



Spot Welding Data Galvanized Steel

Galvanized steel sheet is available in various base metal compositions, coating types and surface treatments. Compared to uncoated steel, more frequent dressing of the electrodes is required. This is to maintain the proper shape of the electrode and to help reduce coating pickup by the electrodes.

Thickness	Gauge	Tip Face	Tip Pressure	Weld Current	Weld Time	Edge Overlap	Weld Space
.022"	26	3/16"	310	8,800	6	7/16"	3/8"
.031"	22	3/16"	450	9,500	7	7/16"	1/2"
.036"	21	3/16"	550	11,000	9	1/2"	3/4"
.051"	18	7/32"	800	14,000	12	9/16"	7/8"
.064"	16	1/4"	1,050	15,500	15	5/8"	1 1/16"
.078"	14	5/16"	1,350	19,500	18	11/16"	1 3/8"
.093"	13	11/32"	1,700	23,000	22	3/4"	1 5/8"
.108"	12	11/32"	2,200	26,000	25	13/16"	1 13/16"
.123"	11	13/32"	2,500	28,000	28	7/8"	2"
.138"	10	7/16"	3,000	31,000	33	1 1/8"	2 1/4"

****NOTE:** Weld times are with Up Slope included.

Machine Recommendations: Rocker or Press type, air operated.

Electrode Recommendation: Class 2 Zirconium or Aluminum-Oxide Dispersion-Strengthened Copper (Glidcop).