WELD LOBE FORM

Enter data here:

CURRENT IN KILOAMPS Enter KA under results

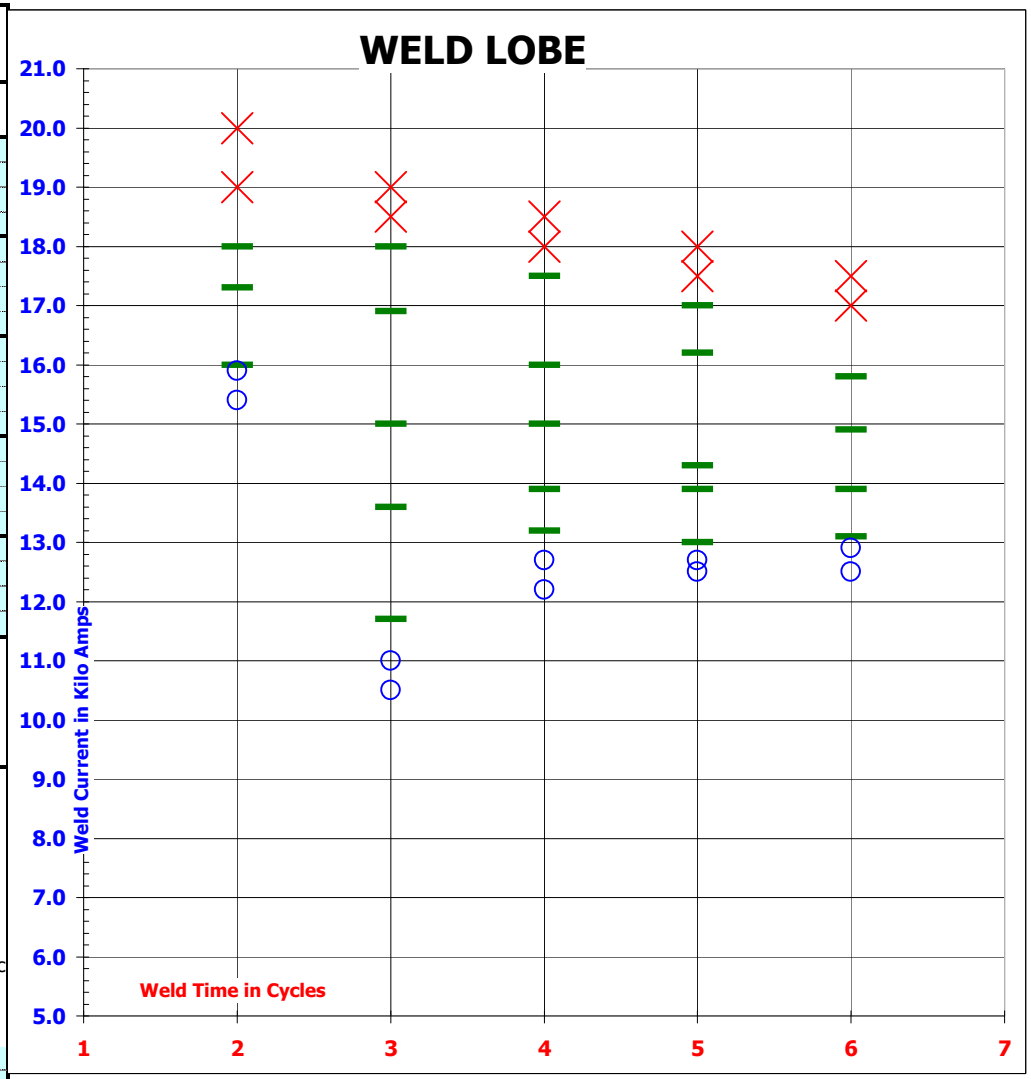
		ACCEPTABLE				TOO HOT			COLD		
Column #:		A	B	C	D	E	F	G	H	I	J
Row#	Heat Cyc	—	—	—	—	X	X	X	O	O	O
1	4	13.2	17.5	15.0	16.0	18.0	18.5		12.2	12.7	
2	4	13.9									
3	4										
4	4										
5	5	13.0	13.9	14.3		17.5	18.0		12.5	12.7	
6	5		17.0								
7	5			16.2							
8	5										
9	6	13.1		15.8		17.0	17.5		12.5	12.9	
10	6		13.9	14.9							
11	6										
12	6										
13	3	15.0	18.0			18.5	19.0		10.5	11.0	
14	3		16.9	11.7							
15	3			13.6							
16	3										
17	2	18.0	16.0	17.3		19.0	20.0		15.4	15.9	
18	2										
19	2										
20	2										

No. of entries made: **42**

Best current range: **6300 amps**, occurring at **3 cycles**

I RECOMMEND 17055 AMPS AT 3 CYCLES

	Date	**FINAL SCHEDULE:**			
	Job	**Force**		Lbs	PSI
	Location	**Slope**		Cycles	
	Part#	**Start KA**		KAmps	%
	Done by	**End KA**		KAmps	%
		Weld KA		KAmps	%
	Weld Count	**Weld Cyc**		@60Hz	
	Material	WelderType		(AC,MFDC,LFDC,etc	
	Fastener	**Impulses**		(0=1 pulse)	
	WeldSpec	**Cool**		Cycles	
		Hold		Cycles	
mm	**Min Button Dia**	**Tap(ratio)**			
mm	**Upper Tip Face**				
mm	**Lower Tip Face**	NOTES:			



Enter KA	Get %
% Heat	= KA
0	0