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 your 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 hand operated Tip Dressers or Pneumatic Power Driven Dressers. Design or type will depend on your production requirements. P. 46 & 47.

RESISTANCE WELDING

<p>| | | | | | | |</p>
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<tbody>
<tr>
<td></td>
<td>400%</td>
<td>PROPER</td>
<td>56%</td>
<td>125%</td>
<td>300%</td>
<td>525%</td>
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<tr>
<td></td>
<td>TOO SMALL</td>
<td>NEW TIPS</td>
<td>TOO LARGE</td>
<td>TOO LARGE</td>
<td>TOO LARGE</td>
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<tr>
<td></td>
<td>(A)</td>
<td>(B)</td>
<td>(C)</td>
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RESULT: Four times too much pressure, current. Very severe indentation and splitting 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 the required pressure and current. Welds would be unacceptable. If the current or time were increased with tips in this condition a large weak weld would result.

RESULT: Only 25% of the required current and pressure. No weld would be made if tips were left in this condition.

RESULT: Only 16% of the required current and pressure. This is a very serious condition and the only cure is to dress the tips back to (B) condition.

(†) Current density required for this gage to be 200,000 amps per sq. in. Setting is 9,900 amps for condition (B)

(*) Five inch diameter air cylinder A 80 lbs. air pressure—1570 lbs. on ram.

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