

Welding identifier 436755A5
 Material number APC
 Description 316 tot 2.5
 System Model 20
 Ring none
 Diameter 50.8 mm
 Thickness 1.45 mm
 Prepurge time 15
 Postpurge time 10
 Weld type weld with p.c.
 Welding from zero
 Operator demo expert
 Date / Time 1-11-2005

11:46:45

weldstate measuring

high	current (A)	width (ms)	speed (mm/min)
low	49.5	231	71
	16.0	397	71

Current (A)	Quality Level	Arcvoltage (V)	Heatinput (J/mm)
46.6 / 15.0	0	11.2 / 11.3	250

demo expert

weldstate measuring

0.1	46.6 / 15.0	1	11.1 / 11.1	247
0.6	47.1 / 15.2	1	11.1 / 10.9	248
1.6	47.4 / 15.3	1	11.0 / 10.8	248
2.9	47.8 / 15.4	1	10.9 / 10.7	247
4.7	47.0 / 15.2	1	10.9 / 10.8	243
6.7	47.8 / 15.4	6	10.9 / 10.6	247
8.7	47.6 / 15.4	6	10.9 / 10.8	247
10.7	47.8 / 15.4	4	11.0 / 10.8	250
12.7	48.3 / 15.6	4	11.1 / 10.9	255
14.8	48.6 / 15.7	5	11.1 / 10.9	256
16.8	48.9 / 15.8	5	11.2 / 10.7	257
18.8	49.2 / 15.9	6	11.1 / 10.7	258
20.8	49.4 / 15.9	6	11.1 / 10.7	258
22.8	49.5 / 16.0	6	11.0 / 10.6	257

weldstate penetration

24.8	49.5 / 16.0	7	10.9 / 10.6	256
26.9	49.7 / 16.1	7	10.9 / 10.5	256
28.9	49.8 / 16.1	7	10.9 / 10.4	254
30.9	50.1 / 16.2	8	10.9 / 10.3	255
32.9	50.3 / 16.2	9	10.9 / 10.3	256
34.9	50.7 / 16.4	10	10.8 / 10.2	257
36.9	50.7 / 16.4	10	10.9 / 10.2	257
39.0	51.1 / 16.5	10	10.9 / 10.3	260
41.0	51.1 / 16.5	10	10.9 / 10.1	258
43.0	51.4 / 16.6	10	10.9 / 10.2	261
45.0	51.3 / 16.6	10	10.9 / 10.2	260
47.0	51.3 / 16.6	10	10.8 / 10.2	259
49.1	50.8 / 16.4	11	10.8 / 10.2	256
51.1	50.5 / 16.3	11	10.7 / 10.2	254
53.1	50.2 / 16.2	11	10.8 / 10.2	254
55.1	50.0 / 16.2	10	10.7 / 10.2	251
57.1	49.6 / 16.0	10	10.7 / 10.2	249
59.1	49.6 / 16.0	10	10.7 / 10.3	250
61.2	49.6 / 16.0	10	10.7 / 10.2	250
63.2	49.6 / 16.0	10	10.7 / 10.3	250
65.2	49.6 / 16.0	10	10.8 / 10.7	255
67.2	49.6 / 16.0	10	10.7 / 10.3	250
69.2	49.6 / 16.0	11	10.7 / 10.1	248
71.3	49.5 / 16.0	11	10.7 / 10.2	249
73.3	49.6 / 16.0	11	10.8 / 10.4	253
75.3	49.5 / 16.0	11	10.8 / 10.4	253
77.3	49.5 / 16.0	11	10.8 / 10.3	251
79.3	49.7 / 16.1	11	10.8 / 10.4	253
81.3	50.2 / 16.2	10	10.8 / 10.4	256
83.4	50.6 / 16.3	9	10.8 / 10.4	257
85.4	51.0 / 16.5	9	10.9 / 10.5	262
87.4	51.4 / 16.6	8	10.9 / 10.5	264
89.4	51.4 / 16.6	8	11.0 / 10.5	265
91.4	51.4 / 16.6	8	11.0 / 10.7	267
93.5	51.3 / 16.6	9	11.0 / 10.7	267
95.5	51.7 / 16.7	9	11.1 / 10.6	269
97.5	51.3 / 16.6	9	11.1 / 10.6	267
99.5	51.4 / 16.6	8	11.1 / 10.6	267
101.5	51.4 / 16.6	9	11.2 / 10.7	270
103.5	51.4 / 16.6	9	11.2 / 10.7	269
105.6	51.0 / 16.5	10	11.2 / 10.9	269
107.6	51.1 / 16.5	11	11.1 / 10.8	268
109.6	51.0 / 16.5	11	11.1 / 10.8	268
111.6	51.0 / 16.5	11	11.1 / 10.9	268
113.6	51.0 / 16.5	11	11.1 / 10.9	268
115.7	50.6 / 16.3	10	11.2 / 10.8	266
117.7	50.2 / 16.2	10	11.2 / 10.8	264
119.7	49.8 / 16.1	9	11.1 / 11.0	263
121.7	49.4 / 15.9	9	11.1 / 11.0	260
123.7	49.4 / 15.9	10	11.1 / 10.9	260
125.7	49.3 / 15.9	10	11.1 / 10.9	260
127.8	49.6 / 16.0	10	11.2 / 10.8	261

129.8	49.6 / 16.0	10	11.2 / 11.0	263	436755A5/3
131.8	49.6 / 16.0	10	11.2 / 10.9	262	
133.8	49.2 / 15.9	10	11.2 / 11.0	261	
135.8	48.8 / 15.8	10	11.4 / 11.1	262	
137.9	48.9 / 15.8	10	11.2 / 10.8	258	
139.9	48.9 / 15.8	11	11.2 / 11.0	259	
141.9	48.8 / 15.8	11	11.2 / 11.1	261	
143.9	48.9 / 15.8	11	11.2 / 10.9	259	
145.9	49.3 / 15.9	11	11.3 / 11.1	264	
148.0	49.6 / 16.0	10	11.2 / 11.0	263	
150.0	50.0 / 16.2	10	11.2 / 11.1	267	
152.0	50.4 / 16.3	9	11.3 / 11.1	269	
154.0	50.4 / 16.3	9	11.2 / 11.0	268	
156.0	50.4 / 16.3	8	11.3 / 10.9	268	
158.0	50.4 / 16.3	8	11.3 / 11.0	269	
160.1	50.8 / 16.4	8	11.3 / 11.0	271	
162.1	51.1 / 16.5	8	11.3 / 11.0	273	
164.1	51.1 / 16.5	8	11.3 / 11.0	273	
166.1	51.1 / 16.5	9	11.2 / 10.9	270	
168.1	50.8 / 16.4	9	11.3 / 11.1	272	
170.2	50.4 / 16.3	9	11.3 / 11.1	270	
172.2	50.4 / 16.3	9	11.4 / 11.1	271	
174.2	50.4 / 16.3	10	11.4 / 11.2	272	
176.2	50.0 / 16.1	10	11.4 / 11.2	270	
178.2	49.6 / 16.0	10	11.4 / 11.2	268	
180.2	49.6 / 16.0	10	11.3 / 11.2	268	
182.3	49.6 / 16.0	10	11.3 / 11.1	266	
184.3	49.2 / 15.9	10	11.3 / 11.1	264	
186.3	48.9 / 15.8	9	11.3 / 11.2	264	
188.3	48.9 / 15.8	9	11.5 / 11.4	267	
190.3	48.9 / 15.8	9	11.4 / 11.3	265	
192.4	48.6 / 15.7	10	11.4 / 11.3	263	
194.4	48.6 / 15.7	10	11.3 / 11.3	263	
196.4	48.7 / 15.7	9	11.3 / 11.5	265	
198.4	48.2 / 15.6	9	11.3 / 11.6	264	
200.4	48.2 / 15.6	10	11.3 / 11.4	261	
202.4	48.8 / 15.8	10	11.3 / 11.3	264	
204.5	49.0 / 15.8	10	11.2 / 11.3	264	
206.5	49.0 / 15.8	10	11.3 / 11.3	265	
208.5	48.5 / 15.7	9	11.3 / 11.4	263	
210.5	48.1 / 15.5	10	11.3 / 11.3	260	
212.5	48.2 / 15.6	10	11.4 / 11.4	263	
214.6	48.7 / 15.7	10	11.5 / 11.3	266	
216.6	49.1 / 15.9	9	11.5 / 11.4	268	
218.6	49.5 / 16.0	8	11.5 / 11.2	270	
220.6	49.9 / 16.1	8	11.6 / 11.3	274	
222.6	50.2 / 16.2	8	11.6 / 11.3	275	
224.6	50.7 / 16.4	7	11.6 / 11.3	278	
226.7	51.0 / 16.5	7	11.6 / 11.2	279	
228.7	51.3 / 16.6	7	11.5 / 11.2	279	
230.7	51.2 / 16.5	7	11.5 / 11.2	278	
232.7	51.2 / 16.5	8	11.6 / 11.1	279	
234.7	51.4 / 16.6	8	11.6 / 11.2	281	
236.8	51.1 / 16.5	9	11.5 / 11.3	280	
238.8	51.4 / 16.6	10	11.5 / 11.2	279	
240.8	51.4 / 16.6	10	11.5 / 11.1	279	
242.8	50.9 / 16.4	11	11.5 / 11.2	277	
244.8	51.0 / 16.5	10	11.5 / 11.1	277	
246.8	50.5 / 16.3	10	11.4 / 11.2	274	
248.9	50.1 / 16.2	10	11.4 / 11.2	272	
250.9	50.1 / 16.2	9	11.4 / 11.2	272	
252.9	49.7 / 16.1	9	11.4 / 11.4	271	
254.9	49.7 / 16.1	9	11.5 / 11.2	271	
256.9	49.7 / 16.1	8	11.4 / 11.5	273	
259.0	49.7 / 16.1	7	11.4 / 11.1	269	
261.0	49.7 / 16.1	8	11.4 / 11.1	269	
263.0	49.3 / 15.9	8	11.5 / 11.3	270	
265.0	48.9 / 15.8	8	11.4 / 11.4	267	
267.0	48.5 / 15.7	9	11.4 / 11.2	263	
269.0	48.1 / 15.5	9	11.3 / 11.2	259	
271.1	48.1 / 15.5	9	11.2 / 11.2	258	
273.1	48.1 / 15.5	9	11.2 / 11.3	258	
275.1	48.1 / 15.5	10	11.1 / 11.0	256	
277.1	48.5 / 15.7	9	11.1 / 10.9	257	
279.1	48.5 / 15.7	9	11.0 / 11.0	256	
281.2	48.0 / 15.5	9	11.0 / 11.0	253	
283.2	47.6 / 15.4	9	11.0 / 11.0	251	
285.2	47.3 / 15.3	9	11.0 / 11.0	250	
287.2	46.9 / 15.2	10	10.9 / 11.1	248	
289.2	47.0 / 15.2	10	11.0 / 11.0	247	
291.2	47.0 / 15.2	10	10.9 / 10.9	247	
293.3	47.5 / 15.3	11	10.9 / 11.0	249	
295.3	47.8 / 15.4	11	11.0 / 10.8	250	
297.3	47.8 / 15.4	11	10.9 / 10.9	250	
299.3	47.9 / 15.5	11	10.9 / 10.7	248	
301.3	47.9 / 15.5	11	10.8 / 10.7	248	
303.4	47.9 / 15.5	10	10.8 / 10.6	247	
305.4	48.2 / 15.6	10	10.8 / 10.5	246	
307.4	48.4 / 15.6	10	10.8 / 10.5	248	
309.4	48.4 / 15.6	10	10.7 / 10.5	246	
311.4	48.7 / 15.7	10	10.8 / 10.4	249	
313.4	48.7 / 15.7	11	10.8 / 10.4	248	
315.5	48.7 / 15.7	11	10.7 / 10.3	246	
317.5	48.3 / 15.6	11	10.6 / 10.2	242	
319.5	47.9 / 15.5	11	10.5 / 10.2	238	
321.5	47.9 / 15.5	11	10.6 / 10.3	240	
323.5	47.9 / 15.5	11	10.5 / 10.2	239	

325.6	47.9 / 15.5	11	10.6 / 10.2	239
327.6	47.8 / 15.5	11	10.5 / 10.1	237
329.6	47.6 / 15.4	10	10.5 / 10.1	236
331.6	47.6 / 15.4	10	10.4 / 10.2	235
333.6	47.6 / 15.4	10	10.4 / 10.1	235
335.6	47.6 / 15.4	11	10.5 / 10.0	235
337.7	47.6 / 15.4	11	10.5 / 10.1	236
339.7	47.6 / 15.4	12	10.4 / 10.1	236
341.7	47.6 / 15.4	11	10.4 / 10.1	235
343.7	47.6 / 15.4	11	10.4 / 10.1	235
345.7	47.6 / 15.4	12	10.4 / 10.1	235
347.8	47.6 / 15.4	12	10.4 / 10.1	236
349.8	47.6 / 15.4	12	10.4 / 10.1	234
351.8	47.6 / 15.4	12	10.4 / 10.1	234
353.8	47.4 / 15.3	12	10.5 / 10.1	235
355.8	47.4 / 15.3	12	10.5 / 10.2	235
357.8	47.4 / 15.3	11	10.5 / 10.1	235
359.9	46.9 / 15.2	11	10.4 / 10.0	230
1.9	47.2 / 15.3	11	10.3 / 10.0	231
3.9	50.1 / 16.2	11	10.7 / 10.0	249
5.9	50.1 / 16.2	11	10.8 / 10.0	251
7.9	50.1 / 16.2	11	10.6 / 9.9	247
10.0	50.1 / 16.2	11	10.7 / 10.2	251
12.0	49.8 / 16.1	11	10.6 / 10.0	247
14.0	49.6 / 16.0	11	10.6 / 10.1	248
16.0	49.6 / 16.0	11	10.5 / 10.0	245
18.0	49.3 / 15.9	11	10.7 / 10.0	246
20.0	48.9 / 15.8	11	10.5 / 10.0	241
22.1	48.9 / 15.8	11	10.5 / 10.0	241
24.1	48.9 / 15.8	10	10.6 / 9.9	242

	weldstate	downslope		

26.1	43.8 / 15.8	0	10.6 / 9.9	0
28.1	38.7 / 15.8	0	10.6 / 9.9	0
30.1	33.5 / 15.8	0	10.6 / 9.9	0
32.2	28.4 / 15.8	0	10.6 / 9.9	0
34.2	23.3 / 15.8	0	10.6 / 9.9	0
36.2	18.2 / 15.8	0	10.6 / 9.9	0
38.2	13.1 / 15.8	0	10.6 / 9.9	0
40.2	8.0 / 15.8	0	10.6 / 9.9	0

	Weld succesfull			

Heatinput	Average	Minimum	Maximum	Total
	257 J/mm	230 J/mm	281 J/mm	41224 J
