

# RANOMANG 1

## General Description

Ranomang 1 is an outstanding **OPEN ARC WIRE**. Deposits of Ranomang 1 are excellent work hardening austenitic manganese steel alloys. It can be used for build-up or overlay on manganese steel, carbon and low alloy steels. It is designed to join austenitic manganese steel to austenitic manganese steel. Deposits are very tough and work harden rapidly under high impact.

**Typical applications:** Crusher rolls and cones, hammer mill hammers, impactor bars, railroad frogs and crossings.

## Welding Parameters

Diameter	0.045"	1/16"	7/64"
Current	DCRP	DCRP	DCRP
Amperage	145-195	150-275	350-450
Voltage	18 – 24	25 – 28	26 - 30
Shielding Gas	None	None	None
Wire Extension	1/2" – 3/4"	1" – 1 1/4"	1 1/2" – 2"

## Deposit Characteristics

Deposit Layers	Multiple
Hardness as Deposit	HRC-15-20
Work Hardened	HRC 50-55
Impact Resistance	High
Abrasive Resistance	Fair
Surface Cross Check	None
Flame Cut	No
Machinability	Poor

## Deposit Chemistry

C	Mn	Si	Cr	Ni	Fe
0.3	15.0	0.3	3.6	3.5	Balance

**RANKIN**®

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