

# RANMANG 1

## General Description

Ranmang 1 is an outstanding **STICK ELECTRODE**. Deposits of Ranmang 1 are excellent work hardening austenitic manganese steel alloys. It can be used for build-up or overlay on manganese steel, carbon and low alloy steels. It is designed to join austenitic manganese steel to austenitic manganese steel. Deposits are very tough and work harden rapidly under high impact.

**Typical applications:** Crusher rolls and cones, hammer mill hammers, impactor bars, railroad frogs and crossings.

## Welding Parameters

Diameter	1/8"	5/32"	3/16"
Current	DCRP	DCRP	DCRP
Amperage	125-140	140-160	175-200

## Deposit Characteristics

Deposit Layers	Multiple
Hardness as Deposit	HRC 15-22
Work Hardened	HRC 50-55
Impact Resistance	High
Abrasive Resistance	Fair
Surface Cross Check	None
Flame Cut	No
Machinability	Poor

## Deposit Chemistry

C	Mn	Si	Cr	Ni	Fe
0.3	15.0	0.3	3.6	3.5	Balance

**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](mailto:sales@rankin.com)