

# RANTUNG 60, 60F

## General Description

A 40% and 60% blend of cast tungsten carbide particles in a tough steel matrix. Deposit of Rantung 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 and tool joints.

## Welding Parameters

Diameter	1/8"	5/32"	3/16"
Current	DC/AC reverse polarity	same	same
Amperage	80*	110*	135*

Oxygen acetylene gas with bare rod; Use excess acetylene feather (3x)

\* 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	Low
Machinability	Not applicable
Thickness	2 layers maximum**
Deposit cross check	yes

\*\* 1 layer is recommended

## Nominal Chemistry:

Mn	WC/W2C	Fe
1.0	59	BAL

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