

# RANOMATIC<sup>®</sup> BU/BU-G

## General Description

The Ranomatic – BU-G and BU-O alloys are an ideal choice for buildup of carbon and low alloy steels. Its composition is similar to low alloy steel. It has excellent compressive strength and toughness – will not mush out under heavy loading. Deposit is crack-free, machinable and can be flame cut. Maximum deposit is unlimited.

**Typical applications:** Buildup of carbon steel parts prior to hardfacing, rollers, sheaves, couplings and guides. Buildup of shovel rolling parts. Final overlay on gears and shafts.

<u>Welding Parameters</u>	<u>BU-O</u>	<u>BU-G</u>
Diameter	1/16"	.045"
Current	DCRP	DCRP
Amperage	175 – 350	150 - 200
Voltage	24 – 28	22 - 26
Shielding Gas	Open arc wire or CO <sub>2</sub>	CO <sub>2</sub> or 75% Ar/25% CO <sub>2</sub>
Wire Extension	1/2" - 1"	1/2" – 3/4"

## Deposit Characteristics

Hardness (two layers)	HRC 22 – 28
Abrasion Resistance	Moderate
Impact Strength	Excellent
Machinability	Excellent
Thickness	Unlimited layers
Deposit cross check	No

## Deposit Chemistry (typical)

C	Mn	Si	Cr	Others	Fe
0.1	1.6	0.5	0.5	1.0	Balance

**RANKIN<sup>®</sup>**

Hardfacing Products

Rankin<sup>®</sup> Industries, Inc.  
400 S. Rockefeller Ave.  
Ontario, CA 91761  
909.483.3222  
Toll Free 800.854.2159  
Fax 909.483.3233  
Email [sales@rankin.com](mailto:sales@rankin.com)

**BROCO | RANKIN**

Revised: 8/15/2016