

Spot Welding Schedules for CRCA Steel Sheets					
Class B					
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	4	59	3700	3.2	91
0.5	8	91	5100	4.1	208
0.8	12	125	6300	5.1	385
1	17	163	7500	5.6	556
1.3	20	186	8000	5.8	770
1.6	24	227	9000	6.6	975
2	30	293	10400	7.6	1370
2.5	36	358	11400	8.4	1766
2.8	41	435	12200	9.1	2293
3	50	516	12900	9.9	2944
3.5	60	635	14100	11.4	4200
4	70	635	14500	11.4	4200
4.3	89	715	14700	12.2	4870
4.7	106	800	15300	13	5450
5	122	880	15900	13.7	6100
5.5	138	970	16450	14.5	6680
5.8	155	1040	17000	15.2	7350
6.3	170	1140	17600	16	7950
6.6	185	1230	18100	168	8500
7	205	1310	18700	17.5	9000
8	235	1480	19800	18.8	10000
Starting values, based on our experience					