

# RANOMATIC® R-100HD

- **General Description**

Deposits of Ranomatic R-100HD are the ultimate high chromium carbide-surfacing alloys. It can be used on components subject to the most extreme abrasive wear combined with low to moderate impact. It can also be used where high temperature (1100°F) wear resistance is required.

**Typical applications:** crushing rolls, grinding equipment, tillage tools, shovel teeth, augers, slag-handling equipment, pipe I.D., Coal Pulverizer Roll

- **Welding Parameters**

Diameter	7/64"	1/8"
IPM	75 – 300	75 - 250
Amperage	225 – 500	290 - 600
Voltage	27 - 33	28 - 33
Shielding Gas	None, open arc	None, open arc
Wire Extension	1 – 1 ½"	1 – 1 ½"

- **Deposit Characteristics**

Hardness (two layers)	HRC 57 – 64
Abrasion Resistance	Outstanding
Impact Strength	Moderate
Retains properties to:	1100°F
Machinability	Grinding only
Thickness	2 – 4 layers recommended (multiple layers with proper procedures)
Deposit cross check	yes

- **Deposit Chemistry**

C	Mn	Si	Cr	Fe
6.0	1.7	0.4	30.0	Balance

**RANKIN®**  
Hardfacing Products

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