



Universal Weld Schedule

Job Description _____

Part Number _____

Job Order No. _____

Material: SEC. _____

Tensile Strength _____ KVA _____

Welding Machine No: _____

Surface Preparation _____

Thickness (Thinnest Piece) _____

Air Gauge Press (PSI) _____

DESCRIPTION OF WELD:

Transformer TAP _____

Tensile Strength _____

Weld Force (LBS) _____

Peel Test Button Diameter _____

Secondary Current (AMPS) _____

General Appearance _____

Secondary Depth (Inches) _____ Heights (Inches) _____

Dimensional Check _____

Secondary Voltage (V RMS) _____

ELECTRODES:

UPPER:

LOWER:

Material Class _____

Shank Size (S) _____

Face Size (F) _____

Radius (R) _____

WELD CONTROL DATA:

Spot / Seam / Pulsation _____

Squeeze Count _____

Preheat Count _____

Preheat Current _____

Upslope Count _____

Slope Bottom Current _____

Weld Count _____

Weld Percent Current _____

Impulses _____

Cool _____

Quench Count _____

Temper Count _____

Post Heat Count _____

Post Heat Current _____

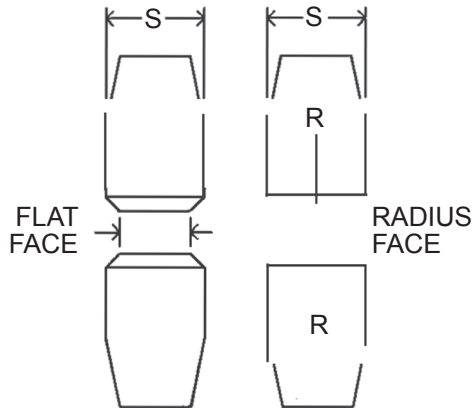
Non Repeat or Repeat _____

Off Count _____

Intermittent or Continuous _____

REDRESS ELECTRODES:

After _____ Welds



Comments _____

Originator _____ Date _____