

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.