

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.
2. Pick a Force (One chart per force setting)
3. Condition caps with 25 welds.
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:

Expulsion:

Undersize:

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.

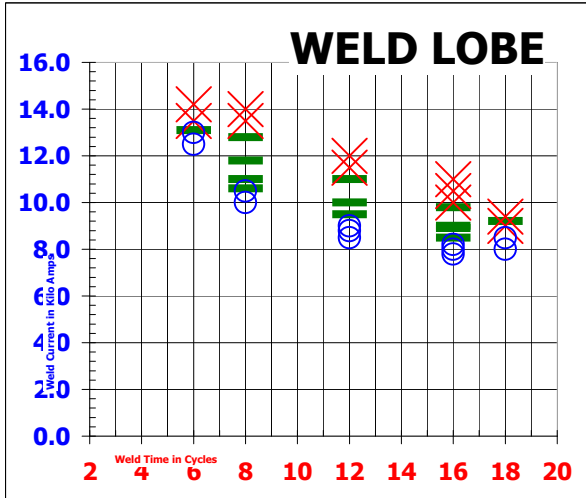
Enter data here:		CURRENT IN KILOAMPS Enter KA under results										
		ACCEPTABLE			EXPULSION			UNDERSIZE				
		Column #: A B C D E F G H I J										
Row#	Heat Cyc	-----			X	X	X	○	○	○		
1												
2												
3												
4												
5												

Enter data here:		CURRENT IN KILOAMPS Enter KA under results										
		ACCEPTABLE			EXPULSION			UNDERSIZE				
		Column #: A B C D E F G H I J										
Row#	Heat Cyc	-----			X	X	X	○	○	○		
1	12	10.0	11.0	9.5	11.5	12.0	9.0	8.5	8.8			
2	12											
3	12											
4	12											
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:		36							
		Best current range:		2200		amps, occurring at:		8		cycles	
		I RECOMMEND		12770		AMPS AT		8		CYCLES	