

Mild Steel Sheet

Material Thickness	Electrode	Min. Weld Spacing	Min. Weld Overlap	Class A (Best Condition)			
	d			time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	mm	mm	mm	ms	lbf	A	mm
0.5	4.8	10	10	100	292	6100	4.3
0.8	4.8	15	11	140	405	8000	5.3
1.0	6.3	20	13	160	495	9100	5.8
1.5	6.3	25	16	240	809	11600	6.9
2.0	8.0	35	17	340	1102	13500	8.0
2.5	8.0	40	19	440	1461	15000	8.6
3.0	9.5	50	22	480	1798	17300	10.4
4.0	11	67	32	840	2316	18900	12.0
5.0	13	89	45	1400	2967	20900	14.7

Material Thickness	Class B (Average Condition)				Class C (Acceptable Condition)			
	Time	Electrode force	Weld Current	Diameter of Fusion Zone	Time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	ms	lbf	A	mm	ms	lbf	A	mm
0.5	160	202	5100	4.0	360	112	3800	3.5
0.8	240	292	6300	5.0	480	135	4700	4.6
1.0	340	360	7500	5.6	620	180	5600	5.3
1.5	480	517	9000	6.6	780	247	6800	6.3
2.0	600	674	10400	7.6	960	337	8000	7.1
2.5	760	899	11600	8.5	1100	427	9000	7.8
3.0	900	1079	12400	10.0	1300	540	9800	9.3
4.0	1400	1439	14100	11.5	2080	719	11000	10.7
5.0	2450	1978	15900	13.7	3500	989	12200	12.7

Galvanized Steel Sheet

Material Thickness	Electrode	Min. Weld Spacing	Min. Weld Overlap	Class A (Best Condition)			
	d			time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	mm	mm	mm	ms	lbf	A	mm
0.5	4.8	10	10	70	351	6100	4.3
0.8	4.8	15	11	98	486	8000	5.3
1.0	6.3	20	13	112	593	9100	5.8
1.5	6.3	25	16	168	971	11600	6.9
2.0	8.0	35	17	238	1322	13500	8.0
2.5	8.0	40	19	308	1754	15000	8.6
3.0	9.5	50	22	336	2158	17300	10.4
4.0	11	67	32	588	2779	18900	12.0
5.0	13	89	45	980	3561	20900	14.7

Material Thickness	Class B (Average Condition)				Class C (Acceptable Condition)			
	Time	Electrode force	Weld Current	Diameter of Fusion Zone	Time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	ms	lbf	A	mm	ms	lbf	A	mm
0.5	112	243	5100	4.0	252	135	3800	3.5
0.8	168	351	6300	5.0	336	162	4700	4.6
1.0	238	432	7500	5.6	434	216	5600	5.3
1.5	336	620	9000	6.6	546	297	6800	6.3
2.0	420	809	10400	7.6	672	405	8000	7.1
2.5	532	1079	11600	8.5	770	513	9000	7.8
3.0	630	1295	12400	10.0	910	647	9800	9.3
4.0	980	1727	14100	11.5	1456	863	11000	10.7
5.0	1715	2374	15900	13.7	2450	1187	12200	12.7

Stainless Steel Sheet

Material Thickness	Electrode	Min. Weld Spacing	Min. Weld Overlap	Class A (Best Condition)			
	d			time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	mm	mm	mm	ms	lbf	A	mm
0.5	4.8	10	10	70	409	3050	4.3
0.8	4.8	15	11	98	567	4000	5.3
1.0	6.3	20	13	112	692	4550	5.8
1.5	6.3	25	16	168	1133	5800	6.9
2.0	8.0	35	17	238	1542	6750	8.0
2.5	8.0	40	19	308	2046	7500	8.6
3.0	9.5	50	22	336	2518	8650	10.4
4.0	11	67	32	588	3242	9450	12.0
5.0	13	89	45	980	4154	10450	14.7

Material Thickness	Class B (Average Condition)				Class C (Acceptable Condition)			
	Time	Electrode force	Weld Current	Diameter of Fusion Zone	Time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	ms	lbf	A	mm	ms	lbf	A	mm
0.5	112	283	2550	4.0	252	157	1900	3.5
0.8	168	409	3150	5.0	336	189	2350	4.6
1.0	238	504	3750	5.6	434	252	2800	5.3
1.5	336	724	4500	6.6	546	346	3400	6.3
2.0	420	944	5200	7.6	672	472	4000	7.1
2.5	532	1259	5800	8.5	770	598	4500	7.8
3.0	630	1511	6200	10.0	910	755	4900	9.3
4.0	980	2014	7050	11.5	1456	1007	5500	10.7
5.0	1715	2770	7950	13.7	2450	1385	6100	12.7

Aluminium Sheet

Material Thickness	Electrode	Min. Weld Spacing	Min. Weld Overlap	Class A (Best Condition)			
	d			time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	mm	mm	mm	ms	lbf	A	mm
0.5	4.8	10	10	50	146	10370	4.3
0.8	4.8	15	11	70	202	13600	5.3
1.0	6.3	20	13	80	247	15470	5.8
1.5	6.3	25	16	120	405	19720	6.9
2.0	8.0	35	17	170	551	22950	8.0
2.5	8.0	40	19	220	731	25500	8.6
3.0	9.5	50	22	240	899	29410	10.4
4.0	11	67	32	420	1158	32130	12.0
5.0	13	89	45	700	1484	35530	14.7

Material Thickness	Class B (Average Condition)				Class C (Acceptable Condition)			
	Time	Electrode force	Weld Current	Diameter of Fusion Zone	Time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	ms	lbf	A	mm	ms	lbf	A	mm
0.5	80	101	8670	4.0	180	56	6460	3.5
0.8	120	146	10710	5.0	240	67	7990	4.6
1.0	170	180	12750	5.6	310	90	9520	5.3
1.5	240	259	15300	6.6	390	124	11560	6.3
2.0	300	337	17680	7.6	480	169	13600	7.1
2.5	380	450	19720	8.5	550	214	153000	7.8
3.0	450	540	21080	10.0	650	270	16660	9.3
4.0	700	719	23970	11.5	1040	360	18700	10.7
5.0	1225	989	27030	13.7	1750	495	20740	12.7

Brass Sheet

Material Thickness	Electrode	Min. Weld Spacing	Min. Weld Overlap	Class A (Best Condition)			
	d			time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	mm	mm	mm	ms	lbf	A	mm
0.5	4.8	10	10	60	292	14640	4.3
0.8	4.8	15	11	405	84	19200	5.3
1.0	6.3	20	13	96	495	21840	5.8
1.5	6.3	25	16	144	809	27840	6.9
2.0	8.0	35	17	204	1102	32400	8.0
2.5	8.0	40	19	264	1461	36000	8.6
3.0	9.5	50	22	288	1798	41520	10.4
4.0	11	67	32	504	2316	45360	12.0
5.0	13	89	45	840	2967	50160	14.7

Material Thickness	Class B (Average Condition)				Class C (Acceptable Condition)			
	Time	Electrode force	Weld Current	Diameter of Fusion Zone	Time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	ms	lbf	A	mm	ms	lbf	A	mm
0.5	96	202	12240	4.0	216	112	9120	3.5
0.8	144	292	15120	5.0	288	135	11280	4.6
1.0	204	360	18000	5.6	372	180	13440	5.3
1.5	288	517	21600	6.6	468	247	16320	6.3
2.0	360	674	24960	7.6	576	337	19200	7.1
2.5	456	899	27840	8.5	660	427	21600	7.8
3.0	540	1079	29760	10.0	780	540	23520	9.3
4.0	840	1439	33840	11.5	1248	719	26400	10.7
5.0	1470	1978	38160	13.7	2100	989	29280	12.7

Nickel Sheet

Material Thickness	Electrode	Min. Weld Spacing	Min. Weld Overlap	Class A (Best Condition)			
	d			time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	mm	mm	mm	ms	lbf	A	mm
0.5	4.8	10	10	50	438	9150	4.3
0.8	4.8	15	11	70	607	1200	5.3
1.0	6.3	20	13	80	742	13650	5.8
1.5	6.3	25	16	120	1214	17400	6.9
2.0	8.0	35	17	170	1650	20250	8.0
2.5	8.0	40	19	220	2192	22500	8.6
3.0	9.5	50	22	240	2698	25950	10.4
4.0	11	67	32	420	3473	28350	12.0
5.0	13	89	45	700	4451	31350	14.7

Material Thickness	Class B (Average Condition)				Class C (Acceptable Condition)			
	Time	Electrode force	Weld Current	Diameter of Fusion Zone	Time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	ms	lbf	A	mm	ms	lbf	A	mm
0.5	80	303	7650	4.0	180	169	5700	3.5
0.8	120	438	9450	5.0	240	202	7050	4.6
1.0	170	540	11250	5.6	310	270	8400	5.3
1.5	240	776	13500	6.6	390	371	10200	6.3
2.0	300	1012	15600	7.6	480	506	12000	7.1
2.5	380	1349	17400	8.5	550	641	13500	7.8
3.0	450	1619	18600	10.0	650	809	14700	9.3
4.0	700	2158	21150	11.5	1040	1079	16500	10.7
5.0	1225	2967	23850	13.7	1750	1484	18300	12.7

Usibor Sheet

Material Thickness	Electrode	Min. Weld Spacing	Min. Weld Overlap	Class A (Best Condition)			
	d			time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	mm	mm	mm	ms	lbf	A	mm
0.5	4.8	10	10	120	445	5800	4.3
0.8	4.8	15	11	200	607	7400	5.3
1.0	6.3	20	13	240	719	7800	5.8
1.5	6.3	25	16	Heat :180 Cold : 40 Pulse : 2	1000	5800	6.9
2.0	8.0	35	17	Heat :160 Cold : 40 Pulse : 3	1279	9400	8.0
2.5	8.0	40	19	Heat :140 Cold : 40 Pulse : 4	1556	10300	8.6
3.0	9.5	50	22	Heat :180 Cold : 40 Pulse : 4	1834	11800	10.4

Trip800 Sheet

Material Thickness	Electrode	Min. Weld Spacing	Min. Weld Overlap	Class A (Best Condition)			
	d			time	Electrode force	Weld Current	Diameter of Fusion Zone
mm	mm	mm	mm	ms	lbf	A	mm
0.5	4.8	10	10	120	445	6600	4.3
0.8	4.8	15	11	200	614	6400	5.3
1.0	6.3	20	13	240	724	7900	5.8
1.5	6.3	25	16	Heat :180 Cold : 40 Pulse : 2	1000	8600	6.9
2.0	8.0	35	17	Heat :160 Cold : 40 Pulse : 3	1279	10800	8.0
2.5	8.0	40	19	Heat :140 Cold : 40 Pulse : 4	1556	10900	8.6
3.0	9.5	50	22	Heat :180 Cold : 40 Pulse : 4	1834	11900	10.4



DC Inverter Welding Parameter