

RANKIN Build-Up and Hardfacing Electrodes & Wires



Electrodes

Build Up of Carbon Steel

BUILD UP (Similar to *STOODY Build Up LH, McKay Hardalloy 32, Lincoln Wearshield BU)

DIA	PART No.	PRICE	Pack Weight
1/8"	BU18-10	\$32.50	10 lb.
5/32"	BU532-10	\$31.50	10 lb.
3/16"	BU316-10	\$30.50	10 lb.

Build Up & Joining of Carbon & Manganese Steel

Ranrang 3 (Similar to *STOODY 2110, McKay Chrome-Mang, Lincoln Wearshield 15 CrMn)

DIA	PART No.	PRICE	Pack Weight
1/8"	M318-10	\$62.50	10 lb.
5/32"	M3532-10	\$54.90	10 lb.
3/16"	M3316-10	\$51.60	10 lb.

Metal-To-Earth Wear (For Moderate to Severe Impact & Moderate to Severe Abrasion)

Ranite C Tubular Core (Similar to *STOODY 21, McKay Hardalloy 140, Lincoln Wearshield ABR)

DIA	PART No.	PRICE	Pack Weight
1/8"	RC18-10	\$65.20	10 lb.
5/32"	RC532-10	\$60.50	10 lb.
3/16"	RC316-10	\$56.80	10 lb.

Ranite 35 (Similar to *STOODY 35 Solid Core, McKay Hardalloy 140, Lincoln Wearshield ME)

DIA	PART No.	PRICE	Pack Weight
3/32"	35332-10	\$123.00	10 lb.
1/8"	3518-10	\$109.50	10 lb.
5/32"	35532-10	\$99.90	10 lb.
3/16"	35316-10	\$99.90	10 lb.

Build Up of Cast Iron

(Use Nickel 55 Cast Iron Welding Electrode)

Metal-To-Metal Wear

Ranite A (Similar to *STOODY 1105, McKay Hardalloy 32, Lincoln Wearshield MM & 40)

DIA	PART No.	PRICE	Pack Weight
1/8"	RA18-10	\$45.50	10 lb.
5/32"	RA532-10	\$39.90	10 lb.
3/16"	RA316-10	\$37.70	10 lb.

Wires

Industry's First No Gas Required!

.035" Tubular High Alloy Hardfacing Wire

Ranomatic "D" (a welder's favorite for over forty five years, in larger diameters) produces the hardest iron-based overlay at 62 - 64 Rockwell C. A highly refined grain structure provides the ultimate wear resistance. Can be applied to carbon, alloy and manganese steels and cast iron. Now available in a small .035" (0.9mm) diameter Ranomatic "D" is self-shielding; however, gas coverage improves welding characteristics slightly.

Typical applications include tillage tools, bucket teeth and lips, extruder screws, tamper feet, cutter teeth, and other fine-edged parts.

Runs on 17-22 Volts (DC+) @ 90-150 Amps 1/2" - 3/4" Wire Stick-Out

SMALL DIAMETER (.045 & 1/16) GAS-SHIELDED IRON-BASE HARDFACING WIRES

RANO MATIC	PART NO.	PRICE Per	SPOOL SIZE	DIA	TYPICAL APPLICATION
BUG	BUG045-10	\$6.59	10LB	.045	An outstanding gas-shielded buildup wire with excellent compressive strength and resistance to plastic deformation.
	BUG045-25	\$6.07	25LB	.045	
	BUG116-10	\$5.55	10LB	1/16	
BBG	BBG045-10	\$6.98	10LB	.045	High deposition wire with good abrasion resistance and severe impact. Deposits consist of chromium carbides in a semi austenetic matrix.
	BBG045-25	\$6.48	25LB	.045	
	BBG116-10	\$6.44	10LB	1/16	
DDG	DDG045-10	\$7.80	10LB	.045	High carbon, high chromium premium deposits provide excellent resistance to severe abrasion and moderate impact
	DDG045-25	\$7.28	25LB	.045	
	DDG116-10	\$6.57	10LB	1/16	
	DDG116-25	\$6.06	25LB	1/16	

- Ideal for small 110 Volt MIG welders
- Eliminates distortion
- Smooth arc transfer
- Fast-freezing slag

Part Number	Spool	Price Spool
DGS035-10	10lb	\$199.00
DGS035-25	25lb	\$481.25



DEPOSIT CHARACTERISTICS (.045" Dia)

.045"175-225	Typical Rockwell C hardness:
Volts:18-24	On .10% C steel24-28
Gas: .98% Ar, 2% O ₂	On .40% C steel30-35
Unlimited layers.	On .80% C steel38-42
.045"150-250	Typical Rockwell C hardness:
Volts21-26	As deposited..... 40-47
Gas:75% Ar, 25% CO ₂ or 100% CO ₂	Three layer maximum
.045"150-250	Typical Rockwell C hardness:
Volts21-26	As deposited 53-56
Gas:75% Ar, 25% CO ₂ or 100% CO ₂	Excellent check pattern
	Hot wear service to 900°F

* Stody Industrial & Welding Supply, Inc. (SIWS) is not sponsored, affiliated or in any way related to "STOODY COMPANY", a division of THERMADYNE INDUSTRIES, INC. **OTHER ALLOYS & SIZES AVAILABLE CALL**

HARDNESS CONVERSION TABLE

HARDNESS # BRINELL	"C" SCALE - VICKERS	"B" SCALE - ROCKWELL	TON/SQ.INS. U.T.S.
780	1150	70	—
745	1050	68	—
712	960	66	—
682	885	64	—
653	820	62	—
627	765	60	—
601	717	58	—
578	675	57	—
555	633	55	—
534	598	53	—
514	567	52	—
495	540	50	—
477	515	49	—
461	494	47	—
444	472	46	—
429	454	45	—
415	437	44	—
401	420	42	—
388	404	41	—
375	389	40	—
363	375	38	—
352	363	37	—
341	350	36	—
331	339	35	—
321	327	34	—
311	316	33	(108)
302	305	32	(107)
293	296	31	(106)
285	287	30	(105)
277	279	29	(104)
269	270	28	104
262	256	26	103
255	253	25	102
248	248	24	102
241	241	23	100
235	235	22	99
229	229	21	98
223	223	20	97
217	217	(18)	96
212	212	(17)	96
207	207	(16)	95
202	202	(15)	94
183	183	(9)	90
163	163	(3)	85
146	146	—	80
121	121	—	70
101	101	—	60