WELD LOBE FORM

Enter data here:

CURRENT IN KILOAMPS Enter KA under results

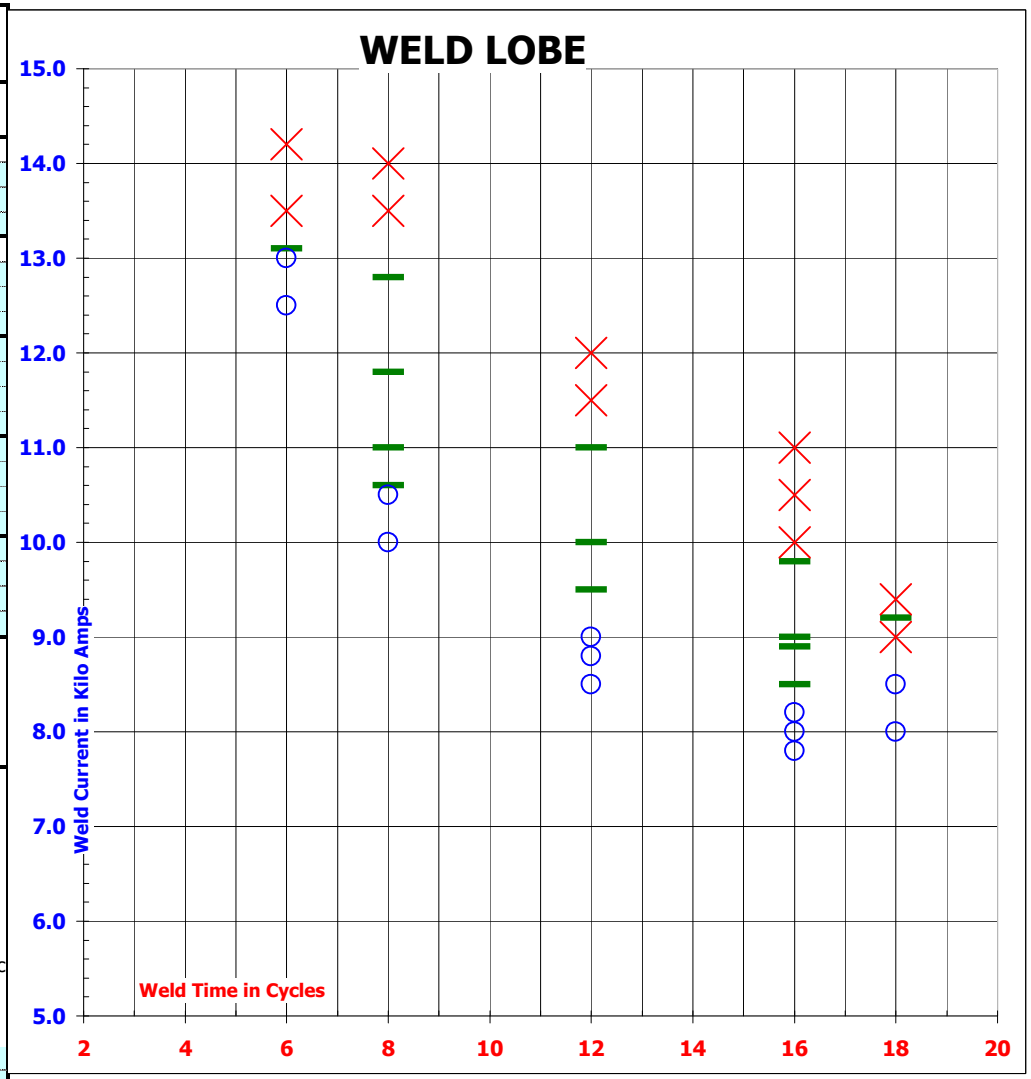
Column #:		A	B	C	D	E	F	G	H	I	J
		ACCEPTABLE				**EXPULSION**			**UNDERSIZE**		
Row#	**Heat Cyc**	—	—	—	—	X	X	X	O	O	O
1	12	10.0	11.0	9.5		11.5	12.0		9.0	8.5	8.8
2	12										
3	12										
4	12										
5	16	8.5	8.9	9.0	9.8	10.0	10.5	11.0	8.0	8.2	7.8
6	16										
7	16										
8	16										
9	8	10.6	12.8	11.0	11.8	14.0	13.5		10.0	10.5	
10	8										
11	8										
12	8										
13	6		13.1			13.5	14.2		13.0	12.5	
14	6										
15	6										
16	6										
17	18	9.2				9.0	9.4		8.5	8.0	
18	18										
19	18										
20	18										

No. of entries made: **36**

Best current range: **2200 amps**, occurring at **8 cycles**

I RECOMMEND 12770 AMPS AT 8 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