

# Weld Settings • Low Carbon Weld Nut



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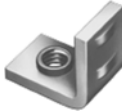
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Part Type	Thread Size		Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Size Welder
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	
	#8	4mm	700	1,000	4	7	9,000	14,000	0.500	0.500	50
	#10	5mm	700	1,000	4	7	9,000	14,000	0.500	0.500	50
	1/4-20	6mm	800	1,200	5	9	10,000	15,000	0.500	0.500	75
	5/16-18	8mm	1,000	1,300	8	10	12,000	17,000	0.625	0.625	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	
	#6	3.5mm	550	800	6	10	12,700	19,500	0.250	0.250	30
	#8	4mm	550	800	6	10	12,700	19,500	0.250	0.250	30
	#10	5mm	550	800	6	10	12,700	19,500	0.250	0.250	30
	1/4-20	6mm	800	1,300	8	15	14,000	20,000	0.312	0.312	50
	5/16-18	8mm	1,000	2,000	10	25	15,000	25,000	0.375	0.375	75
	3/8-16	10mm	1,000	2,000	10	25	15,000	25,000	0.375	0.375	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	
	#6	3.5mm	300	1,000	3	10	7,300	15,000	0.625	0.625	30
	#8	4mm	300	1,000	3	10	7,300	15,000	0.625	0.625	30
	#10	5mm	300	1,000	3	10	7,300	15,000	0.625	0.625	30
	1/4-20	6mm	700	1,300	3	10	8,500	16,000	0.813	0.813	50
	5/16-18	8mm	1,000	1,500	6	12	10,000	17,000	1.000	1.000	75
	3/8-16	10mm	1,000	1,500	6	12	10,000	17,000	1.125	1.125	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	




QN / QNM	#6	3.5mm	400	900	3	8	8,000	16,000	0.625	0.625	30
	#8	4mm	400	900	3	8	8,000	16,000	0.625	0.625	30
	#10	5mm	400	900	3	8	8,000	16,000	0.625	0.625	30
	1/4-20	6mm	800	1,200	4	10	13,000	20,000	0.813	0.813	50
	5/16-18	8mm	900	1,500	5	15	15,000	24,000	1.000	1.000	75
	3/8-16	10mm	900	1,500	5	15	15,000	24,000	1.000	1.000	75
1/2-13	12mm	1,000	3,500	6	16	20,000	35,000	1.250	1.250	100	

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




RD / RDM	#6	3 / 3.5mm	600	800	3	7	9,000	12,000	0.625	0.625	20
	#8	4mm	600	800	3	7	9,000	12,000	0.625	0.625	20
	#10	5mm	600	800	3	7	9,000	12,000	0.625	0.625	20
	1/4-20	6mm	600	900	6	10	9,000	14,000	0.875	0.875	30

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



RH / RHM	#6	3.5mm	700	1,000	3	12	10,000	16,000	0.625	0.625	30
	#8	4mm	700	1,000	3	12	10,000	16,000	0.625	0.625	30
	#10	5mm	800	1,100	4	16	12,000	18,000	0.750	0.750	50
	1/4-20	6mm	900	1,200	6	18	13,000	20,000	1.000	1.000	75
	5/16-18	8mm	1,000	1,500	10	20	14,000	22,000	1.000	1.000	75
	3/8-16	10mm	1,000	1,500	10	20	14,000	22,000	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
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	Welder



RN / RNM	#6	3.5mm	500	1,000	3	10	8,000	12,000	0.625	0.625	30
	#8	4mm	500	1,000	3	10	8,000	12,000	0.625	0.625	30
	#10	5mm	500	1,000	3	10	8,000	12,000	0.625	0.625	30
	1/4-20	6mm	700	1,300	4	12	9,000	16,000	0.813	0.813	50
	5/16-18	8mm	900	1,500	5	14	10,000	18,000	1.000	1.000	75
	3/8-16	10mm	900	1,500	5	14	10,000	18,000	1.000	1.000	75
1/2-13	12mm	1,000	1,700	6	16	11,000	20,000	1.125	1.125	75	


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



SF	5/16-18	---	1,500	3,000	10	25	30,000	50,000	1.125	1.125	200
	3/8-16	---	1,500	3,000	10	25	30,000	50,000	1.125	1.125	200
	1/2-13	---	2,200	3,700	15	25	30,000	50,000	1.125	1.125	200


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

#6	3.5mm	550	800	6	10	12,700	19,500	0.218	0.250	30
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SN / SNM	#8	4mm	550	800	6	10	12,700	19,500	0.022	0.250	30
	#10	5mm	550	800	6	10	12,700	19,500	0.250	0.250	30
	1/4-20	6mm	800	1,300	8	15	14,000	20,000	0.312	0.312	50
	5/16-18	8mm	1,000	2,000	10	25	15,000	25,000	0.375	0.375	75
	3/8-16	10mm	1,000	2,000	10	25	15,000	25,000	0.375	0.375	75

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




TP	#6	---	550	800	6	10	12,700	19,500	0.250	0.250	30
	#8	---	550	800	6	10	12,700	19,500	0.250	0.250	30
	#10	---	550	800	6	10	12,700	19,500	0.250	0.250	30
	1/4-20	---	800	1,300	8	15	14,000	20,000	0.312	0.312	50
	5/16-18	---	1,000	2,000	10	25	15,000	25,000	0.375	0.375	75
	3/8-16	---	1,000	2,000	10	25	15,000	25,000	0.375	0.375	75

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




WF / WFM	#6	3.5mm	700	950	3	8	8,000	14,500	0.625	0.625	30
	#8	4mm	700	950	3	8	8,000	14,500	0.625	0.625	30
	#10	5mm	800	1,050	6	12	9,000	15,200	0.750	0.750	50
	1/4-20	6mm	900	1,100	7	14	10,000	16,100	1.000	1.000	75
	5/16-18	8mm	1,000	1,200	8	15	12,000	18,000	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
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	Welder



WP / WPM	#6	3.5mm	400	900	3	8	8,000	16,000	0.625	0.625	30
	#8	4mm	400	900	3	8	8,000	16,000	0.625	0.625	30
	#10	5mm	450	950	3	10	11,000	16,000	0.625	0.625	50
	1/4-20	6mm	600	1,000	4	11	12,000	17,000	0.625	0.625	75
	5/16-18	8mm	800	1,100	5	12	13,000	18,000	0.750	0.750	75

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



WS / WSM	#6	3.5mm	400	900	3	8	8,000	16,000	0.625	0.625	30
	#8	4mm	400	900	3	8	8,000	16,000	0.625	0.625	30
	#10	5mm	450	950	3	10	11,000	16,000	0.625	0.625	50
	1/4-20	6mm	600	1,000	4	11	12,000	17,000	0.625	0.625	75
	5/16-18	8mm	800	1,100	5	12	13,000	18,000	0.750	0.750	75
	3/8-16	10mm	900	1,200	6	13	14,000	19,000	0.875	0.875	75

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

#6	3.5mm	800	1,000	4	9	9,000	15,000	0.625	0.625	30
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WT / WTM	Thread Size	Pressure Range in LBS.	Weld Cycles	Current in Secondary Amps.	Recommended Electrode Dia.	Approx. KVA Size
	#8	4mm	800 1,000	4 9	9,000 15,000	0.625 30
	#10	5mm	900 1,200	7 13	10,000 16,000	0.750 50
	1/4-20	6mm	1,000 1,300	8 15	11,000 17,000	1.000 75

Part Type	Thread Size		Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Size
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	
	#6	3.5mm	700	1,200	5	9	13,000	20,000	0.625	0.625	75



WW / WWM	Thread Size	Pressure Range in LBS.	Weld Cycles	Current in Secondary Amps.	Recommended Electrode Dia.	Approx. KVA Size
	#8	4mm	900 1,800	6 10	18,000 30,000	0.625 75
	#10	5mm	1,200 2,000	7 15	20,000 40,000	0.750 100
	1/4-20	6mm	1,600 3,000	8 20	25,000 50,000	1.000 150 - 200
	5/16-18	8mm	1,800 3,200	10 25	30,000 60,000	1.000 200
	3/8-16	10mm	1,800 3,200	10 25	30,000 60,000	1.000 200

Part Type	Thread Size		Pressure Range in LBS.		Weld Cycles		Current in Secondary Amps.		Recommended Electrode Dia.		Approx. KVA Size
	Inch	Metric	From	To	From	To	From	To	Nut Side	Sheet Side	
	#6	3.5mm	350	800	5	10	9,700	17,800	0.218	0.250	20



XN / XNM	Thread Size	Pressure Range in LBS.	Weld Cycles	Current in Secondary Amps.	Recommended Electrode Dia.	Approx. KVA Size
	#8	4mm	350 800	5 10	9,700 17,800	0.218 20
	#10	5mm	350 800	5 10	9,700 17,800	0.218 20
	1/4-20	6mm	350 800	5 10	9,700 17,800	0.250 20
	5/16-18	8mm	800 1,300	8 15	14,000 20,000	0.312 50
	3/8-16	10mm	800 1,300	8 15	14,000 20,000	0.312 50