

RANOMATIC[®] M-7

General Description

This is a metal cored wire using Argon or Argon with 2% Oxygen as shielding gas. The deposits provide excellent metal-to-metal wear resistance and edge retention. The maximum deposit thickness is determined by work piece mass; crack-free deposits can be made with proper preheat and postweld heat treatment procedure. Deposits require rigid, well-powered equipment and carbide tools for machining. Deposits are difficult to flame-cut, but will withstand high compressive loading and impact resistance. Typical applications include carpet cutting knife, tire shredder knife and die repair.

Welding Parameters

Diameter	.045"	1/16"
Current	DCRP	DCRP
Amperage	175-250	200-300
Voltage	25-30	25-31
Shielding Gas	Argon or 98% Ar 2 O ₂	Argon or 98% Ar 2% O ₂
Wire Extension	3/8" – 5/8"	1/2" – 1"

Typical Rockwell Hardness

Two Layer	60 - 64
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Deposit Characteristics

Abrasion Resistance	Excellent for metal-to-metal wear
Impact Resistance	Very good
Machinability	With Carbide tools
Thickness	Depends on work piece size
Check Free Deposits	Use proper pre-heating and slow cooling

Typical Wire Chemistry

C	Mn	Si	Cr	W	V	Mo	Fe
1.0	0.3	0.3	3.8	1.8	2.0	8.8	Balance

RANKIN[®]

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