

The CMW GCAP® electrode is the answer to welding galvanized steels. The GCAP's® revolutionary design, and precision manufacturing from CMW Engineering provides for no sticking from the very first weld. GCAP® electrode nuggets meet or exceed industry standards for high quality welds from the first weld through the life of the cap. This cap design made from R.W.M.A. class 2 material eliminates brass build-up by literally rolling the brass away. You will use

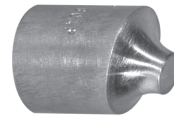
less electric power (up to 25% less) and still achieve superior welds due to GCAP® design. Productivity will increase with up to 10 times more welds without dressing.

For best use of CMW GCAPS®, a stepper program is recommended. Consult CMW application engineering.
U.S. Patent 49,954,687; 5,015,816; 5,126,528.
Other patents pending.

CMW FEMALE GCAP® ELECTRODES

ALL DIMENSIONS MARKED WITH AN (*) ARE COMMON TO EACH CAP IN A HORIZONTAL LINE.

- See pages 12 for Shanks
- See page 71 for suggested weld schedules

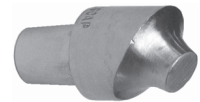


	STRAIGHT	OFFSET	OFFSET 15°	OFFSET 30°
Cap Taper RW #4 Diameter .500* Length .840* CMW®3	 MPG244	 MPGD244	 MPGD244-1501	 MPGD244-3001
Cap Taper RW #5 Diameter .625* Length .880* CMW®3	 MPG254	 MPGD254	 MPGD254-1501	 MPGD254-3001
Cap Taper RW #5 Diameter .625* Length .880* CMW®3	 MPG255	 MPGD255	 MPGD255-1501	 MPGD255-3001
Cap Taper RW #6 Diameter .750* Length 1.000* CMW®3	 MPG266	 MPGD266	 MPGD266-1501	 MPGD266-3001

CMW MALE GCAP® ELECTRODES

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- See page 71 for suggested weld schedules



	STRAIGHT	OFFSET	OFFSET 15°	OFFSET 30°
Cap Taper RW #4 Diameter .500* Length 1.125* CMW®3	 MG244	 MGD244	 MGD244-1501	 MGD244-3001
Cap Taper RW #5 Diameter .625* Length 1.250* CMW®3	 MG254	 MGD254	 MGD254-1501	 MGD254-3001
Cap Taper RW #5 Diameter .625* Length 1.250* CMW®3	 MG255	 MGD255	 MGD255-1501	 MGD255-3001
Cap Taper RW #6 Diameter .750* Length 1.625* CMW®3	 MG266	 MGD266	 MGD266-1501	 MGD266-3001

GCAP® WELD AND STEPPER SCHEDULE



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GCAP® ELECTRODE WELD SCHEDULE FOR GALVANIZED STEEL

Metal Thickness	.020	.030	.035	.040	.050	.060	.078	.093	.125
G-CAP	244	254	254	254	255	255	266	266	266
Pressure	300	400	500	650	750	800	1000	1200	1400
Squeeze cycle	25	25	25	25	30	30	30	35	35
Up-Slope cycle					4	4	4	4	5
Upslope Kiloamps					2.0 to S.C.*	2.0 to S.C.*	2.0 to S.C.*	2.0 to S.C.*	2.0 to S.C.*
Weld cycle	6	8	9	10	7	8	10	12	10
Kiloamps	8.5	9.0	9.5	10.0	10.5	11.0	11.5	12.5	13.5
Cool cycle					1	1	1	1	1
Weld cycle					7	8	10	12	10
Kiloamps					10.5	11.0	11.5	12.5	13.5
Cool cycle									1
Weld cycle									10
Kiloamps									13.5
Hold cycle	3	4	4	5	5	10	10	15	20

* S.C. – Starting Weld Current

GCAP® LINEAR STEPPER

Total Weld Count	500	1,000	3,000	5,000	7,500	10,000	12,000
Total Amps Boost	600	1000	3000	5000	6800	8400	9200
Amps Boost Per Weld	1.20		.88			.60	

The above schedules and stepper is only meant to be a guide and will require adjustments to fit the application.