

# RANOMATIC<sup>®</sup> R-100

- **General Description**

Deposits of Ranomatic R-100 are the ultimate high chromium carbide-surfacing alloys. It can be used on components subject to the most severe abrasive wear combined with low to moderate impact. It can also be used where high temperature (1100°F) wear resistance is required.

**Typical applications:** crushing rolls, grinding equipment, tillage tools, shovel teeth, augers, slag-handling equipment, pipe I.D.

- **Welding Parameters**

Diameter	0.045"	1/16"	5/64"	7/64"
Current	DCRP	DCRP	DCRP	DCRP
Amperage	150-200	175 - 350	250 - 400	350 – 550
Voltage	21-28	26-32	28 – 32	30-38
Shielding Gas	None, open arc	None, open arc	None, open arc	None, open arc
Wire Extension	½" – ¾"	½" – 1 ¼"	1" – 1 ¼"	1" – 1 ½"

- **Deposit Characteristics**

Hardness (two layers)	HRC 58 – 62
Abrasion Resistance	Outstanding
Impact Strength	Moderate
Retains properties to:	1100°F
Machinability	Grinding only
Thickness	2 – 3 layers recommended (Multiple layers with proper procedures)
Deposit cross check	yes

- **Deposit Chemistry**

C	Mn	Si	Cr	Mo	B	Fe
5.2	1.3	1.1	25.1	1.2	0.2	Balance

**RANKIN<sup>®</sup>**

Hardfacing Products

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