

RANOTUNG WC

General Description

A 40% and 60% blend of cast tungsten carbide particles in a tough steel matrix. Deposit of Ranotung WC is a sandpaper-like appearance. It can be used on components subject to extreme earth abrasion.

Typical applications: scrapping, cutting, digging and handling of highly abrasive earth-like materials. Examples are: dredge cutter blades, augers, conveyor flights, scraper blades any ground engagement tool, and tool joints.

Welding Parameters

Diameter	1/16"	7/64"
Current	DCRP	DCRP
Amperage	100 – 200*	150-250*
Voltage	22 – 28*	24-30
Shielding Gas	Open arc wire or CO ₂	Same
Wire Extension	½" – ¾"	½" – 1"
Maintaining Short Arc	If possible	Same

* DC reverse and lowest practical current setting is recommended. High current setting will dissolve tungsten carbide particle in the matrix.

Deposit Characteristics

Abrasion Resistance	Outstanding
Impact Strength	Light
Machinability	Not applicable
Thickness	2 layers maximum**
Deposit cross check	yes
Approximate Hardness	Moh's 9-10

** 1 layer is recommended

Deposit Chemistry Typical % by Weight

<u>1/16"</u>	<u>5/32"</u>	<u>7/64"</u>
W ₂ C/WC	W ₂ C/WC	W ₂ C/WC
40	60	60

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Revised: 8/15/2016