

# RANOMATIC<sup>®</sup> DD-G

## General Description

Ranomatic DD-G is a flux cored wire. It is a general-purpose hardfacing alloy, which provides a good balance of abrasion and impact resistance. It can be used for metal-to-metal friction applications as well as metal-to-earth abrasion.

**Typical applications:** Shafts, Idlers, metal-to-metal construction parts.

## • Welding Parameters

Diameter	1/16"	0.045"
Current	DCRP	DCRP
Amperage	175 – 350	150 – 250
Voltage	24 – 28	22 – 26
Shielding Gas	CO <sub>2</sub> or Mix gas	CO <sub>2</sub> or Mix gas
Wire Extension	½" – 1"	½" – ¾"

## • Deposit Characteristics

Hardness (two layers)	HRC 53 - 56
Abrasion Resistance	Good
Impact Resistance	Good
Adhesive Resistance	Good
Machinability	Good
Thickness	2 – 3 layers recommended (Multiple layers with proper procedures)
Deposit cross check	No

## • Deposit Chemistry

C	Mn	Si	Cr	Mo	Fe
0.6	1.5	1.5	6.0	0.7	Balance

**RANKIN<sup>®</sup>**

Hardfacing Products

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