused by external impact, shocks or pressure
- INCREASED hardness of the weld metal up to 59 HRC



High concentration of fine Nb, V and Cr carbides finely dispersed in a tough matrix of martensite and residual austenite

Crystallographic structure of ultra-hard cubic phase (NbC)

## Applications

Developed for wear protective coatings on carbon steel, alloy steel and austenitic manganese steel.

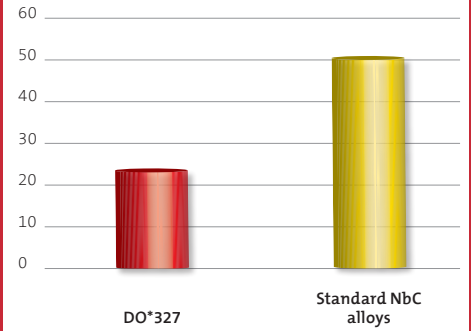
Typical sectors where this product is applied include:

**Cement, mining, drilling, quarries, public works, tools and dies, etc.**

**Hammers, rolls, anvils and crusher casings.**

**Mechanical loader bucket edges and teeth.**

Volume loss (mm³)



Hardox - 450

Martensitic steel (58 HRC)

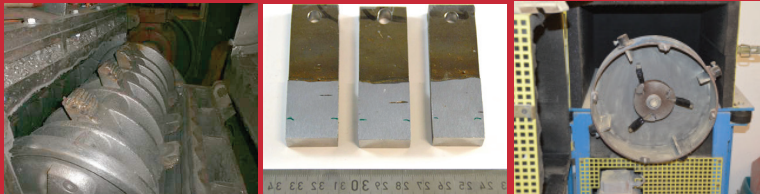
DO\*327



Uground cracker (DO\*15+WC)

Ground cracker (DO\*15+WC)

Titanium carbides

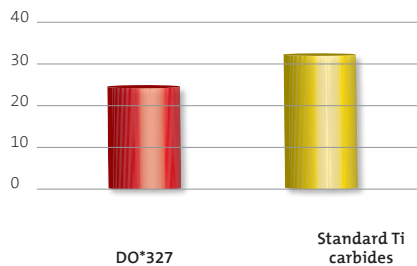


Combined Impact / Abrasion wear testing in special Impellor-Tumbler chamber

## New Impact/Abrasion tests and results

DO\*327 and 6327 XHD optimised microstructure minimises residual stresses and eliminates microcracking even in multipass welds. This ensures greater wear resistance to combined effects of high impact / abrasion forces.

Volume loss (mm³)



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