



NCSX Weld Trial Photos







Horizontal Welds

	WFS (ipm)	Amps	Volts	Travel Speed (ipm)	Heat Input
Weld 1	350	193	20.0	12.6	18.381 KJ/in
Weld 2	350	191	20.9	12.4	19.316 KJ/in
Weld 3	350	193	18.3	12.6	16.819 KJ/in
Weld 4	350	190	19.6	14.4	15.517 KJ/in
Weld 5	350	183	20.8	13.7	16.670 KJ/in
Weld 6	350	190	19.6	12.5	17.875 KJ/in
Weld 7	350	189	19.0	11.7	18.415 KJ/in
Weld 8	350	181	21.0	11.0	20.733 KJ/in
Weld 9	350	191	20.5	11.8	19.909 KJ/in

Overhead Welds

	WFS (ipm)	Amps	Volts	Travel Speed (ipm)	Heat Input
Weld 1	230	137	15.0	9.5	12.979 KJ/in
Weld 2	230	130	15.7	10.0	12.246 KJ/in
Weld 3	230	129	16.9	9.5	13.769 KJ/in