

Weld Settings

Low Carbon Weld Pin & Special Purpose



[Low Carbon
Weld Screw Setup Data](#)


[Stainless Steel
Weld Screw Setup Data](#)


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Part Type	Thread Size		Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Size Welder
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	
KL 	.190	---	300	700	4	10	8,000	14,000	0.250	0.250	30

Part Type	Thread Size		Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Size Welder
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	
PC 	0.375	---	500	900	4	9	8,000	12,000	0.375	0.375	50
	0.750	---	900	1,400	5	10	10,000	18,000	0.750	0.750	75
	1.000	---	1,000	15,000	5	15	12,000	20,000	1.000	1.000	75

Part Type	Thread Size		Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Size Welder
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	
PG / PGM 	0.117	3mm	200	800	3	5	3,000	7,500	0.500	0.500	20
	0.144	---	300	800	3	5	3,700	8,500	0.500	0.500	20
	0.163	4mm	400	850	3	6	6,000	12,300	0.500	0.500	20
	0.190	5mm	600	900	3	7	7,000	13,200	0.500	0.500	30
	0.218	---	700	950	3	8	8,000	14,500	0.500	0.500	30
	0.250	6mm	700	950	3	8	8,000	14,500	0.500	0.500	30
	0.277	---	800	1,050	6	12	9,000	15,200	0.625	0.625	50
	0.335	8mm	900	1,150	7	14	10,000	16,100	0.750	0.750	50
0.375	10mm	900	1,150	7	14	10,000	161,000	0.750	0.750	50	

Part Type	Thread Size		Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Size Welder
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	
0.117	3mm	300	900	3	7	4,000	13,000	0.500	0.500	20	

PH / PHM



0.144	---	300	900	3	7	4,000	13,000	0.500	0.500	20
0.163	4mm	400	900	3	8	6,000	14,000	0.500	0.500	20
0.190	5mm	600	1,000	3	10	9,000	15,000	0.500	0.500	30
0.218	---	700	1,000	3	12	10,000	16,000	0.625	0.625	30
0.250	6mm	700	1,000	3	12	10,000	16,000	0.625	0.625	30
0.277	---	800	1,100	4	16	12,000	18,000	0.750	0.750	50
0.335	8mm	900	1,200	6	18	13,000	20,000	0.875	0.875	50
0.375	10mm	900	1,200	6	18	13,000	20,000	0.875	0.875	50
0.500	12mm	1,000	1,500	10	20	14,000	22,000	1.000	1.000	75

Part Type

SP



Thread Size	Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Size		
	Inch	Metric	From	To	From	To	Nut Side	Sheet Side			
0.117	---		300	700	4	10	8,000	14,000	0.250	0.250	20
0.144	---		300	700	4	10	8,000	14,000	0.250	0.250	20
0.163	---		300	700	4	10	8,000	14,000	0.250	0.250	20
0.190	---		300	700	4	10	8,000	14,000	0.250	0.250	20
0.218	---		500	900	6	12	12,000	18,000	0.312	0.312	50
0.250	---		600	1,000	8	15	12,000	18,000	0.312	0.312	50
0.277	---		800	1,300	10	25	14,000	20,000	0.375	0.375	75