

# RANITE<sup>®</sup> GX

## General Description

**Ranite GX** is specially formulated to weld dissimilar steels: high carbon, tool and die steels; stainless steels; spring and coil steels; pressure vessels and aircraft steels. This is the prime AC-DC electrode to use where high strength and porosity-free deposits are required. It is the perfect composition to use where the alloy content of the base metal is unknown. Weld deposits are abrasion, impact, heat and corrosion resistant. Typical applications include the underlaying of hardfacing alloys in mining applications, rebuilding shafts and agitator blades in turbines, frames, cast steel parts and gears.

## Welding Parameters

<i>Size</i>	<b>3/32"</b>	<b>1/8"</b>	<b>5/32"</b>	<b>3/16"</b>
<i>Amperage</i>	40-90	75-125	100-150	140-240

## Deposit Characteristics

Tensile Strength	120,000 psi
Yield Strength	90,000 psi
Elongation	35%
Hardness as deposited	300 Brinell
Workhardens fairly rapidly	
Impact Resistance	Excellent
Frictional Resistance	Excellent
Heat Resistance	High
Abrasion Resistance	Mild
Will not respond to heat treatment	

## Preparatory and Welding Procedures

Work area must be clean. Bevel thick deposits. A preheat of 400° F is recommended for carbon and cast steels. Maintain a short arc, slightly inclined in the direction of travel. Apply in stringer beads. Peening is recommended.

**RANKIN<sup>®</sup>**

Hardfacing Products

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