

RANOMATIC® 969-G

General Description

Ranomatic 969G is a general-purpose hardfacing alloy, which provides a good balance of abrasion and impact resistance. It can be used for metal-to-metal friction applications as well as metal-to-earth abrasion.

Typical applications: Mining parts, metal-to-metal construction parts, dredge components, extruder screws and agricultural tillage tools.

• Welding Parameters

Diameter	1/16"	0.045"	0.035"
Current	DCRP	DCRP	DCRP
Amperage	175 – 350	150 – 250	90-150
Voltage	24 – 28	22 – 26	17-22
Shielding Gas	Mix gas	Mix gas	Mix gas
Wire Extension	1/2" – 1"	1/2" – 3/4"	1/2" – 3/4"

• Deposit Characteristics

Hardness (two layers)	HRC 55 - 60
Abrasion Resistance	Good
Impact Resistance	Good
Adhesive Resistance	Good
Machinability	Grinding only
Thickness	2 – 3 layers recommended (multiple layers with proper procedures)
Deposit cross check	No

• Deposit Chemistry

C	Mn	Si	Cr	Mo	Fe
0.6	1.6	1.5	6.6	0.7	Balance

RANKIN®

Hardfacing Products

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