





#6	---	250	800	3	6	5,000	11,000	0.437	0.437	20
#8	---	350	800	3	7	6,000	12,000	0.500	0.500	20
#10	---	900	1,200	4	8	8,000	13,000	0.500	0.500	30
1/4-20	---	900	1,500	5	9	9,000	14,000	0.625	0.625	50
5/16-18	---	900	1,500	6	15	12,000	17,000	0.875	0.875	75
3/8-16	---	1,000	1,600	7	18	13,000	21,000	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	
#6	3.5mm	300	600	4	6	8,500	13,000	0.500	0.500	20	
#8	4mm	500	1,200	2	5	9,000	17,000	0.500	0.500	50	
#10	5mm	900	1,200	2	5	14,000	22,000	0.500	0.500	75	
1/4-20	6mm	900	1,500	5	15	15,500	24,000	0.625	0.625	100	
5/16-18	8mm	1,600	1,800	11	20	21,000	25,000	0.750	0.750	150	
3/8-16	10mm	2,200	2,600	11	15	27,000	35,000	0.875	0.875	150	



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	300	700	4	10	8,000	14,000	0.218	0.250	20	
#8	4mm	300	700	4	10	8,000	14,000	0.218	0.250	20	
#10	5mm	300	700	4	10	8,000	14,000	0.250	0.250	20	
1/4-20	6mm	500	900	6	12	12,000	18,000	0.281	0.312	50	
5/16-18	8mm	800	1,300	8	15	14,000	20,000	0.375	0.375	75	
3/8-16	10mm	1,000	2,000	10	25	15,000	25,000	0.375	0.375	75	