

# PRODUCT DATA SHEET

## Ranomatic D

Ranomatic D is a self-shielding flux cored wire that deposits a chromium boron weld metal. The deposited metal has excellent resistance to severe abrasion, moderate impact and high compressive loads.

### Applications

Ranomatic D is suitable for hardfacing of dredger cutter teeth, tool joints, drill collars and tillage tools. Deposits should be limited to two layers and develop cross checks.

### Typical Chemical Analysis (All weld metal)

% Manganese	0,9	% Chromium	26,5
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### Typical Mechanical Properties

Hardness	62-64 HRc
Abrasion Resistance	Excellent
Impact Resistance	Poor
Machinability	Grinding is difficult
Flame Cutting	Cannot be flame cut
Thickness	3 layers max
Microstructure	Massive chrome carbide in an austenite-carbide matrix

Deposit will relief check crack

Maintains hot hardness to 675°C

### Welding Data

(Ranomatic D can be welded on either DC+ or DC- however DC+ is recommended. For increased deposition rates use DC-)

Diameter (mm)	Current		Electrode Stick Out
	Amps (A)	Volts (V)	
1,6	175 - 350	24 - 28	20 - 25

### Packing Data

Diameter (mm)	Spool Mass (kg)	Spool Type	Item Number
1,6	15,0	Wire Basket	W077066

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