

# Resistance Spot Welding Tips

1. Resistance welding is not recommended for aluminum, copper, or copper alloys. Use for steel and stainless steel only.
2. For more heat (amperage output), use shorter tongs.
3. For units without a heat control, tong length can be used for a control. For instance, for thin metals where you want less heat, longer tongs can be used.
4. Keep in mind that longer tongs can bend, and you may lose pressure at the weld.
5. For the metals being welded, make sure there is no gap between the pieces - this will weaken the weld.
6. Keep the alignment of the tongs straight, so that the tips touch each other exactly. Also, maintain a proper pressure adjustment - not too much or too little pressure.
7. When you need one side of the weld to have good appearance, you can flatten (machine) the tip somewhat on that side.
8. Clean the tips on a regular basis, or you will lose output (amperage). Dress the tips with a proper tip dresser.