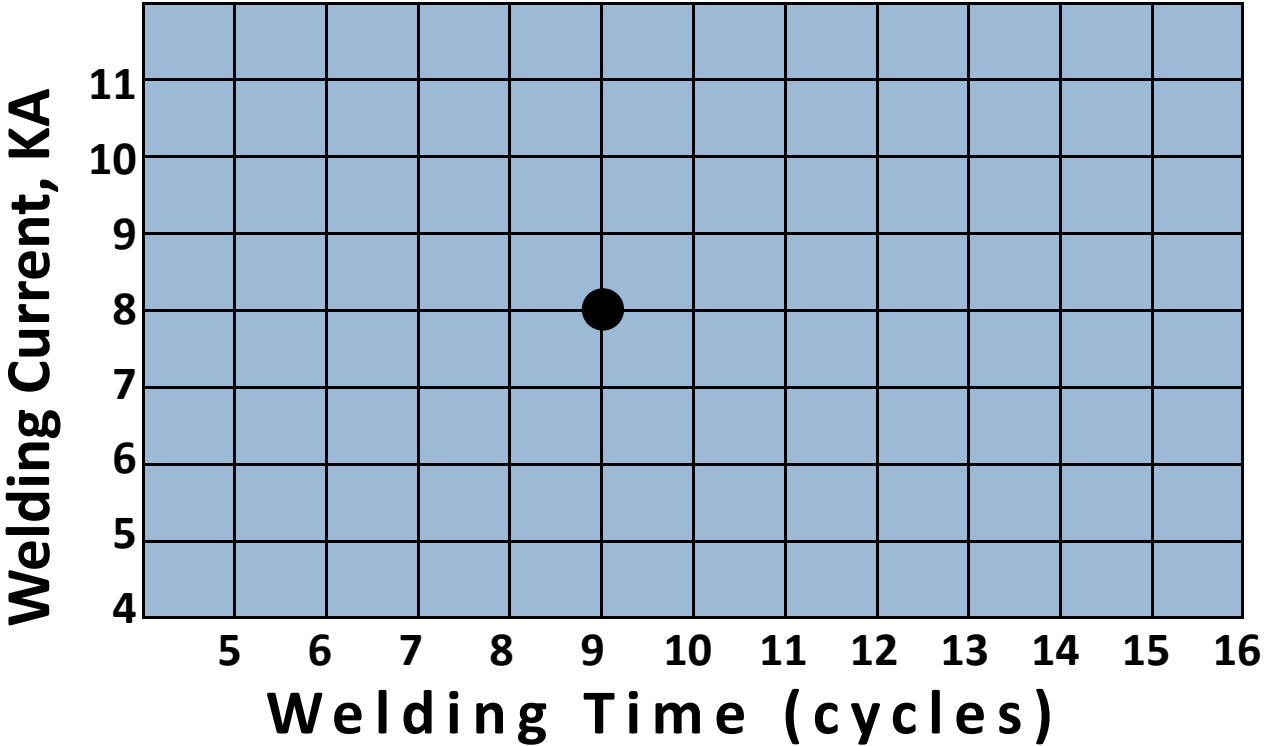
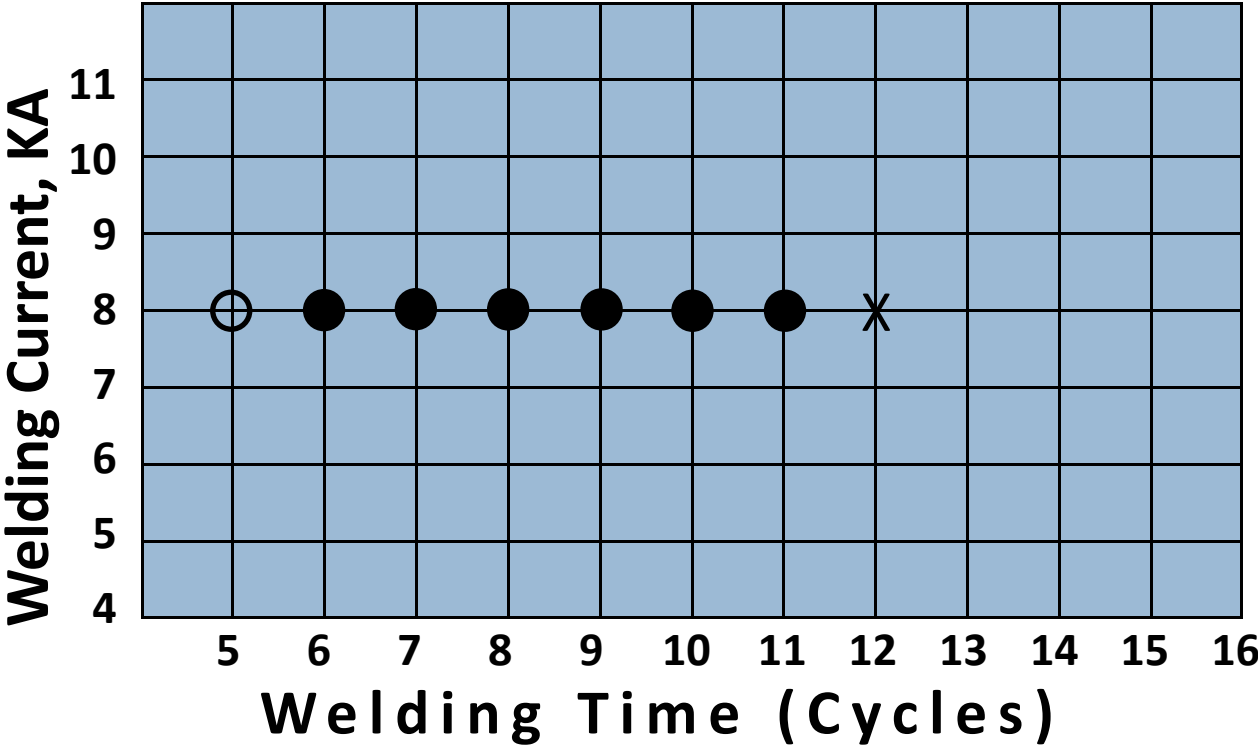


# DEVELOPING A WELDING LOBE



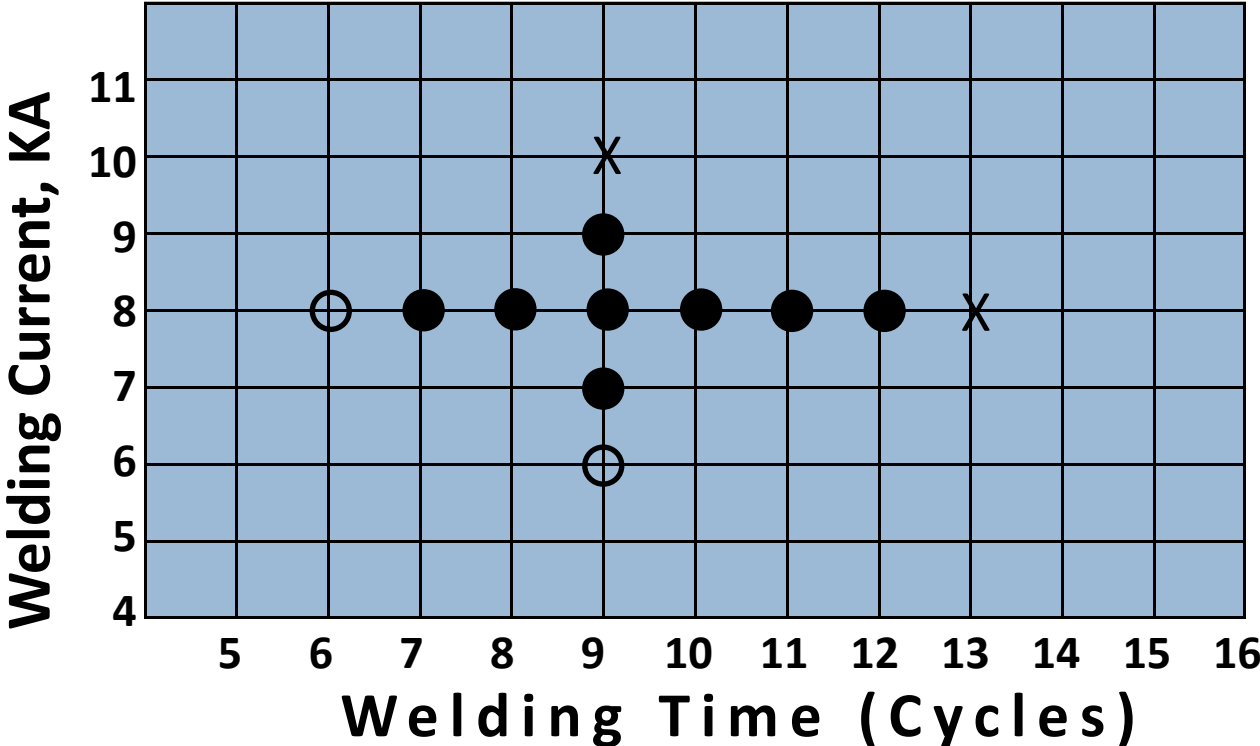
**STEP 1. Make a weld that meets test requirements. Use a standard welding chart for the most similar alloy available and adjust as needed. Put a dot at the intersection of the welding current and the welding time.**

# DEVELOPING A WELDING LOBE



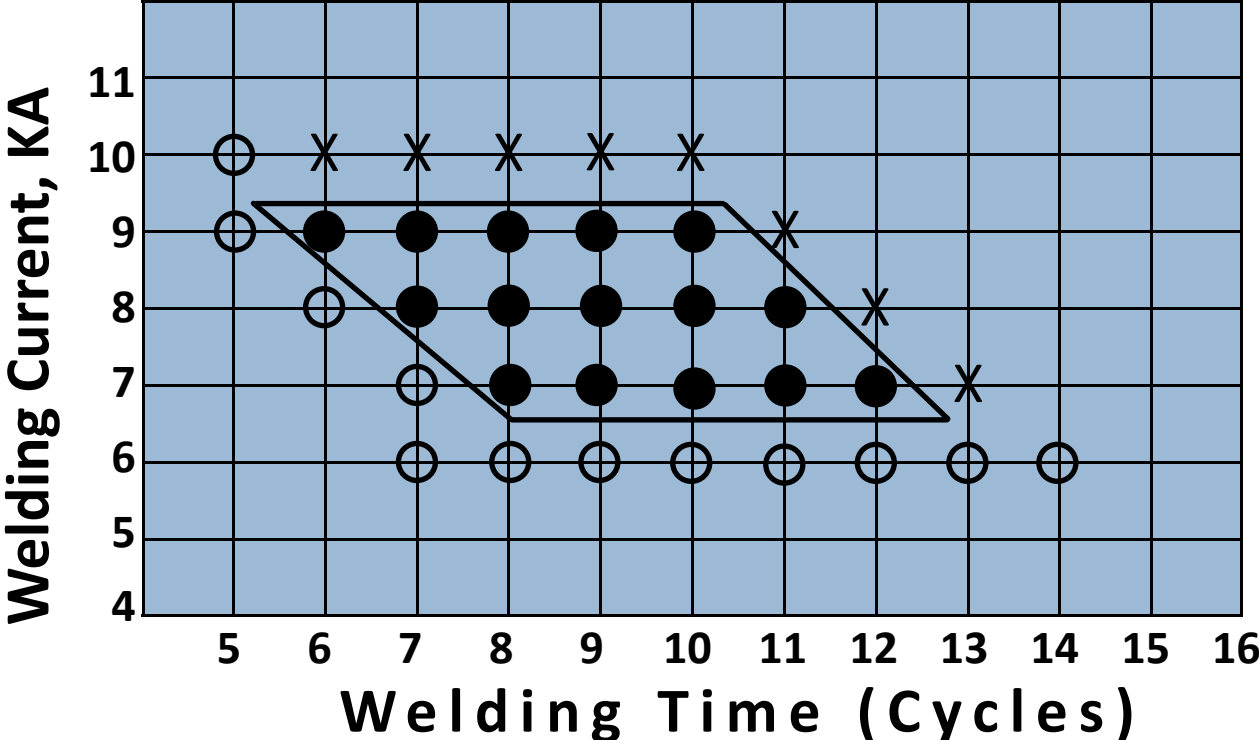
**STEP 2.** Increase the Welding Time one cycle at a time until you see the start of metal expulsion and put an X at that intersect. Then decrease Weld Time until the weld result is just on the edge of being acceptable and put a O at that intersect.

# DEVELOPING A WELDING LOBE



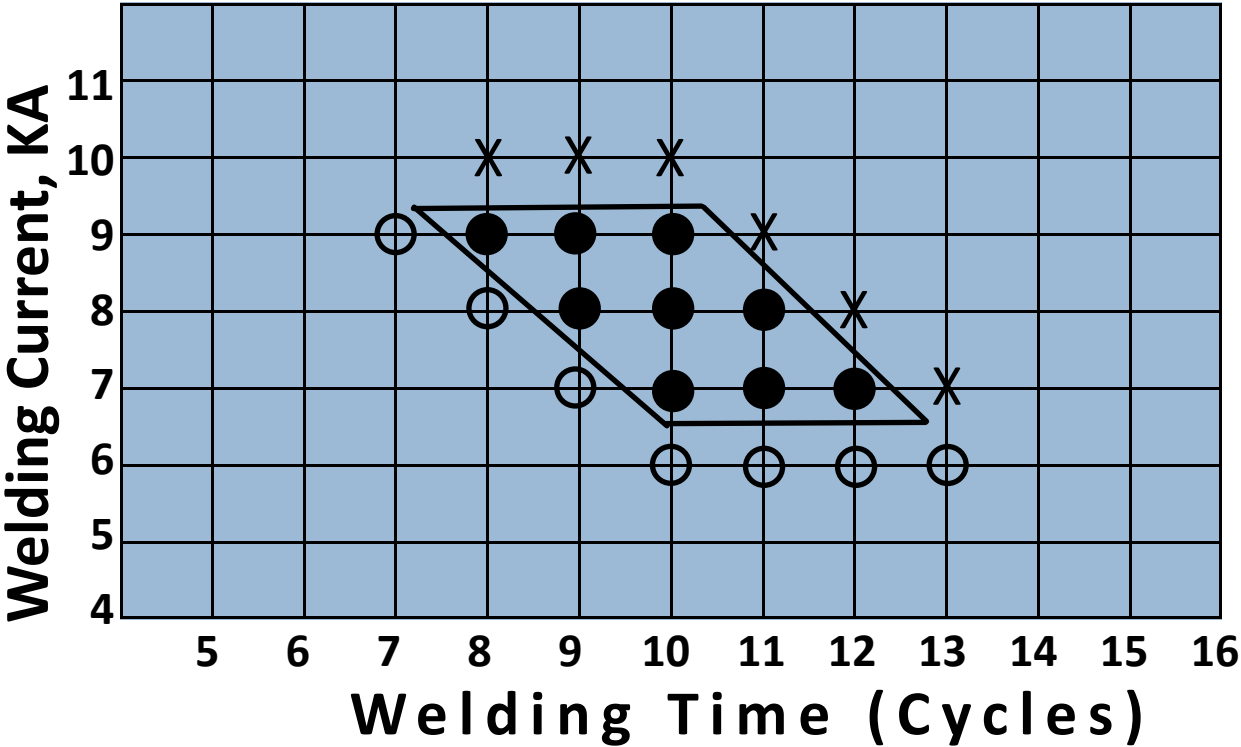
**STEP 3. Increase the Welding Current until you see the start of expulsion metal expulsion and put an X at the intersect. Decrease the Welding Current until the weld result is just on the edge of being acceptable and put a O at that intersect.**

# DEVELOPING A WELDING LOBE



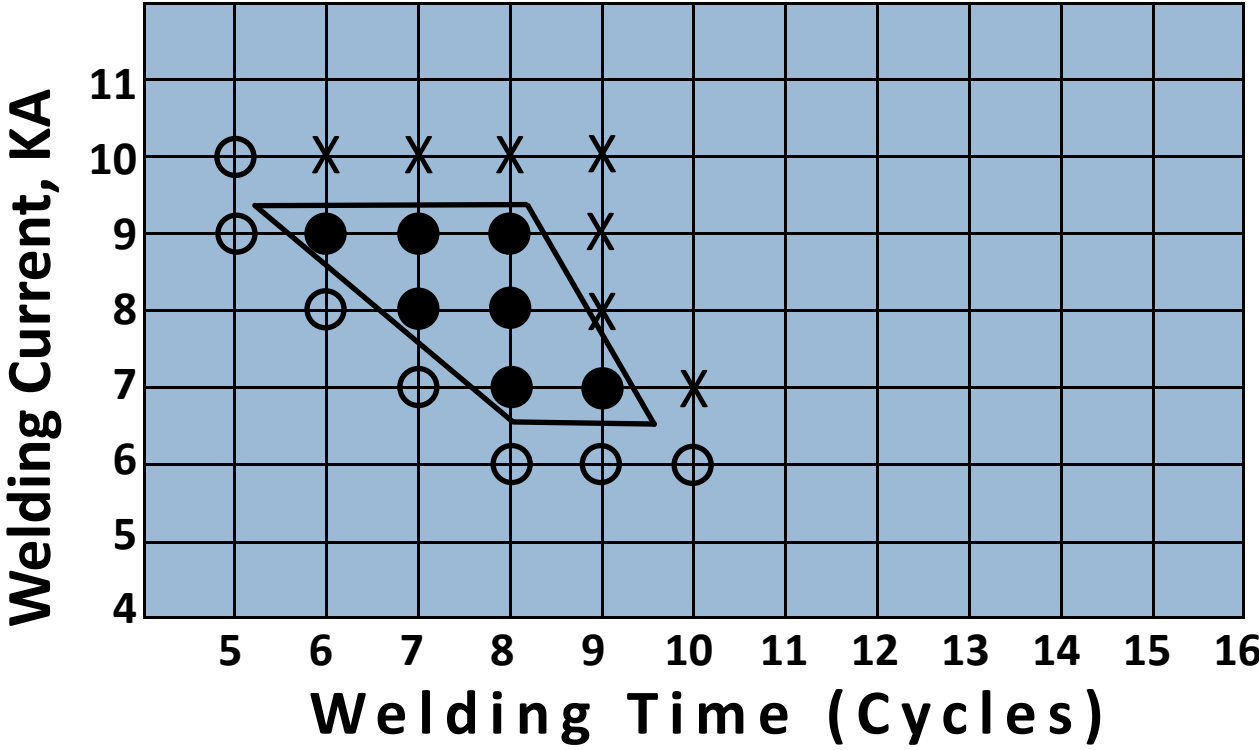
**STEP 4. Repeat the same process for each line of Welding Current.**

# DEVELOPING A WELDING LOBE



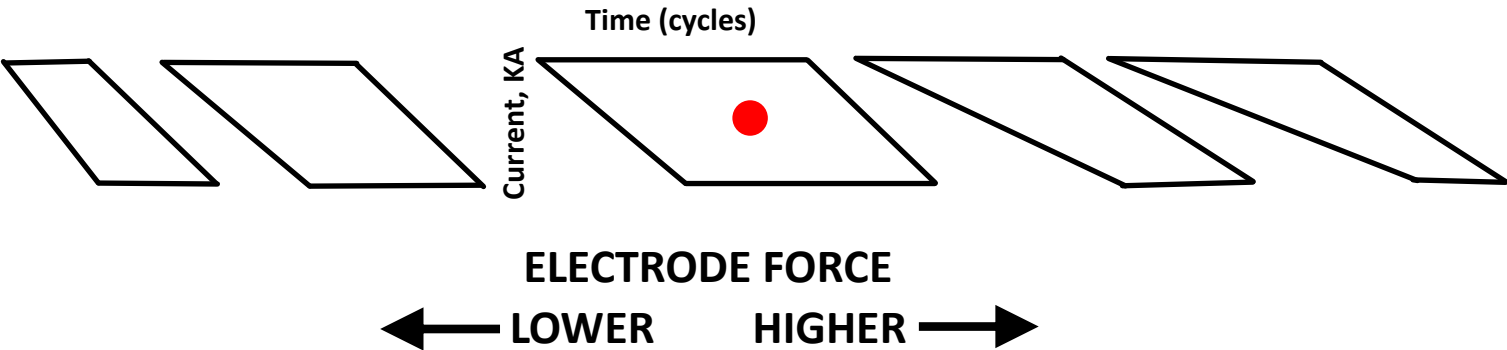
**STEP 5. Increase the Electrode force and repeat the same process for each line of welding current. The resulting lobe will be smaller and shift to the right.**

# DEVELOPING A WELDING LOBE



**STEP 6. Lower the Electrode Force and repeat the same process for each line. The resulting lobe will be smaller and shift to the left.**

# DEVELOPING A WELDING LOBE



**STEP 7. Find the electrode force setting that develops the largest size welding lobe. Then use the weld time and welding current that is in the middle of the lobe.**