

# GCAP® WELD AND STEPPER SCHEDULE

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## GCAP® ELECTRODE WELD SCHEDULE FOR GALVANIZED STEEL

|                     |      |      |      |      |                 |                 |                 |                 |                 |
|---------------------|------|------|------|------|-----------------|-----------------|-----------------|-----------------|-----------------|
| Metal Thickness     | .020 | .030 | .035 | .040 | .050            | .060            | .078            | .093            | .125            |
| G-CAP               | 244  | 254  | 254  | 254  | 255             | 255             | 266             | 266             | 266             |
| Pressure            | 300  | 400  | 500  | 650  | 750             | 800             | 1000            | 1200            | 1400            |
| Squeeze cycle       | 25   | 25   | 25   | 25   | 30              | 30              | 30              | 35              | 35              |
| Up-Slope cycle      |      |      |      |      | 4               | 4               | 4               | 4               | 5               |
| Upslope<br>Kiloamps |      |      |      |      | 2.0<br>to S.C.* | 2.0<br>to S.C.* | 2.0<br>to S.C.* | 2.0<br>to S.C.* | 2.0<br>to S.C.* |
| Weld cycle          | 6    | 8    | 9    | 10   | 7               | 8               | 10              | 12              | 10              |
| Kiloamps            | 8.5  | 9.0  | 9.5  | 10.0 | 10.5            | 11.0            | 11.5            | 12.5            | 13.5            |
| Cool cycle          |      |      |      |      | 1               | 1               | 1               | 1               | 1               |
| Weld cycle          |      |      |      |      | 7               | 8               | 10              | 12              | 10              |
| Kiloamps            |      |      |      |      | 10.5            | 11.0            | 11.5            | 12.5            | 13.5            |
| Cool cycle          |      |      |      |      |                 |                 |                 |                 | 1               |
| Weld cycle          |      |      |      |      |                 |                 |                 |                 | 10              |
| Kiloamps            |      |      |      |      |                 |                 |                 |                 | 13.5            |
| Hold cycle          | 3    | 4    | 4    | 5    | 5               | 10              | 10              | 15              | 20              |

\* S.C. – Starting Weld Current

## GCAP® LINEAR STEPPER

|                            |      |       |       |       |       |        |        |
|----------------------------|------|-------|-------|-------|-------|--------|--------|
| <b>Total Weld Count</b>    | 500  | 1,000 | 3,000 | 5,000 | 7,500 | 10,000 | 12,000 |
| <b>Total Amps Boost</b>    | 600  | 1000  | 3000  | 5000  | 6800  | 8400   | 9200   |
| <b>Amps Boost Per Weld</b> | 1.20 | .88   |       |       |       | .60    |        |

The above schedules and stepper is only meant to be a guide and will require adjustments to fit the application.