

Instructions for the AZ Weld Lobe Form

GENERAL:

1. This form finds the best current and time for a given weld force.
2. As tests are performed, the growing chart indicates where the next test should be done.
3. Enter these on a laptop as you test, so that the chart can guide you.
4. Entering the values later will only make you want to do the test again, so please consider item 3 above.

DIRECTIONS:

First, clear out cells B5 through L24

1. (Optional) Setup slope or preheat to condition the surface. Usually NOT done with projections.
2. Pick a Force (One chart per force setting)
3. Make sure electrodes are parallel (Carbon paper test)
4. Pick a cycle time, enter it here (The 3 boxes below will auto-fill with the same value.)
5. Pick a current, weld, test it, and enter the results in one of three areas:

Acceptable:

"too Hot" means you are wrecking the part somehow.

Too Hot:

Cold:

6. Notice that the chart starts to build from this data.
7. Repeat step 5 until the "area of weldability" is clearly defined.
8. After this, try another electrode force, use a new chart.

Enter data here:		CURRENT IN KILOAMPS Enter KA under results									
		ACCEPTABLE				TOO HOT			COLD		
		Column #: A B C D E F G H I J									
Row#	Heat Cyc	-----				X	X	X	O	O	O
1											
2											
3											
4											
5											

Enter data here:		CURRENT IN KILOAMPS Enter KA under results									
		ACCEPTABLE				TOO HOT			COLD		
		Column #: A B C D E F G H I J									
Row#	Heat Cyc	-----				X	X	X	O	O	O
1	4	13.2	17.5	15.0	16.0	18.0	18.5	12.2	12.7		
2	4	13.9									
3	4										
4	4										
5											

Here is an example: →

Label each sample with the row-column numbers, i.e. "1B"

9. When the chart is filled out, the widest current range is identified, and a recommendation is made.

19										
20										
		No. of entries made: 42								
		Best current range: 6300 amps, occurring at: 3 cycles								
		I RECOMMEND 17055 AMPS AT 3 CYCLES								

