

Weld Settings • Stainless Steel Weld Nut



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Part Type	Thread Size		Material Thickness Range	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode. Dia.		Approx. KVA Welder Size
	Inch	Metri c		From	To	From	To	From	To	Nut Side	Sheet Side	
BTZ 	#10	---	20g to 13g	750	900	3	8	7,300	11,000	0.500	0.500	50

Part Type	Thread Size		Material Thickness Range	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode. Dia.		Approx. KVA Welder Size
	Inch	Metri c		From	To	From	To	From	To	Nut Side	Sheet Side	
PNZ 	#8	4mm	24g to 14g	750	900	4	6	6,800	8,500	0.625	0.625	30
	#10	5mm	24g to 14g	750	900	4	6	6,800	8,500	0.625	0.625	30
	1/4-20	6mm	24g to 13g	850	1,500	3	6	4,500	13,500	1.250	1.250	50-75
	5/16-18	---	20g to 11g	1,400	1,600	4	8	10,500	13,500	1.250	1.250	75
	3/8-16	---	20g to 11g	1,400	1,600	4	8	10,500	13,500	1.250	1.250	75

Part Type	Thread Size		Material Thickness Range	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode. Dia.		Approx. KVA Welder Size
	Inch	Metri c		From	To	From	To	From	To	Nut Side	Sheet Side	
RHZ 	#6	---	24g to 14g	750	900	4	10	7,800	12,500	0.625	0.625	30
	#8	---	24g to 14g	750	900	4	10	7,800	12,500	0.625	0.625	30
	#10	---	24g to 14g	850	1,500	4	8	7,500	18,000	0.750	0.750	75

 RNZ	1/4-20	---	20g to 11g	850	1,600	8	14	10,500	16,000	1.000	1.000	50-75
	5/16-18	---	20g to 11g	1,500	1,600	7	15	10,750	16,000	1.000	1.000	75-100
	3/8-16	---	18g to 11g	1,500	1,600	7	15	10,750	16,000	1.000	1.000	75-100
	Part Type	Thread Size	Material	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Welder Size
	Inch	Metri c	Thickness Range	From	To	From	To	From	To	Nut Side	Sheet Side	
	#8	4mm	24g to 14g	700	800	4	6	6,500	9,000	0.625	0.625	30
	#10	5mm	24g to 14g	700	800	4	6	6,500	9,000	0.625	0.625	30
	1/4-20	6mm	20g to 11g	850	1,500	3	6	11,500	13,500	0.813	0.813	30
	5/16-18	---	20g to 11g	1,400	1,600	4	8	11,000	14,000	1.000	1.000	75-100
	3/8-16	---	20g to 11g	1,400	1,600	4	8	11,000	14,000	1.000	1.000	75-100
 SNZ	Part Type	Thread Size	Material	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Welder Size
	Inch	Metri c	Thickness Range	From	To	From	To	From	To	Nut Side	Sheet Side	
	#8	4mm	24g to 14g	750	900	4	8	7,200	10,500	0.218	0.250	30
	#10	5mm	24g to 14g	750	900	4	8	7,200	10,500	0.218	0.250	30
	1/4-20	6mm	24g to 13g	850	1,250	2	8	10,000	11,000	0.250	0.250	40-75
	5/16-18	---	20g to 11g	850	1,500	4	10	10,800	13,000	0.312	0.375	40-75
3/8-16	---	20g to 11g	850	1,500	4	10	10,800	13,000	0.312	0.375	40-75	
 WFZ	Part Type	Thread Size	Material	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Welder Size
	Inch	Metri c	Thickness Range	From	To	From	To	From	To	Nut Side	Sheet Side	
	#6	---	20g to 14g	750	850	3	6	7,800	11,000	0.625	0.625	30
	#8	---	20g to 14g	750	850	3	6	7,800	11,000	0.625	0.625	30
	#10	---	20g to 13g	750	900	3	8	8,800	12,000	0.750	0.750	50
	1/4-20	---	20g to 11g	1,350	1,600	3	8	11,300	18,000	1.000	1.000	75-100
	5/16-18	---	16g to 11g	1,400	1,600	4	10	10,800	18,000	1.000	1.000	100
3/8-16	---	16g to 11g	1,400	1,600	4	10	10,800	18,000	1.000	1.000	100	

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	Inch	Metri c		From	To	From	To	From	To	Nut Side	Sheet Side	
 WTZ	#6	---	24g to 13g	750	900	4	7	7,000	10,300	0.625	0.625	30
	#8	---	24g to 13g	750	900	4	9	7,000	10,300	0.625	0.625	30
	#10	---	24g to 11g	700	900	4	9	7,800	13,000	1.000	1.000	50
	1/4-20	---	20g to 11g	1,300	1,600	4	9	11,600	14,500	1.000	1.000	100

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	Inch	Metri c		From	To	From	To	From	To	Nut Side	Sheet Side	
 WWZ	#6	---	24g to 13g	850	1,600	4	8	11,700	18,000	0.625	0.625	50
	#8	---	24g to 13g	850	1,600	4	8	11,700	18,000	0.625	0.625	50
	#10	---	24g to 11g	1,400	1,800	6	12	14,000	30,000	1.000	1.000	100-150
	1/4-20	---	20g to 11g	2,900	4,400	5	10	27,500	33,000	1.250	1.250	200
	5/16- 18	---	18g to 11g	3,500	4,400	7	12	33,300	35,000	1.250	1.250	200
	3/8-16	---	18g to 11g	3,500	4,400	7	12	33,300	35,000	1.250	1.250	200