



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.