

Seam Welding Data for CRCA Sheets

| Thickness of Outside Piece | Wheel Thickness | Contact Thickness | Net Electrode Force | Weld Time | Off Time | Weld Speed | Welds per cm | Welding Current | Minimum Contacting Overlap |
|----------------------------|-----------------|-------------------|---------------------|-----------|----------|------------|--------------|-----------------|----------------------------|
| mm | mm | mm | KGF | Cycles | Cycles | cm/min | cm | Amp | mm |
| 0.3 | 9.5 | 4.8 | 181 | 2 | 1 | 203 | 5.9 | 8000 | 10 |
| 0.5 | 9.5 | 4.8 | 249 | 2 | 2 | 191 | 4.7 | 11000 | 11 |
| 0.8 | 12.7 | 6.4 | 318 | 3 | 2 | 183 | 3.9 | 13000 | 13 |
| 1.0 | 12.7 | 6.4 | 408 | 3 | 3 | 170 | 3.5 | 15000 | 13 |
| 1.3 | 12.7 | 7.9 | 476 | 3 | 3 | 165 | 3.1 | 16500 | 14 |
| 1.6 | 12.7 | 7.9 | 544 | 3 | 3 | 160 | 2.8 | 17500 | 16 |
| 1.9 | 15.9 | 9.5 | 680 | 5 | 4 | 140 | 2.4 | 19000 | 17 |
| 2.4 | 15.9 | 11.1 | 771 | 6 | 5 | 127 | 2.2 | 20000 | 19 |
| 2.8 | 19.1 | 12.7 | 885 | 8 | 5 | 122 | 2.0 | 21000 | 21 |
| 3.2 | 19.1 | 12.7 | 998 | 9 | 6 | 114 | 1.8 | 22000 | 22 |

Starting values indicated above based on our experience