

Parameter Guide for Projection Welding of Nuts

Weld Nuts with 4 projections

Thread dia mm	Pressure		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	181	408	3	7	8000	16000	16.0	16.0
4	181	408	3	7	8000	16000	16.0	16.0
5	204	431	3	8	11000	16000	16.0	16.0
6	272	454	3	9	12000	17000	16.0	16.0
8	363	499	4	10	13000	18000	19.0	19.0
10	408	544	5	11	14000	19000	22.0	22.0

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