

RANOMATIC[®] R-101

- **General Description**

Deposits of Ranomatic R-101 are similar to high chromium carbide hardfacing alloy. 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: shovel teeth, blades, ripper shanks, scraper sides, cutters, bucket sides and lips, tillage tools, conveyor screws, augers and auger flights

- **Welding Parameters**

Diameter	0.045"	1/16
Current	DCRP	DCRP
Amperage	150-200	175 - 350
Voltage	21-28	24 - 28
Shielding Gas	Open arc wire or CO ₂	Open arc wire or CO ₂
Wire Extension	½" – ¾"	½" - 1"

- **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	Others	Fe
5.5	1.0	0.8	18.3	0.3	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