

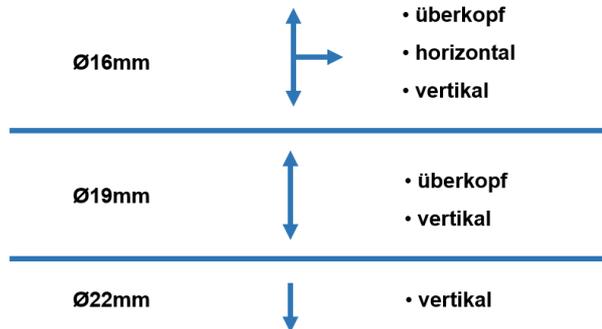
TUNGSTUDS WELDING MANUAL

Welding Parameters

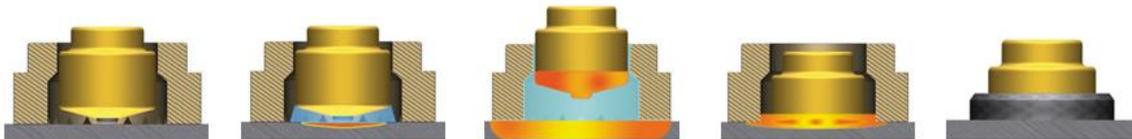
Type	Ø in mm	Current in A	Time in ms	TungStuds / m ²
BTS01	16	1200	600	1350
BTS02	16	1200	600	1350
BTS20	16	1100	500	1350
BTS03	19	1350	700	1050
BTS04	19	1350	700	1050
BTS100	19	1350	700	1050
BTS05	22	1500	800	700
BTS06	22	1500	800	700
BTS08	22	1500	800	700

The indicated quantities are based on the maximum welded TungStuds per square meter. It's also possible to weld on less then these quantities but this depends on the application.

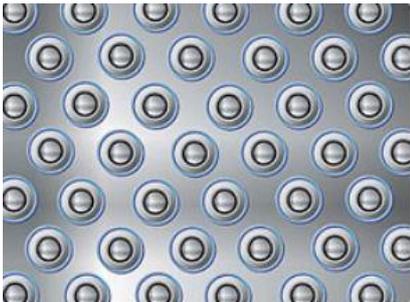
Welding Positions



Welding Process

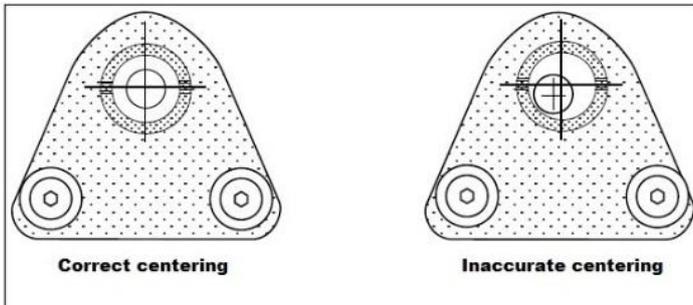


Recommended Welding Pattern (cermic ferrule touching ceramic ferrule)

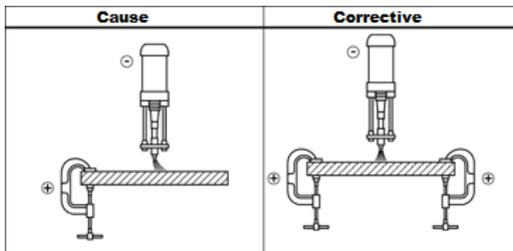


TUNGSTUDS WELDING MANUAL

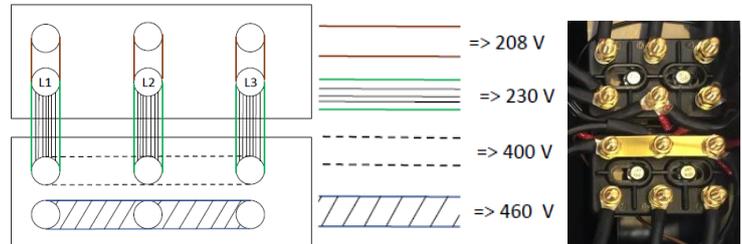
Setting Welding Gun



Setting Earth Cables



Setting Connectors



Welding Inspection



Welding joint is closed
Welding joint is blue-grey-shining
Height of the TungStuds after being welded on is ok



Current is too low
Welding joint is not closed, matt and porous
Height of the TungStuds after weld-on is too long



Current is too high
Welding Splash
Height of the TungStuds after being welded on is too short

Caution! The welding machine should be operated only by qualified staff.