

Parameter Guide for Projection Welding of Nuts

Weld Nuts with 3 projections

Thread Dia mm	Electrode Force		Weld Cycles		Welding Current		Electrode Dia	
	From KGF	to KGF	From Cycles	to Cycles	From Amp	to Amp	Nut Side mm	Sheet Side mm
3.5	318	431	3	7	8000	14500	16.0	16.0
4	318	431	3	7	8000	14500	16.0	16.0
5	363	476	5	10	9000	15200	19.0	19.0
6	408	499	6	12	10000	16100	25.0	25.0
8	454	544	7	13	12000	18000	25.0	25.0
10	454	544	7	13	12000	18000	25.0	25.0

Force and current depends on the sheet on which nut is to be welded

Range of values includes this possibility

Starting values indicated above based on our experience