

**LAA-5131 - Recorded Joint Welding Procedure for Resistance Welding**

**Cover Sheet**

(Please Type or Print)

Parts supplied by:

Welded by:

1. Company Name: \_\_\_\_\_ 4. Company Name: \_\_\_\_\_

2. Company Address: \_\_\_\_\_ 5. Company Address: \_\_\_\_\_  
\_\_\_\_\_

3a. Supplier Signature/Date: \_\_\_\_\_ 6. Fabricator Signature/Date: \_\_\_\_\_

3b. Supplier Phone Number: \_\_\_\_\_

3c. Supplier Contact: \_\_\_\_\_

For

BAE Systems  
Land & Armaments  
P.O. Box 15512  
York, PA 17405-1512

Or

BAE Systems  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

ATTN: \_\_\_\_\_  
(Buyers Name)

7a. P/O Part Number	7b. Part Name	7c. P/O Number	7d. Contract Number	7e. Weldment Part Number

In accordance with

8. Specification:

<input type="checkbox"/> MIL-W-12332	<input type="checkbox"/> MIL-DTL-45210	<input type="checkbox"/> MIL-W-6858 (CANCELLED SUPERCEDED BY SAE.AMS-W6858)
<input type="checkbox"/> OTHER:		

9. Specification Revision: \_\_\_\_\_

10. BAE Systems Signature/Date: \_\_\_\_\_

**Parameter and Drawing Sheet**

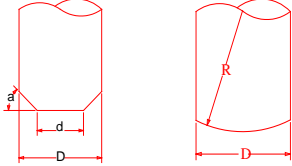
Company Name: \_\_\_\_\_

WP No: \_\_\_\_\_

1. Resistance Welding Process: Spot  Projection  Seam

2. Welding Machine Identification: \_\_\_\_\_

3. Electrodes



	3a.	3b.	3c.	3d.	3e.
	<u>D, in.</u>	<u>d, in.</u>	<u>a, degrees</u>	<u>R, in.</u>	<u>Material</u>
Upper	_____ "	_____ "	_____ °	_____ "	_____
Lower	_____ "	_____ "	_____ °	_____ "	_____

4. Electrode Force: a. Applied Force \_\_\_\_\_ LBS or b. Gauge Pressure \_\_\_\_\_ PSI Cylinder Area \_\_\_\_\_ in<sup>2</sup>

5. Welding Current: a. Transformer Tap \_\_\_\_\_ b. Phase Shift \_\_\_\_\_ % c. Secondary Current \_\_\_\_\_ Amps  
d. Current Type: AC  DC

6. Welding Sequence Timing:

<u>Single Impulse</u>		<u>Multiple Impulse</u>	
a. Squeeze Time: _____ Cycles	d. Squeeze Time: _____ Cycles	g. Number of Pulses: _____	
b. Weld Time: _____ Cycles	e. Heat Time: _____ Cycles	h. Hold Time: _____ Cycles	
c. Hold Time: _____ Cycles	f. Cool Time: _____ Cycles		

7. Seam Welding Travel Speed: \_\_\_\_\_ IPM 8. Cleaning Method: \_\_\_\_\_

9. Provide below a simple drawing or sketch that clearly shows the type of joint, including dimensions, tolerances and braze symbols.

10. Weldment Part Number: \_\_\_\_\_

**Part List**

Piece Part Number	Piece Part Name	Thickness	Material Specification	Material Type