

# Monitor Troubleshooting – Solutions Guide

(For use with Current Feedback Controls)

PROJECTION & SPOT WELDS			
Screen	Condition/Diagnosis	Possible Causes	Corrective Action
Thickness	Exceeds (HL)	Fit-up problem	Identify and correct
		Electrodes damaged	Dress or replace as needed
	Exceeds (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 Causes	Corrective Action	Possible Causes	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 sub-standard	Force is too high	Check head for binding; decrease pressure	Force is too high	Exceeds LL Weld is sub-standard
	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 LL 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 [weldcomputer.com](http://weldcomputer.com) or call: 1-800-553-WELD (9353)