

Spot Welding Data for Stainless Steels

Sheet Thickness	Electrode Body Diameter	Electrode Contact Diameter	Pitch (Min)	Contact Overlap (Min)
t	D	d	P	L
mm	mm	mm	mm	mm
0.20	4.80	2.40	4.80	4.80
0.30	6.40	3.20	6.40	6.40
0.40	6.40	3.20	7.90	6.40
0.50	6.40	4.00	4.80	7.90
0.60	9.50	4.00	11.10	9.50
0.80	9.50	4.80	12.70	9.50
0.90	9.50	4.80	14.30	11.10
1.00	9.50	4.80	15.90	11.10
1.10	9.50	4.80	17.50	11.10
1.30	12.70	6.40	19.10	12.70
1.40	12.70	6.40	22.20	14.30
1.60	12.70	6.40	25.40	15.90
1.80	15.90	6.40	28.60	15.90
2.00	15.90	7.90	31.80	17.50
2.40	15.90	7.90	34.90	19.10
2.80	19.10	9.50	38.10	20.60
3.20	19.10	9.50	50.80	22.20

Starting values indicated above based on our experience