

Weld Settings • Stainless Steel Weld Pin



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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
			From	To	From	To	From	To	Nut Side	Sheet Side	
 PGZ	0.119	24g to 14g	750	900	2	6	6,000	9,000	0.500	0.500	20
	0.144	24g to 14g	750	900	2	8	4,000	9,000	0.500	0.500	20
	0.163	20g to 14g	750	850	4	10	7,700	11,300	0.500	0.500	30
	0.190	24g to 14g	800	1,100	5	10	9,500	13,200	0.500	0.500	50
	0.250	20g to 13g	750	1,000	4	12	8,000	12,200	0.625	0.625	50
	0.335	20g to 11g	1,400	1,700	4	10	11,300	19,000	1.000	1.000	75-100
	0.375	20g to 11g	1,400	1,700	4	10	11,300	19,000	1.000	1.000	75-100

Part Type	Thread Size	Material Thickness Range	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode. Dia.		Approx. KVA Welder Size
			From	To	From	To	From	To	Nut Side	Sheet Side	
 PHZ	0.117	24g to 14g	750	900	2	6	4,000	9,000	0.500	0.500	20
	0.144	24g to 14g	750	900	2	8	6,000	9,000	0.500	0.500	20
	0.163	20g to 14g	750	850	4	10	7,700	11,300	0.500	0.500	30
	0.190	24g to 14g	800	1,100	5	10	9,500	13,200	0.500	0.500	50
	0.218	20g to 13g	750	1,000	5	12	8,000	12,200	0.625	0.625	50
	0.250	20g to 13g	750	1,000	4	12	8,000	12,200	0.625	0.625	50
	0.277	20g to 11g	750	1,000	5	12	8,000	12,200	0.625	0.625	50
	0.335	20g to 11g	1,400	1,700	4	10	11,300	19,000	1.000	1.000	75-100
	0.375	20g to 11g	1,400	1,700	4	10	11,300	19,000	1.000	1.000	75-100
	0.500	16g to 11g	1,400	1,800	4	10	11,000	16,500	1.000	1.000	100-150

Part Type	Thread Size	Material Thickness Range	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode. Dia.		Approx. KVA Welder Size
			From	To	From	To	From	To	Nut Side	Sheet Side	



0.119	24g to 14g	700	850	2	6	5,300	6,500	0.219	0.219	20
0.144	24g to 14g	700	850	2	8	5,500	6,700	0.219	0.312	20
0.163	24g to 14g	700	850	2	8	5,500	6,700	0.219	0.312	20
0.190	24g to 14g	700	850	2	8	5,500	6,700	0.219	0.312	20
0.218	20g to 13g	700	900	4	8	6,600	8,500	0.250	0.312	30
0.250	20g to 13g	850	1,450	4	8	6,400	13,900	0.250	0.312	50
0.277	18g to 11g	850	1,500	3	8	8,400	14,800	0.250	0.375	50-75