




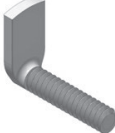


Material welded to: low carbon cold rolled steel

Welding setups to metal thickness: 24 to 11 Gage

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	Part Side	Sheet Side	Welder
 DW	1/4-20	—	700	1,100	3	8	8,000	15,000	0.500	0.500	50
	5/16-18	—	800	1,200	4	12	9,000	16,000	0.625	0.625	75
 GW / GWM	#6	M3.5	200	800	3	5	3,000	7500	0.500	0.500	20
	#8	M4	300	800	3	5	3700	8500	0.500	0.500	20
	#10	M5	400	850	3	7	6,000	12300	0.500	0.500	20
	1/4-20	M6	700	950	3	8	8,000	14500	0.500	0.500	30
	5/16-18	M8	800	1,050	8	12	9,000	15200	0.625	0.625	50
	3/8-16	M10	900	1,150	7	14	10,000	16100	0.750	0.750	50
 HW / HWM	#6	M3.5	300	900	3	7	4,000	13,000	0.500	0.500	20
	#8	M4	300	900	3	7	4,000	13,000	0.500	0.500	20
	#10	M5	300	900	3	7	4,000	13,000	0.500	0.500	20
	1/4-20	M6	700	1,000	3	12	10,000	16,000	0.625	0.625	30
	5/16-18	M8	800	1,100	4	16	12,000	18,000	0.750	0.750	50
	3/8-16	M10	900	1,200	6	18	13,000	20,000	0.875	0.875	50
	1/2-13	M12	1,000	1,500	10	20	14,000	22,000	1.000	1.000	75
 PD	#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
	 RW / RWM	#6	M3.5	300	600	4	6	8500	13,000	0.500	0.500
#8		M4	500	1,200	2	5	9,000	17,000	0.500	0.500	50
#10		M5	900	1,200	2	5	14,000	22,000	0.500	0.500	75
1/4-20		M6	900	1,500	5	15	15500	24,000	0.625	0.625	100
5/16-18		M8	1,600	1,800	11	20	21,000	25,000	0.750	0.750	150
3/8-16		M10	2,200	2,600	11	15	27,000	35,000	0.875	0.875	150
 SS / SSM #	6	M3.5	300	700	4	10	8,000	14,000	0.218	0.250	20
	#8	M4	300	700	4	10	8,000	14,000	0.218	0.250	20
	#10	M5	300	700	4	10	8,000	14,000	0.250	0.250	20
	1/4-20	M6	500	900	6	12	12,000	18,000	0.281	0.312	50
	5/16-18	M8	800	1,300	8	15	14,000	20,000	0.375	0.375	75
	3/8-16	M10	1,000	2,000	10	25	15,000	25,000	0.375	0.375	75