



## Spot Welding Data Low Carbon Steel

Low carbon/mild steels are the most commonly welded materials. A satisfactory weld can be achieved over a wide range of time, current and force.

Thickness	Gauge	<b>Tip Face</b>	Тір	Weld	Weld	Edge	Weld
			Pressure	Current	Time	Overlap	Space
.010"	30	1/8"	200	4,000	2	3/8"	1/4"
.021"	25	3/16'	300	6,500	4	7/16"	3/8"
.031"	22	3/16"	400	8,000	5	7/16"	1/2"
.040"	20	1/4"	500	8,800	6	1/2"	3/4"
.050"	18	1/4"	650	9,600	8	9/16"	7/8"
.062"	16	1/4"	800	10,600	10	5/8"	1"
.078"	14	5/16"	1,100	11,800	13	11/16"	1 1/4"
.094"	13	5/16"	1,300	13,000	15	3/4"	1 1/2"
.109"	12	3/8"	1,600	14,200	18	13/16"	1 5/8"
.125"	11	3/8"	1,800	15,600	20	7/8"	1 3/4"

**Machine Recommendations:** Rocker or Press type, air operated. Press type is required for very thick material or when welding Medium Carbon or High Carbon-Low Alloy steels.

Electrode Recommendation: Class 2.