

RANMANG 3

General Description

Ranmang 3 is an outstanding **STICK ELECTRODE**. Deposits of Ranmang 3 are excellent work hardening high chromium austenitic manganese steel alloys. It can be used for build-up or overlay on manganese steel, carbon and low alloy steels. It can also join austenitic manganese steel to manganese steel as well as carbon steel and low alloy steel. Deposits are very tough and work hardens 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

Hardness as Deposit	HRC 18-23
Work Hardened	HRC 50-55
Tensile Strength	129,000 psi
Yield Strength	93,000 psi
Elongation 2"	40%
Impact Resistance	High
Abrasive Resistance	Fair

Deposit Chemistry

C	Mn	Si	Cr	Ni	Fe
0.3	16.0	0.3	15.0	0.5	Balance

RANKIN®

Hardfacing Products

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