

## DO'S AND DON'TS FOR RESISTANCE WELDING ELECTRODES

DO'S	DON'TS
<ol style="list-style-type: none"> <li>1. Use the proper electrode material for the job you are doing.</li> <li>2. Use standard electrodes wherever possible.</li> <li>3. Use the most suitable tip diameter for the thickness of stock being welded.</li> <li>4. Use open sight drains to observe more readily the water flow through the holders.</li> <li>5. Connect the water inlet hose to the proper holder inlet so that the water flows through the center cooling tube first.</li> <li>6. Internally cool the spot welding tips with cool water flowing at a rate of at least 1/2 gallon per minute through each tip.</li> <li>7. Be sure the internal water cooling tube of the holder projects into the tip water hole to within 1/4" of the tip hole bottom.</li> <li>8. Adjust the internal water cooling tube of the holder to the proper height when changing to a different length tip.</li> <li>9. Be sure top of adjustable water cooling tube in holders is cut at an angle so as to avoid jamming tip down and shutting water off.</li> <li>10. Place a thin film of cup grease on the tip taper prior to inserting in the holder, to make it easier to remove.</li> <li>11. Use ejector type holders for easy removal of tips and to avoid damage to tip tapers.</li> <li>12. Keep the tip taper and holder taper clean, smooth and free of foreign deposits.</li> <li>13. Dress spot welding electrodes frequently to maintain the quality of the welds.</li> <li>14. Dress electrodes in a lathe to their original contour whenever possible.</li> <li>15. Use a rawhide or rubber mallet for striking holder or tips in aligning operations.</li> <li>16. Provide flood cooling on both sides of the seam welding wheel.</li> <li>17. Use properly designed knurling wheels to maintain proper seam welding wheel shape.</li> </ol>	<ol style="list-style-type: none"> <li>1. Never use unidentified electrodes or electrode materials.</li> <li>2. Avoid special, offset or irregular tips when the job can be done with a standard straight tip.</li> <li>3. Don't use small tips on heavy gauge welding jobs or large tips on small work.</li> <li>4. Don't forget to turn on the cooling water full force before starting to weld.</li> <li>5. Never use water hose that will not fit the holder water connection nipples snugly.</li> <li>6. Do not allow water connections to become leaky, clogged or broken.</li> <li>7. Avoid using holders with leaking or deformed tapers.</li> <li>8. Never use electrode holders that do not have an adjustable internal water cooling tube.</li> <li>9. Do not permit adjustable water tube to be "frozen" by accumulation of deposits. A few drops of oil periodically will keep the tube free.</li> <li>10. Do not allow electrodes to remain idle in tapered holder seats for extended periods.</li> <li>11. Don't use pipe wrenches or similar tools in removing electrodes.</li> <li>12. Avoid using white lead or similar compounds to seal a leaking taper.</li> <li>13. Never permit a spot welding tip to mushroom enough to make dressing difficult.</li> <li>14. Never dress electrodes with a coarse file.</li> <li>15. Don't pound on the holder or tip with a steel hammer in aligning the welder arms.</li> <li>16. Avoid the use of seam welder wheels too thin to stand the heat or pressure of your job.</li> <li>17. Do not permit seam welding wheel to run off the corners of the work being welded.</li> </ol>