Spot welding galvanized low-carbon steel

Material Thickness	Electrode Diameter And Shape			Net Electrode Force	Welding Current (Approx.)	Weld Time	Weld Nugget Size	Minimum Tension-Shear Strength	Minimum Weld Spacing	Minimum Contacting Overlap
notes 1, 2, & 3	note 4									
	D	d	Oc							
Inches	In.	In.	Deg.	Lb.	Amps.	Cycles	In.	Lb.	Inches	Inches
0.022	5/8	3/16	120	300	13000	8	0.15	550	5/8	5/8
0.030	5/8	3/16	120	400	13000	10	0.16	1000	5/8	5/8
0.036	5/8	1/4	120	500	13500	12	0.19	1180	3/4	5/8
0.039	5/8	1/4	120	650	14000	13	0.21	1400	3/4	5/8
0.052	5/8	1/4	120	725	14500	18	0.22	1700	7/8	11/16
0.063	3/4	1/4	120	850	15500	22	0.24	2500	1-1/8	3/4
0.078	3/4	5/16	120	1200	19000	24	0.28	3200	1-1/4	7/8
0.093	3/4	3/8	120	1400	21000	30	0.34	4200	1-1/2	1
0.108	7/8	3/8	120	1750	20000	37	0.40	5900	1-3/4	1-1/8
0.123	7/8	3/8	120	2000	20000	42	0.48	7200	2	1-1/8

Projection welding galvanized low-carbon steel

Material Thickness	Electrode Diameter And Shape		Net Electrode Force	Welding Current (Approx.)	Weld Time	Weld Nugget Size	Minimum Tension-Shear Strength	Projection Size	
notes 1, 2, & 3	note 4						(For Single Projections Only)		
	D	d						Diameter	Height
Inches	In.	In.	Lb.	Amps.	Cycles	In.	Lb.	In.	In.
0.039	5/8	3/8	250	10000	15	0.15	925	0.187	0.041
0.063	5/8	7/16	400	11500	20	0.25	2050	0.218	0.048
0.078	3/4	1/2	550	16000	25	0.25	2700	0.250	0.054
0.093	3/4	1/2	750	16000	30	0.30	4300	0.250	0.054
0.108	7/8	1/2	950	22000	33	0.31	4900	0.250	0.054

NOTES:

1. Material must be free from dirt, grease, paint etc. prior to welding, but may have light oil.
2. Two equal metal thicknesses of each gage.
3. Commercial coating weight is 1.25 oz. per square foot.
4. Electrode Material-RWMA Group A, Class
5. CMW# 3.
6. Water Cooling: 2 gallons per minute.

Projections should be larger in diameter for galvanized than for uncoated material.

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