**Tabel 1.** Variasi Parameter Proses Pengelasan

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **No. Spc** | **Kuat Arus (A)** | **Pendingin** | **Impact Charpy** | **Struktur Makro** |
| 1 | 120 | air | - | - |
| 2 | 120 | udara | - | - |
| 3 | 120 | olie | - | - |
| 4 | 130 | air | - | - |
| 5 | 130 | udara | - | - |
| 6 | 130 | olie | - | - |
| 7 | 140 | air | - | - |
| 8 | 140 | udara | - | - |
| 9 | 140 | olie | - | - |

**Tabel 2.** Hasil Pengujian Impact dan Hasil Perhitungan Impact

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **No. Spc** | **Kuat Arus (A)** | **Pendingin** | **E**  **(Joule)** | **IS**  **(Joule/mm2)** |
| 1 | 120 | air | 8.022 | 0.100 |
| 2 | 120 | udara | 7.463 | 0.093 |
| 3 | 120 | olie | 8.755 | 0.109 |
| 4 | 130 | air | 13.202 | 0.165 |
| 5 | 130 | udara | 2.286 | 0.029 |
| 6 | 130 | olie | 3.219 | 0.040 |
| 7 | 140 | air | 1.135 | 0.014 |
| 8 | 140 | udara | 2.743 | 0.034 |
| 9 | 140 | olie | 7.186 | 0.090 |