RANITE[®] M

General Description

Ranite M is a super welding performance solid core extruded electrode with a proprietary coating. Remarkable smooth welding arc product eclipses anything previously available; no other high-alloy hardfacing product on the market matches its operator appeal; effortless easy arc with self peeling slag.

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

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

Deposit Characteristics

Abrasion Resistance Excellent
Compressive Strength High
Impact Resistance Good
Corrosion Resistance Good
Heat Resistance to 800°F

Hardness on carbon steel 45 – 48 (2 layer deposit HRC)

on manganese steel 42 – 46 (2 layer deposit HRC)

Surface checks Yes
Machinability 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.



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