

Spot Welding Schedules for CRCA Steel Sheets					
Class C					
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	12	29	3000	2.8	73
0.5	18	48	3000	3.5	177
0.8	24	61	4700	4.6	358
1	31	81	5600	5.3	536
1.3	35	93	6100	5.6	725
1.6	40	113	6800	6.4	929
2	48	147	7900	7.1	1314
2.5	55	177	8800	7.9	1696
2.8	60	217	9500	8.9	2197
3	65	259	10000	9.4	2786
3.5	85	280	10600	10.2	3380
4	104	317	11000	10.7	3900
4.3	126	358	11400	11.4	4420
4.7	152	400	11750	11.9	5040
5	175	440	12200	12.7	5600
5.5	197	485	12500	13.2	6120
5.8	221	520	12900	13.2	6120
6.3	241	570	13200	14.5	7230
6.6	265	617	13600	15	7770
7	291	650	14000	15.7	8370
8	337	740	14800	17	9000
Starting values, based on our experience					