

Weld Time Chart

	Length of Bore						
	1"	2"	3"	4"	6"	10"	
Bore Diameter	1	1.3	2.5	3.8	5.0	7.5	12.6
	2	2.5	5.0	7.5	10.0	15.1	25.1
	3	3.8	7.5	11.3	15.1	22.6	37.7
	4	5.0	10.0	15.1	20.1	30.1	50.2
	5	6.3	12.6	18.8	25.1	37.7	62.8
	6	7.5	15.1	22.6	30.1	45.2	75.4
	8	10.0	20.1	30.1	40.2	60.3	100.5
	10	12.6	25.1	37.7	50.2	75.4	125.6
	12	15.1	30.1	45.2	60.3	90.4	150.7
	16	20.1	40.2	60.3	80.4	120.6	201.0
20	25.1	50.2	75.4	100.5	150.7	251.2	

Weld Times (in minutes) All times are calculated with rotation speed of 20"/min and step size of .125"