

### Welding Data for Stainless Steels

Sheet Thickness	Weld Cycles	Net Electrode Force	Current For sheets with UTS		Nugget Diameter	Yield Strength For sheets with UTS		
			< 10 T/cm <sup>2</sup>	> 10 T/cm <sup>2</sup>		Bet 5-7 T/cm <sup>2</sup>	Bet 7-10 T/cm <sup>2</sup>	> 10 T/cm <sup>2</sup>
t	t	F	I	I	d'	U	U	U
mm	~	KgF	Amp	Amp	in	KgF/cm <sup>2</sup>	KgF/cm <sup>2</sup>	KgF/cm <sup>2</sup>
0.20	3.00	91.00	2000	2000	1.40	7	9	10
0.30	3.00	118.00	2100	2000	1.90	13	15	18
0.40	4.00	150.00	3000	2500	2.20	20	21	27
0.50	4.00	181.00	4000	3200	2.50	26	33	35
0.60	5.00	236.00	5000	4100	3.00	35	42	48
0.80	5.00	295.00	6000	4800	3.30	48	56	65
0.90	5.00	340.00	7000	5500	3.80	56	65	77
1.00	5.00	408.00	7800	6800	4.10	70	89	98
1.10	7.00	454.00	8700	7000	4.60	84	102	120
1.30	7.00	544.00	9600	7500	4.80	102	120	141
1.40	9.00	612.00	10300	8300	5.30	120	141	172
1.60	9.00	680.00	11000	9000	5.60	137	172	204
1.80	10.00	771.00	12300	10000	6.40	169	197	250
2.00	12.00	862.00	14000	11000	7.00	190	239	281
2.40	14.00	1089.00	15700	12700	7.20	250	295	373
2.80	15.00	1270.00	17700	14000	7.40	295	352	450
3.20	17.00	1497.00	18000	15500	7.60	352	422	534

Starting values indicated above based on our experience