Weld Current - Too high

ALCAVIL Defect Troubleshooting Guide

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YOUR SOLUTION IN RESISTANCE WELDING Resistance Welding Quick Reference Chart							alcavil.com.mx Monterrey, N.L. Mexic			
Probable Cause Remote Possibility										
ELECTRODES										
CAUSE AREA	Expulsion at Interface	Surface Expulsion / Sticking	Electrode Mushrooming	Low Weld Strength	Excessive Indentation	Internal Crack in Nugget	Cracks in Parent Material	Blackened Weld Nugget		
Electrode face too small										
Electrode face too large										
Misaligned electrodes										
Insufficient cooling										
Excessive weld time										
PARTS WELDED										
CAUSE AREA	Expulsion at Interface	Surface Expulsion / Sticking	Electrode Mushrooming	Low Weld Strength	Excessive Indentation	Internal Crack in Nugget	Cracks in Parent Material	Blackened Weld Nugget		
Dirty / scaled material										
Poor part fit-up										
Insufficient edge distance										
Welds too close together										
Material metallurgy										
Poor head follow-up										
WELDING CONDITIONS		-						•		
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CAUSE AREA	Expulsion at Interface	Surface Expulsion / Sticking	Electrode Mushrooming	Low Weld Strength	Excessive Indentation	Internal Crack in Nugget	Cracks in Parent Material	Blackened Weld Nugget
Squeeze Time - Too short								
Weld Time - Too short								
Weld Time - Too long								
Hold Time - Too short								
Weld Force - Too low								
Weld Force - Too high								
Weld Current - Too low								