

Welding Problem Checklist

1. Identify the weld problem – check all that apply

- Parts do not gage after weld
- Parts look welded but fall off
- Excessive splatter or expulsion
- Weldment discoloration

2. What part are you welding

Part Number _____

3. Mating material

Material type _____

Material thickness _____

Material coating _____

4. Welder type –

Rocker arm

Press type

Welder size in KVA _____

5. Welder Settings

Pressure in psi. _____

Cylinder size in inches _____

6. Weld schedule

Squeeze time in cycle's _____

Weld time in cycle's _____

Hold time in cycle's _____

Percentage of current _____

Secondary Voltage tap regulator setting _____

Secondary amperage reading _____

Number of Impulses _____

7. Phase – check one if applicable

AC Single phase

AC Three phase

MFDC Single phase (Mid-Frequency Direct Current)

MFDC Three phase

8. Electrode tip

Tip diameter in inches _____

Insulated electrode yes no

Properly aligned yes no

Properly dressed yes no

Properly cooled internal external

Class of Copper (1, 2, 10, etc.) _____

If possible please submit pictures of welder, timer control, electrodes, and welded parts.