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