

RESISTANCE WELDING EQUIPMENT & SUPPLY CO.

2045 East 46th Street

Indianapolis, IN 46205-1472

FFA #12

Water Cooling Needs

Proper water flow is essential to the life of your resistance spot welding equipment. Proper flow provides extended machine life, uniform spot welds, longer tip life and aids in the overall operation of your equipment.

This is especially true in the hot summer months, where we have many calls of burned up weld transformers, excessive mushrooming of weld tips and SCR contactors that have been damaged by improper water cooling both too hot and too cold. The lack of cooling water can cause your equipment to “Burn Up”, too much will cause excessive “sweating” (condensation build up) on transformers and SCR and end up costing you down time and replacement parts.

Study your cooling carefully!

Highly recommended is the use of refrigerated water cooled chillers. They drastically reduce water and sewer costs, as well as provide proper temperature water year round. Next... would be the piping, for proper flow to all zones of the plant and individual welders in the facility.

Each individual machine should be properly piped and use visual flow indicators, with FS-1 flow switches. Let us explain:

On a simple rocker arm welder, a ... **“Ball Type Visual Flow Indicator”** should be provided on the drain or outlet line. Seeing the ball movement in the indicator will assure you of proper flow through your welder. By using “Clear Plastic reinforced hose: throughout your welders cooling system, is another way to see the water flow. (Available: 1/4”, 3/8” or 1/2” ID hose sizes - call for information)

On larger press type welders the use of **“Pamark Manifolds”** is becoming a standard. **Blue** for cool water inlet and **Red** for hot water outlet helps in identifying water lines and keeping circuits from becoming mixed.

Individual flow indicators from the manifolds to the transformer, weld tips and SCR or Ignitrons of the control will help balance the flows and verify that there are no stoppages.

The model FS-1 water flow switch senses actual water flow. When connected to the emergency stop circuit of the welder, the FS-1 prevents your machine from welding without cooling water flow so no damage will occur.

We hope these ideas will be of assistance to you and aid you in securing longer welder transformer life, better welds and assurance that the water you are using is doing what is required:

KEEPING YOUR MACHINE COOL!

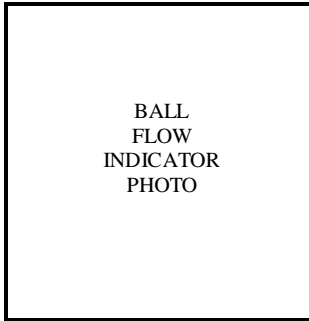
Visit us on the World Wide Web at: www.spotweldequip.com

YOUR PARTNER, SPECIALIZING IN RESISTANCE WELDING!

Spot – Projection – Seam – Butt Tips – Holders – Bar Stock Welding Transformers – Chillers
Cross-Wire and Fine Welders Cables and Jumpers Welding Controls and Monitors

PROTECT YOUR RESISTANCE WELDERS

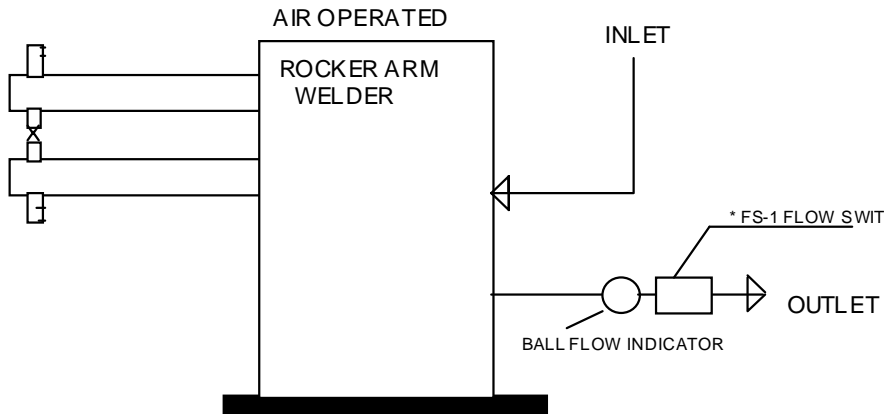
INSTALL BALL FLOW INDICATORS AND VISUALLY SEE THAT COOLING WATER IS FLOWING THROUGH YOUR MACHINE



BALL TYPE VISUAL FLOW INDICATORS:

PIPE SIZE	PART NUMBER	PRICE
1/4" NPT	3048	\$ 47.25
3/8" NPT	3049	\$ 53.25
1/2" NPT	3050	\$ 58.50
3/4" NPT	3051	\$ 69.25
1" NPT	3054	\$ 107.25

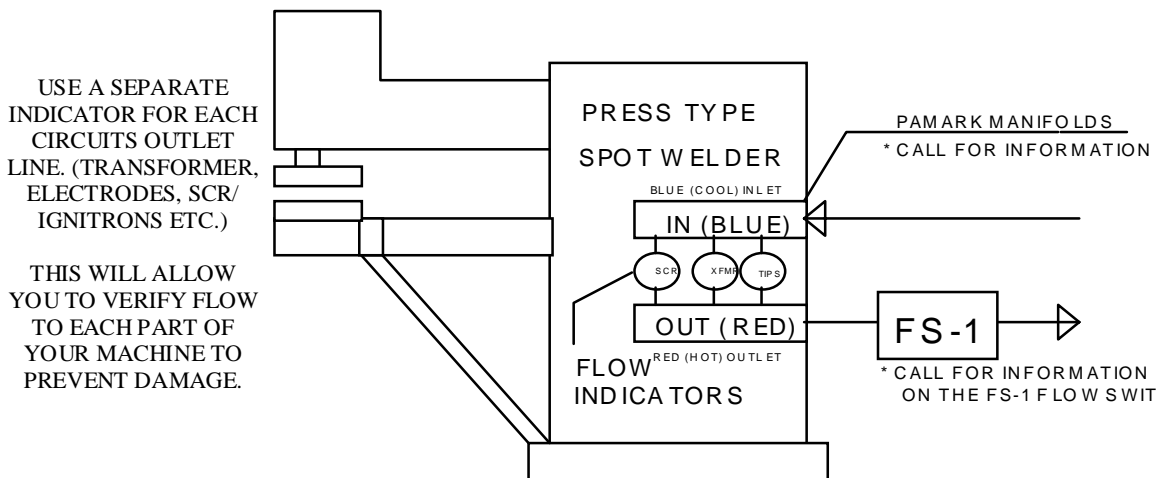
ROCKER ARM TYPE WELDER INSTALLATION OF BALL TYPE VISUAL FLOW INDICATOR



USE A MINIMUM OF (1) FLOW INDICATOR ON THE OUTLET OF YOUR SINGLE MACHINE WATER COOLING LINE.

IT IS PREFERRED THAT AN INDICATOR BE PLACED ON THE TRANSFORMER, SCR AND ELECTRODE WATER COOLING LINES.

PRESS TYPE WELDER INSTALLATION OF BALL TYPE VISUAL FLOW INDICATORS



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