



## **Water Quality for water-cooled rectifiers**

For trouble free operation of your water-cooled Rectifier, Please follow the guidelines below as written in part from *Bulletin #5, Resistance Welding Control Standard* published by the *Resistance Welding Manufacturer's Association*. In which our rectifiers fall under.

.01 Water flow rate shall be 1.2 G.P.M. per 1K amps output minimum. Some larger SCR contactors require greater flow rates.

.02 Maximum water pressure shall be 90 P.S.I.G.

.03 Cooling Water temperature should be no greater than 60°F (15.5°C)

.04 Maintain a pH between 7.0 and 8.0

.05 Maximum Chloride content of 20 PPM.

.06 Maximum Nitrate content of 10 PPM.

.07 Maximum Sulfate content of 100 PPM.

.08 Maximum solids content of 250 PPM.

.09 Maximum Calcium Carbonate content of 250 PPM.

Water should be chemically natural. Distilled, RO and DI water is unsuitable for the unit's copper lines and should not be ran. Conductivity should be kept at 300 - 500  $\mu$ S/cm.