

Student _____

Group _____

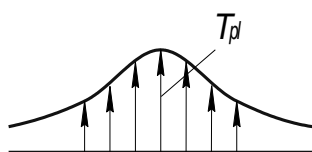
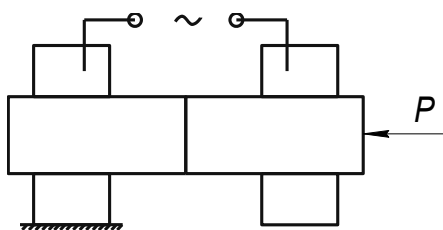
Laboratory work № 2 «Resistance butt welding and soldering»

Upset (butt resistance) welding is used for _____

The main parameters of the upset welding are _____

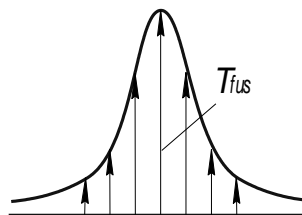
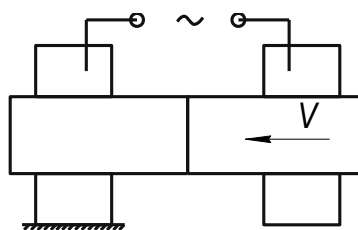
Flash welding is suitable for _____

The main parameters of the flash welding are _____



a)

a) _____



b)

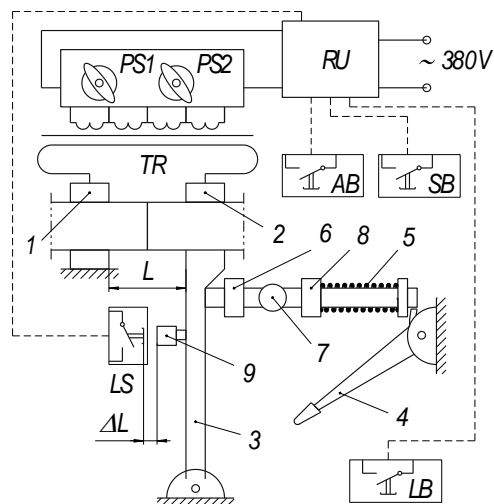
b) _____

Technical data of the machine MC-301

- Nominal power – _____ kW;
- Supply voltage – _____ V.
- Cross-section welded: steel – _____ mm²; copper alloys – _____ mm².
- Maximum of squeezing force – _____ kN.
- Number of power level – _____.
- Secondary voltage – _____ V.
- Welding current – _____ kA.

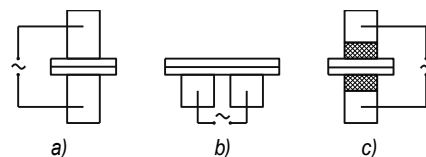
Electric circuit of the machine MC-301

- PS1, PS2 – _____;
- RU – _____; TR – _____;
- AB – _____; SB – _____;
- LS – _____; 1 – _____;
- 2 – _____; 3 – _____;
- 4 – _____; 5 – _____;
- 6 – _____; 7 – _____;
- 8 – _____; 9 – _____;



Process of resistance brazing

- a) _____
- b) _____
- c) _____



Protocol of the sample testing

Material – _____				Brazier – _____			
Cross-section area, mm ² - _____				Flux - _____			
№	Type of process	Pressing force, kN	Power level	Upset distance, mm	Welding time, sec	Distractive force, P, kN	Nature of disruption
1	Welding						
2	Welding						
3	Welding						
4	Soldering						
5	Soldering						

Conclusion: _____

Rating _____

Instructor's signature _____