



MONITOR TROUBLESHOOTING – SOLUTIONS GUIDE

(For use with Current Feedback Controls)

Projection & Spot Welds			
Screen	Condition/Diagnosis	Possible Causes	Corrective Action
Thickness	Exceeds High Limit (HL).	Fit-up Problem.	Identify and correct.
		Electrodes damaged.	Dress or replace as needed.
	Exceeds Low Limit (LL).	Workpiece damaged or missing.	Identify and correct.
		Electrodes worn.	Replace electrodes and/or rezero linear transducer.
Force	Exceeds HL.	Force is too high.	Check head for binding; decrease pressure.
	Exceeds LL.	Force is too low.	Check head for binding; increase pressure.
	Varies widely	Friction in head.	Clean/ repair/ lubricate as required.
Current	Exceeds HL.	Problem with machine connections or control regulation.	Check machine connections/tune control settings/widen limits as required.
	Exceeds LL.		
Voltage	Exceeds HL.	Current set too high.	Decrease Current setting.
		Force is too low.	Check head for binding; increase pressure.
		Secondary resistance high.	Clean connections; replace cables, tips.
	Exceeds LL.	Current set too low.	Increase Current setting.
		Force is too high.	Check head for binding; decrease pressure.
Conductance	Exceeds HL.	Force is too high.	Check head for binding; decrease pressure.
		Secondary shorted.	Check connections, cables, shunts, etc.
	Exceeds LL.	Fit-up Problem.	Identify and correct.
		Force is too low.	Check head for binding; increase pressure.
		Secondary resistance high.	Clean connections; replace cables, tips.
Power	Exceeds HL.	Current set too high.	Decrease Current setting.
		Force is too low.	Check head for binding; increase pressure.
	Exceeds LL.	Current set too low.	Increase Current setting.
		Force is too high.	Check head for binding; decrease pressure.

Projection Welds		Displacement		Spot Welds	
Condition/Diagnosis	Possible Cause(s)	Corrective Action	Possible Cause(s)	Condition/Diagnosis	
Expulsion Weld is too hot.	Force is too low.	Check head for binding; increase pressure.	Force is too low.	Expulsion Weld is too hot.	
	Current set too high.	Decrease Current setting.	Current set too high.		
	Electrodes damaged.	Dress or replace as needed.	Electrodes damaged.		
Exceeds HL. Weld is substandard.	Force is too high.	Check head for binding; decrease pressure.	Force is too high.	Exceeds LL. Weld is substandard.	
	Current set too low.	Increase Current setting.	Current set too low.		
	Electrodes damaged.	Dress or replace as needed.	Electrodes damaged.		
Exceeds LL. Weld may still be acceptable.	Several.	Lower LL / Raise HL or take no action.	Several.	Exceeds HL. Weld may still be acceptable.	

The experts at WeldComputer are available to help with your particular application.

To learn more about our products, or to discuss your particular challenges and needs, please visit our website at weldcomputer.com or give us a call: **1-800-553-WELD (9353)**.