

Guidelines for Welding of Three Sheets Together

Upper Sheet: U			
Middle Sheet: M			
Lower Sheet: L			
Sheet Sizes	Tip Dia Suitable for	Weld Schedules	Max Thickness Ratio
$U = L$	U	U	-
$U < L$	U	U	$U : L = 1 : 4$
$U = M = L$	U	$U + 10\%$	-
$M < U < L$	U	$U + 10\%$	$U : L = 1 : 2.5$
$U < L < M$	L	$L + 10\%$	$U : L = 1 : 2.5$
$U < M < L$	M	$M + 10\%$	$U : L = 1 : 2.5$
$U = L > M$	U	$U + 10\%$	$U : M = 1 : 4$
$U = L < M$	U	$U + 10\%$	$U : M = 1 : 3$
$U < M = L$	L	$L + 10\%$	$U : L = 1 : 2.5$
$U = M < L$	U	$U + 15\%$	$U : L = 1 : 2.5$

Starting values based on experience and experiments