



UNIVERSAL WELD SCHEDULE

JOB DESCRIPTION _____
 PART NUMBER _____ JOB ORDER NO. _____
 MATERIAL: SPEC. _____ TENSILE STRENGTH _____ KVA _____
 WELDING MACHINE NO. _____ SURFACE PREPARATION _____
 THICKNESS (THINNEST PIECE) _____

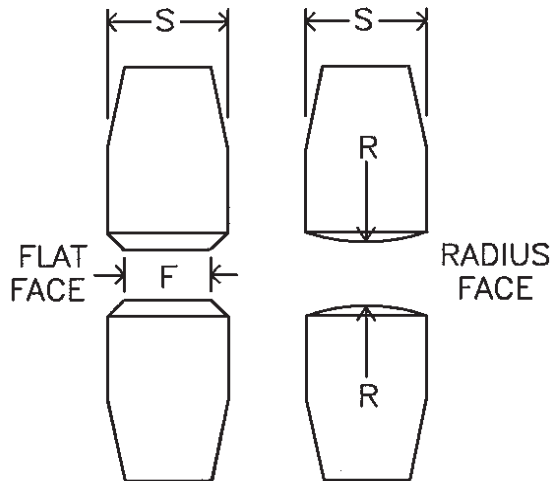
DESCRIPTION OF WELD:
 TENSILE STRENGTH _____
 PEEL TEST BUTTON DIAMETER _____
 GENERAL APPEARANCE _____
 DIMENSIONAL CHECK _____

AIR GAUGE PRESS (PSI) _____
 TRANSFORMER TAP _____
 WELD FORCE (LBS) _____
 SECONDARY CURRENT (AMPS) _____
 SECONDARY DEPTH (IN) _____ HEIGHT (IN) _____
 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 _____
 HOLD COUNT _____
 TEMPER CURRENT _____
 POST HEAT COUNT _____
 POST HEAT CURRENT _____
 NON REPEAT OR REPEAT _____
 OFF COUNT _____
 INTERMITTENT OR CONTINUOUS _____

REDRESS ELECTRODES
 AFTER _____ WELDS.



COMMENTS _____

ORIGINATOR _____ DATE _____

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