

RANOMANG 3

General Description

Ranomang 3 is an outstanding **OPEN ARC WIRE**. Deposits of Ranomang 3 are excellent work hardening high chromium austenitic manganese steel alloys. It can be used for build-up or overlay on manganese steel, carbon and low alloy steels. It can also join austenitic manganese steel to manganese steel as well as carbon steel and low alloy steel. Deposits are very tough and work hardens 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	175-500
Voltage	18 – 24	25 – 28	28-32
Shielding Gas	None	None	None
Wire Extension	1/2" – 3/4"	3/4" – 1 1/4"	1" – 1 1/2"

Deposit Characteristics

Hardness as Deposit	HRC 18-23
Work Hardened	HRC 50-55
Tensile Strength	129,000 psi
Yield Strength	93,000 psi
Elongation 2"	40%
Impact Resistance	High
Abrasive Resistance	Fair

Deposit Chemistry

C	Mn	Si	Cr	Ni	Fe
0.3	16.0	0.3	15.0	0.5	Balance

RANKIN®

Hardfacing Products

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