**Tabel 1.** Variasi Parameter Proses Pengelasan

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **No. Spc** | **Kuat Arus (A)** | **Pendingin** | **Kekerasan Vikers hardness (HV)** | **Mikro Struktur** |
| 1 | 80 | Air | - | - |
| 2 | 80 | Udara | - | - |
| 3 | 80 | Olie | - | - |
| 4 | 100 | Air | - | - |
| 5 | 100 | Udara | - | - |
| 6 | 100 | Olie | - | - |
| 7 | 120 | Air | - | - |
| 8 | 120 | Udara | - | - |
| 9 | 120 | Olie | - | - |

**Tabel 2.** Hasil Pengujian Kekerasan Vikers Hardness (HV)

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **No. Spc** | **Kuat Arus (A)** | **Pendingin** | **Kekerasan Vikers Hardness (HV)** | | | |
| **Left** | **Weld** | **Right** | **Rata-rata** |
| 1 | 80 | Air | 283.2 | 317 | 283.2 | 294.4 |
| 2 | 80 | Udara | 2811.7 | 286.5 | 2811.7 | 283.3 |
| 3 | 80 | Oli | 278.7 | 293.8 | 278.7 | 283.7 |
| 4 | 100 | Air | 284.8 | 323 | 284.8 | 297.5 |
| 5 | 100 | Udara | 278.7 | 290 | 278.7 | 282.4 |
| 6 | 100 | Oli | 277 | 290 | 277 | 281.3 |
| 7 | 120 | Air | 280.2 | 330 | 280.2 | 296.8 |
| 8 | 120 | Udara | 281.7 | 395.7 | 281.7 | 286.3 |
| 9 | 120 | Oli | 276 | 291.8 | 276 | 281.2 |