

RANITE[®] 35

General Description

Ranite 35 is an excellent solid core extruded electrode with a proprietary coating. Slag removal is easy. Ranite 35 is excellent for overlaying surface subjected high stress gouging-wear condition with moderate impact. It retains hardness at relatively high temperatures.

Typical applications

Ripper teeth, dozer end bits & blades, shovel buckets & teeth, dragline buckets & chains, ditcher teeth, tampers, crusher rolls, tripper bars, grizzly bars, hammers, cones, rotary screens, agricultural tools.

Welding Parameters

<i>Size</i>	1/8"	5/32"	3/16"	1/4
<i>Amperage</i>	90-140	120-180	170-230	250-310

Deposit Characteristics

Abrasion Resistance	Excellent
Compressive Strength	High
Impact Resistance	Moderate
Heat Resistance	to 950°F
Hardness on carbon steel	53 – 57 (2 layer deposit HRC)
On Manganese steel	50 – 53 (2 layer deposit HRC)
Surface checks	Yes
Machinability	No
Forgeable	No
Maximum Number Layers	2

Welding Procedures

Can be applied AC or DC, either polarity (reverse preferred), using either stringer or weave beads. Electrode can be dragged if desired. Out-of-position weldability is excellent and slag is self-peeling.

RANKIN[®]

Hardfacing Products

Rankin[®] 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

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