



Firstweld™ Simulation Request Form

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Your name: _____ Company: _____ Contact #: _____

Geometry and Materials Data Spot Welding Projection/ Other Resistance Welding

Worksheets: Number of Sheets: _____

Sheet 1: Thickness: _____ Surface Coating (weight): _____ Coating Type: _____

Sheet Material (provide composition if possible): _____

Sheet 2: Thickness: _____ Surface Coating (weight): _____ Coating Type: _____

Sheet Material (provide composition if possible): _____

Sheet 3: Thickness: _____ Surface Coating (weight): _____ Coating Type: _____

Sheet Material (provide composition if possible): _____

Sheet 4: Thickness: _____ Surface Coating (weight): _____ Coating Type: _____

Sheet Material (provide composition if possible): _____

Electrodes:

Top: Part Number or Geometry (ex. A-nose): _____ Weld Face Diameter: _____

Electrode Material (Class I, Class II, etc.): _____

Bottom: Part Number or Geometry (ex. A-nose): _____ Weld Face Diameter: _____

Same as Top: Electrode Material (Class I, Class II, etc.): _____

Machine Settings and Weld Parameters

Welder Setup: AC: DC: kVA: _____

Welding Parameters: Force: _____ (lbf / kN) Squeeze time: _____ (ms/cyc) Hold time: _____ (ms/cyc)

Current Profile:	Upslope (ms/cyc)	Weld (ms/cyc)	Downslope (ms/cyc)	Cool (ms/cyc)	Heat (kA)
Pulse 1:	_____	_____	_____	_____	_____
Pulse 2:	_____	_____	_____	_____	_____
Pulse 3:	_____	_____	_____	_____	_____
Pulse 4:	_____	_____	_____	_____	_____
Pulse 5:	_____	_____	_____	_____	_____

Simulation Type: Single Simulation Optimization: Weld Current/Time Window Range: _____
 Nugget Size: _____