



SCHEDULE FOR SEAM WELDING STAINLESS STEEL

THICKNESS "T" OF THINNEST OUTSIDE PIECE (See Notes 1, 2, 3 and 4 Below)	ELECTRODE WIDTH AND SHAPE (See Note 5 Below)	ELECTRODE FORCE LB.	ON TIME CYCLES (60 Per Sec.)	OFF TIME FOR MAXIMUM SPEED (Pressure-Tight)		MAXIMUM WELD SPEED		WELDS PER INCH		WELDING CURRENT (Approx.) AMPS.	MINIMUM CONTACTING OVERLAP (See Note 6 Below)
				CYCLES		IN. PER MINUTE					
				2 "T"	4 "T"	2 "T"	4 "T"	2 "T"	4 "T"		
0.006	3/16	300	2	1	1	60	67	20	18	4000	1/4
0.008	3/16	350	2	2	2	67	56	18	16	4600	1/4
0.010	3/16	400	3	2	2	45	51	16	14	5000	1/4
0.012	1/4	450	3	2	2	48	55	15	13	5600	5/16
0.014	1/4	500	3	2	3	51	46	14	13	6200	5/16
0.016	1/4	600	3	2	3	51	50	14	12	6700	5/16
0.018	1/4	650	3	2	3	55	50	13	12	7300	5/16
0.021	1/4	700	3	2	3	55	55	13	11	7900	3/8
0.025	3/8	850	3	3	4	50	47	12	11	9200	7/16
0.031	3/8	1000	3	3	4	50	47	12	11	10600	7/16
0.040	3/8	1300	3	4	5	47	45	11	10	13000	1/2
0.050	1/2	1600	4	4	5	45	44	10	9	14200	5/8
0.062	1/2	1850	4	5	7	40	41	10	8	15100	5/8
0.070	5/8	2150	4	5	7	44	41	9	8	15900	11/16
0.078	5/8	2300	4	6	7	40	41	9	8	16500	11/16
0.094	5/8	2550	5	6	7	36	38	9	8	16600	3/4
0.109	3/4	2950	5	7	9	38	37	8	7	16800	13/16
0.125	3/4	3300	6	6	8	38	37	8	7	17000	7/8

NOTES:

- Types of Steel—301, 302, 303, 304, 308, 309, 310, 316, 317, 321, 347 & 349.
- Material should be free from scale, oxides, paint, grease and oil.
- Welding conditions determined by thickness of thinnest outside piece "T."
- Data for total thickness of pile-up not exceeding 4 "T". Maximum ratio between two thicknesses 3 to 1.
- Electrode material, CMW® 100
- For large assemblies minimum contacting overlap indicated should be increased 30 per cent.

From American Welding Society "Recommended Practices for Resistance Welding"