

# RESISTANCE WELDING ELECTRODE MAINTENANCE

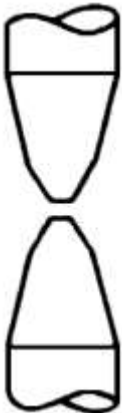
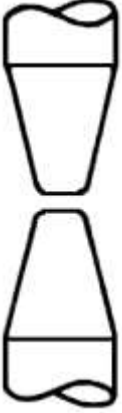
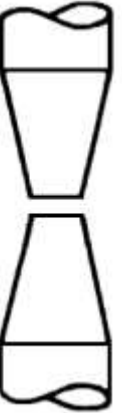
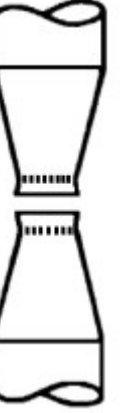

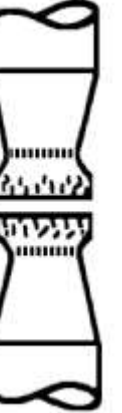








This chart shows graphically the importance of electrode maintenance. This is not only important from the quality of the weld which is of first importance, also extra load added to the welding machine and equipment. Read the data on the chart, you can then draw you own conclusions.

## YOU CAN'T AFFORD TO NEGLECT YOUR ELECTRODES

Keep your electrodes dressed for maximum production and quality welds.

## A TIP DRESSER WILL PAY DIVIDENDS!

We can supply you with a hand operated tip dresser or a pneumatic dresser. Design or type will depend on your production requirements.

WEAR GUIDE						
<i>400% too small</i>	<i>Proper new tips</i>	<i>56% too large</i>	<i>125% too large</i>	<i>300% too large</i>	<i>525% too large</i>	<i>800% too large</i>
						
						
RESULT: Four times too much pressure, current. Very severe indentation and spitting from high current density. CORRECTION: Cut pressure to 1/4, cut current to 1/4	RESULT: Correct pressure, current, tips. Excellent weld. This is the size tip (new) for which the pressure time and current are adjusted	RESULT: Only 60% of proper pressure, current. Borderline weld. Lower strength. Last diameter size tolerated unless current and pressure were set between the 1/4 and 5/16 size tips.	RESULT: Only 45% of the required pressure and current. Welds would be unacceptable. If the current or time were increased with tips in this condition large weak weld would result.	RESULT: Only 25% of required current and pressure. No weld would be made if tips left in this condition.	RESULT: Only 16% of required current and pressure. This is a very serious condition and the only cure is to dress the tips back to proper condition.	RESULT: Only 11% of needed current and pressure. This is an absurd (though often seen) condition that only heats a spot.