

Spot Welding Schedules for CRCA Steel Sheets					
Class A					
Sheet Thickness	Weld Cycles	Net Electrode Force	Current	Nugget Diameter	Yield Strength
t	t	F	I	d'	U
mm	~	daN	Amp	mm	KgF
0.25	3-4	91	4600	3.3	106
0.5	5	130	6100	4.3	240
0.8	6	180	8000	5	440
1	8	230	9500	5.8	610
1.3	10	295	10500	6.3	825
1.6	11	362	11600	6.9	1060
2	17	498	13300	7.9	1463
2.5	21	590	14700	8.6	1865
2.8	24	725	16100	9.4	2406
3	25	815	17500	10.2	3128
3.5	34	925	18200	11.2	3880
4	41	1030	18900	11.9	4750
4.3	50	1120	19500	12.9	5200
4.7	60	1255	20200	13.7	6050
5	70	1320	20900	14.7	6700
5.5	79	1450	21600	15.5	7300
5.8	88	1560	22300	16.5	8000
6.3	96	1750	23000	17.3	8550
6.6	106	1850	23600	18	9300
7	116	2000	24400	19	9850
8	135	2400	25700	20.8	10800
Starting values, based on our experience					