

## SPW-01 Spot welding energy setup cross table

### Basic considerations

- ▲ Nominal and real (welding tip) energy differences are attributable to welding gun connection cables and ambient temperature
- ▲ Welding tip requires frequent check and sharpening (with sandpaper for example), general rule of a thumb for a new tip is a slight sharpening every 10 welds
- ▲ Always test your welding energy using a dummy metal plate of same thickness and composition as your sensors.
- ▲ Recommended weld tip energy for our SWS-02 or SWA-01 sensors is 200 Joules nominal or 24 Joules real (average) in laboratory conditions.



### Nominal versus real weld energy cross table

| Set energy – Nominal on the knob (J) | Real Energy Range (J) |             |
|--------------------------------------|-----------------------|-------------|
|                                      | Min.                  | Max.        |
| NORMAL                               | 35                    | 2,3 – 5,8   |
| NORMAL                               | 50                    | 3,3 – 8,3   |
| NORMAL max                           | 55                    | 3,6 – 9,1   |
| TURBO                                | 85                    | 5,5 – 14,0  |
| TURBO                                | 120                   | 7,8 – 19,8  |
| TURBO                                | 300                   | 19,5 – 49,5 |
| TURBO max                            | 350                   | 22,8 – 57,8 |

For more information contact our sales team at [sales@sylex.sk](mailto:sales@sylex.sk)

\* Specifications are subject to change without notice