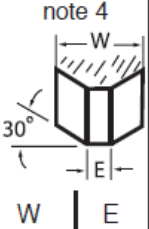





Seam welding galvanized low-carbon steel

Material Thickness notes 1, 2, & 3	Electrode Width And Shape note 4 		Net Electrode Force Lb.	Welding Current (Approx.) Amps.	Weld Time		Welding Speed In./Min.	Welds Per Inch W/In.	Minimum Contacting Overlap  Inches		
	Inches	In.			In.	Cycles				Heat Time	Cool Time
										Cycles	Cycles
0.015	3/8	1/4	900	15000	2	2	120	7.5	3/8		
0.036	1/2	1/4	1100	18000	4	2	60	10.0	1/2		
0.039	1/2	1/4	1200	19000	4	3	60	9.0	1/2		
0.052	1/2	1/4	1350	20000	5	1	90	7.0	9/16		
0.063	1/2	5/16	1500	19800	8	2	54	7.0	5/8		
0.078	5/8	5/16	1850	23000	10	7	30	7.0	11/16		

NOTES:

1. Material must be free from dirt, grease, paint etc. prior to welding, but may have light oil.
2. Two equal metal thicknesses of each gage.
3. Commercial coating weight is 1.25 oz. per square foot.
4. Electrode Material-RWMA Group A, Class 2. CMW# 3.
5. Pressure-tight joints require stripping the zinc coating prior to welding.
6. Nominal electrode diameter ranges between 8 to 10 inches.

From American Welding Society "Recommended Practices for Resistance Welding."