

Weld Settings



[Low Carbon  
Weld Screw Setup Data](#)


[Stainless Steel  
Weld Screw Setup Data](#)


[Low Carbon  
Weld Nut Setup Data](#)


[Stainless Steel  
Weld Nut Setup Data](#)


[Low Carbon  
Weld Pin and Special Purpose  
Welding Setup Data](#)


[Stainless Steel  
Weld Pin Setup Data](#)

Part Type	Thread Size		Material	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Welder Size
	Inch	Metric		Thickness Range	From	To	From	To	From	To	Nut Side	
 GWZ	#6	3.5mm	24g to 14g	750	900	2	6	6,000	9,000	0.500	0.500	20
	#8	4mm	24g to 14g	750	900	2	8	4,000	9,000	0.500	0.500	20
	#10	5mm	20g to 14g	750	850	4	10	7,700	11,300	0.500	0.500	30
	1/4-20	6mm	20g to 14g	750	850	4	12	8,000	12,200	0.500	0.500	50
	5/16-18	8mm	20g to 11g	1,400	1,600	4	8	11,200	18,300	0.750	0.750	100
	3/8-16	10mm	20g to 11g	1,400	1,700	4	10	11,300	19,000	1.000	1.000	100

Part Type	Thread Size		Material	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Welder Size
	Inch	Metric		Thickness Range	From	To	From	To	From	To	Nut Side	
 HWZ	#6	3.5mm	24g to 14g	750	900	2	6	6,000	9,000	0.500	0.500	20
	#8	4mm	24g to 14g	750	900	2	8	4,000	9,000	0.500	0.500	20
	#10	5mm	20g to 14g	750	850	4	10	7,700	11,300	0.500	0.500	30
	1/4-20	6mm	20g to 14g	750	850	4	12	8,000	12,200	0.500	0.500	50
	5/16-18	8mm	20g to 11g	1,400	1,600	4	8	11,200	18,300	0.750	0.750	100
	3/8-16	10mm	20g to 11g	1,400	1,700	4	10	11,300	19,000	1.000	1.000	100
	1/2-13	12mm	16g to 11g	1,400	1,800	4	10	10,700	16,500	1.000	1.000	100-150

Part Type	Thread Size		Material	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Welder Size
	Inch	Metric		Thickness Range	From	To	From	To	From	To	Nut Side	
 PDZ	#6	---	24g to 14g	800	900	4	8	3,500	7,700	0.500	0.500	30
	#8	---	24g to 14g	800	900	4	8	3,500	7,700	0.500	0.500	30
	#10	---	20g to 14g	800	950	3	8	2,700	10,300	0.625	0.625	30

Part Type	Thread Size		Material	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Welder Size
	Inch	Metric		From	To	From	To	From	To	Nut Side	Sheet Side	
			Thickness Range									
 RWZ	1/4-20	---	20g to 13g	850	1,500	4	8	6,700	10,300	0.750	0.750	50
	5/16-18	---	20g to 13g	1,500	1,650	3	8	9,500	12,000	0.875	0.875	50
	#6	---	24g to 14g	850	1,400	2	6	5,700	12,500	0.500	0.500	50-75
	#8	---	24g to 14g	850	1,400	3	6	10,800	13,500	0.500	0.500	50-75
	#10	---	20g to 14g	800	1,000	3	6	12,100	14,400	0.500	0.500	50-75
	1/4-20	---	18g to 11g	2,700	3,400	3	6	23,500	28,500	1.000	1.000	150
	5/16-18	---	18g to 11g	3,300	4,200	5	8	27,500	30,000	1.250	1.250	150
3/8-16	---	18g to 11g	3,500	4,200	6	10	29,500	32,500	1.250	1.250	200	

Part Type	Thread Size		Material	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Welder Size
	Inch	Metric		From	To	From	To	From	To	Nut Side	Sheet Side	
			Thickness Range									
 SSZ	#6	---	24g to 14g	700	850	2	6	5,300	6,500	0.219	0.219	20
	#8	---	24g to 14g	700	850	2	8	5,500	6,700	0.219	0.312	20
	#10	---	24g to 14g	700	850	2	8	5,500	6,700	0.219	0.312	20
	1/4-20	---	20g to 13g	700	900	4	8	6,600	8,500	0.250	0.312	30
	5/16-18	---	18g to 11g	850	1,500	3	8	8,400	14,800	0.312	0.375	50
	3/8-16	---	18g to 11g	1,450	1,550	7	12	10,900	19,400	0.312	0.375	75