



Repair-40x01x45x06-02x65-1-1-1.xml



XSL version : 3.02 du 22/07/11

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SOLDERED ASSEMBLY EQUIPMENT: USE

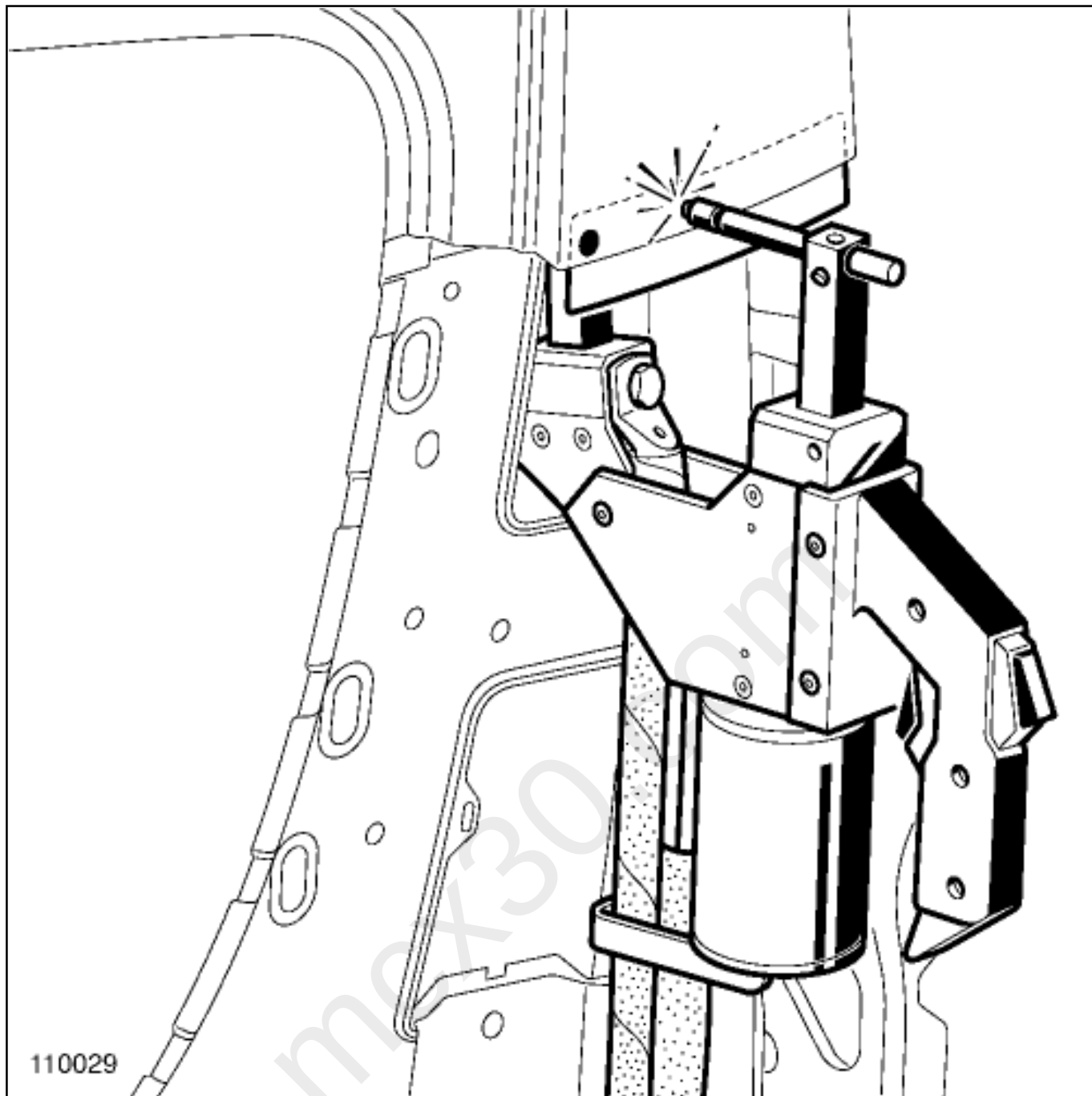
1. ELECTRICAL RESISTANCE SPOT WELDING

Used to weld mating faces where both sides are accessible (e.g.: door entries).

Ordinary welders can weld ordinary steel sheets, and some welders are designed for welding very high or ultra high yield (THLE/UHLE) strength sheets.

The welder used for THLE/UHLE sheets must have an effective minimum welding current of 11500 A. The effective clamp tightening pressure must be a minimum of 450 daN.m. When the appliance is fitted with a manual expansion valve, it is possible to reduce the pressure, but the pressure cannot be measured. Only a peeling test will enable you to check whether the welding bead diameter is enough.

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■ Advantage:

- Identical to original welds.

■ Disadvantage:

- Cannot apply welds over 250 mm from the edge the sheet.

■ Operator protection:

- obligatory eye protection,
- obligatory hand protection.

■ Protection in the work area:

- external bodywork protection,
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- protection of internal and external window faces,

- protection of interior fittings.

2. ARC WELDING UNDER SHIELDING GAS

Used for plug welding sheets, for original weld beads as well as continuous welds on edge-to-edge cuts.

The contact tube and the nozzle must be cleaned regularly so that the gas and the wire are free. To do this, use an anti-splash product.



The welder exists in two versions:



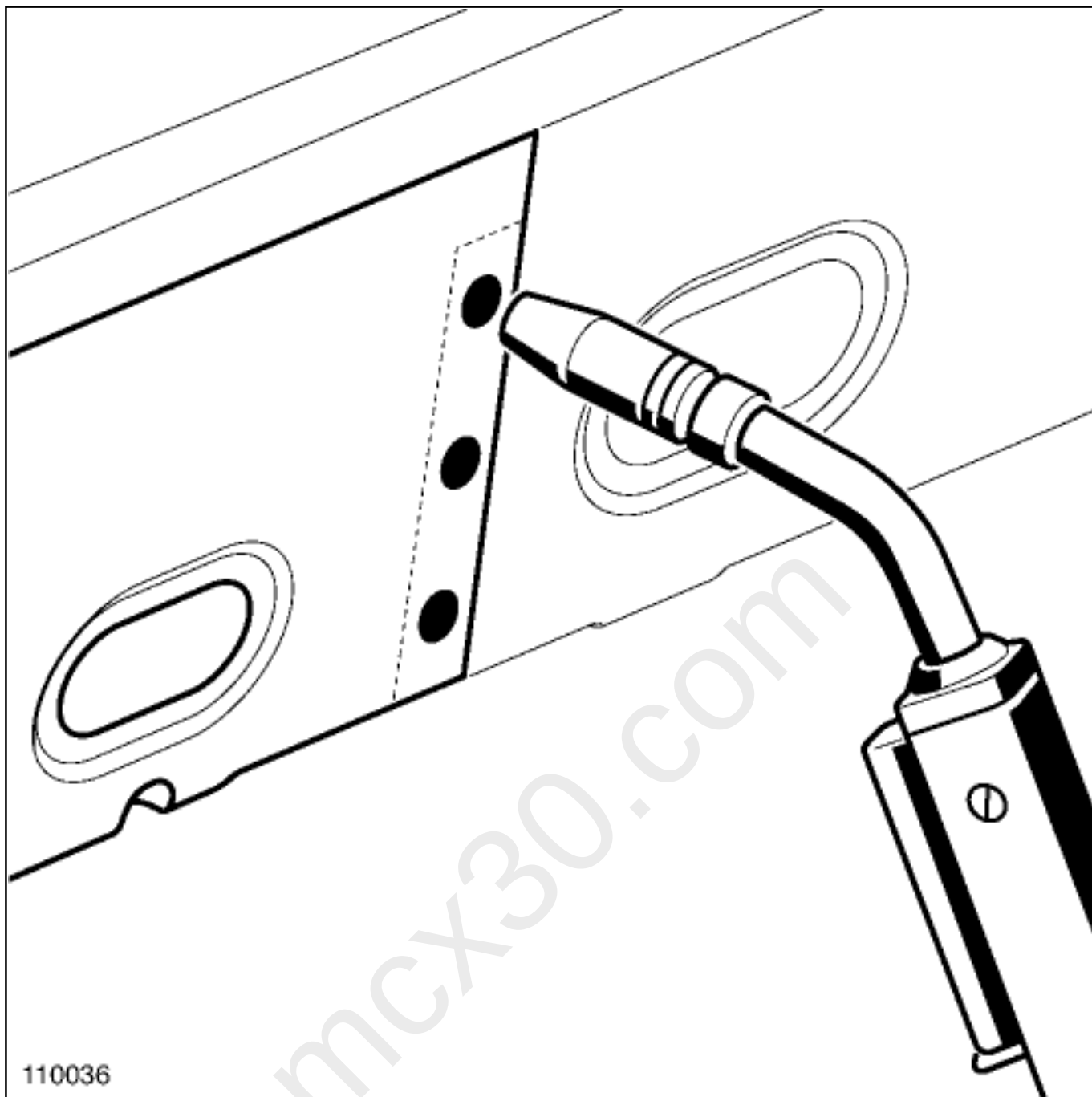
- MAG = Metal Active Gas. The gas mixture contains more than 5% CO₂.



- MIG = Metal Inert Gas. The gas mixture contains less than 5% CO₂.

For routine bodywork jobs, the welder can have a minimum welding current of 200 A with a range of use for welding sheets of 0.6 mm to 4 mm, with a wire Ø 0.6 to 0.8 mm.

PLUG WELDING POINT



■ Advantage:

■ Allows the making of spot welds throughout the sheet by replacing the original SER points.

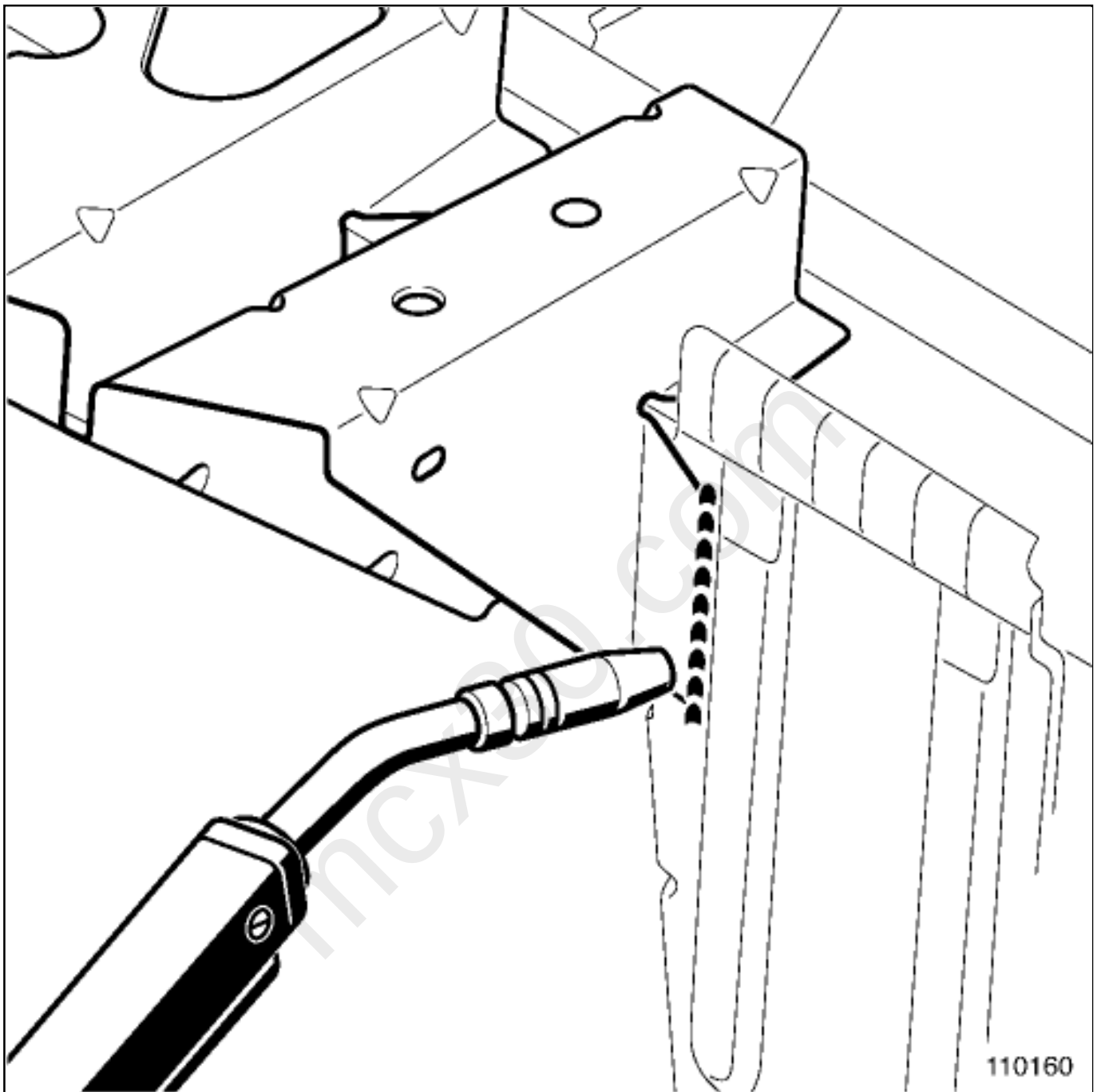
■ Disadvantages:

■ Anticorrosion treatment before assembly is very delicate,

■ Impossibility of sealing the mating surfaces before welding,

Requires perfect mating to obtain correct visible points.

ORIGINAL BEAD



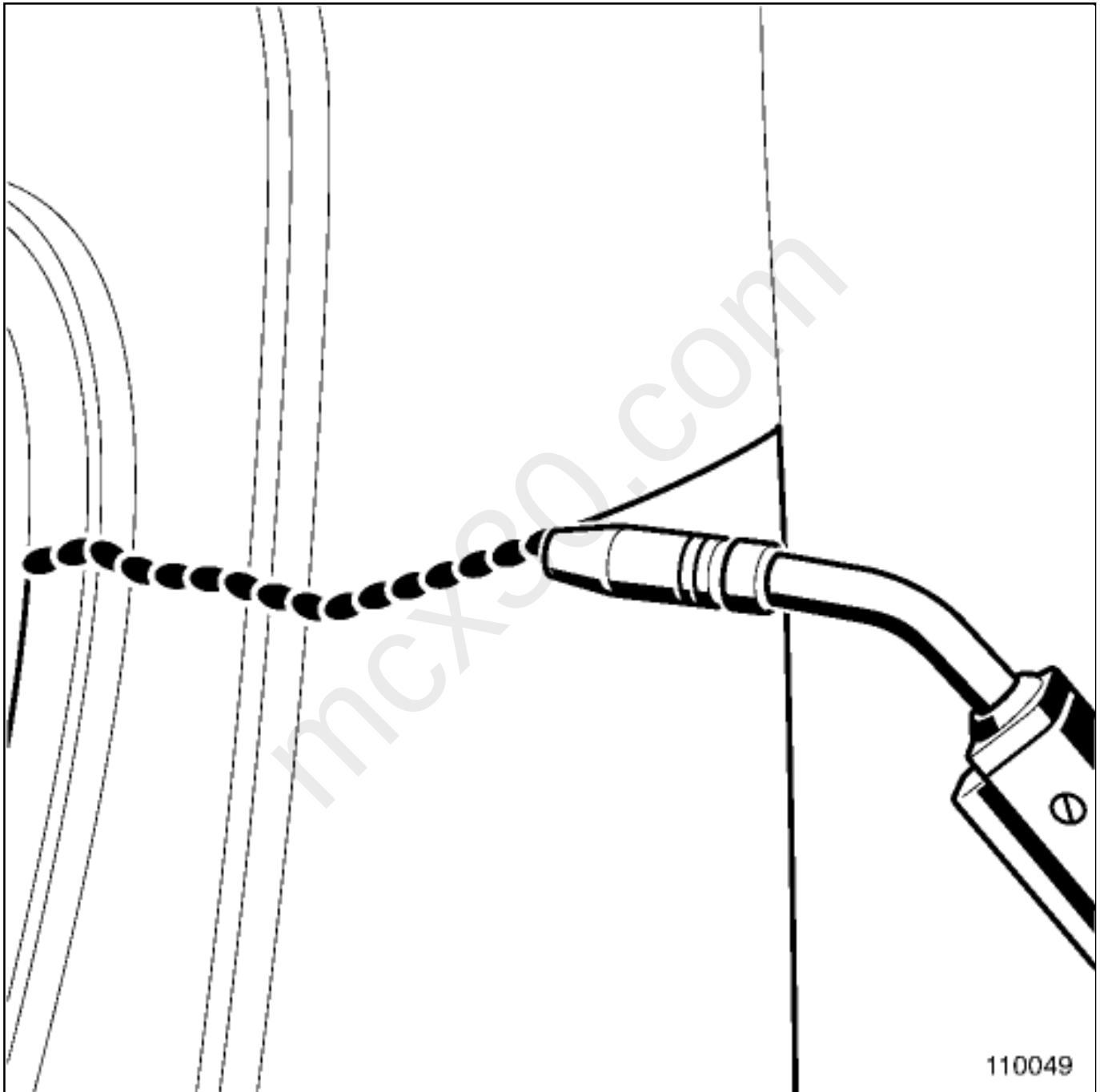
Advantage:

Identical to original welds.

Disadvantages:

- Anticorrosion treatment before assembly is very delicate,
- Impossibility of sealing the mating surfaces before welding,
- Requires perfect mating to obtain a correct visible bead.

CHAIN BEAD



Advantages:

