



## Spot Welding Data Stainless Steel

Stainless steel has good electrical and thermal resistance and requires low welding current. Higher weld forces are needed compared to other materials. Excessive heat and weld times should be avoided.

Thickness	Gauge	Tip Face	Tip Pressure	Weld Current	Weld Time	Edge Overlap	Weld Space
.010"	32	1/8"	230	2,000	1	3/16"	3/16"
.016"	28	1/8"	330	3,000	2	1/4"	1/4"
.022"	26	5/32"	400	3,200	2	5/16"	5/16"
.031"	22	3/16"	650	4,800	3	3/8"	1/2"
.040"	20	3/16"	900	6,300	4	7/16"	5/8"
.050"	18	1/4"	1,200	7,500	6	1/2"	3/4"
.062"	16	1/4"	1,500	9,000	7	5/8"	1"
.094"	15	5/16"	2,400	12,700	12	3/4"	1 3/8"
.109"	12	3/8"	2,800	14,000	14	13/16"	1 1/2"
.125"	11	3/8"	3,200	15,000	17	7/8"	2"

**Machine Recommendations:** Rocker or Press type, air operation required with careful consideration of tip pressure developed by the air cylinder in each model of welder.

**Electrode Recommendation:** Class 2 or Class 3.