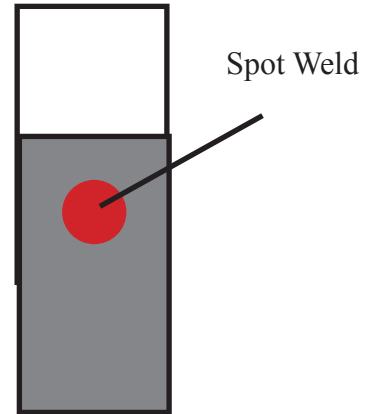


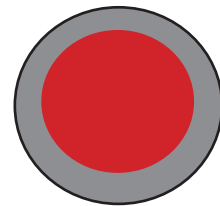
# BS1140 Spot welding Test



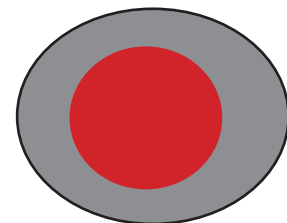
Two welds are to be carried out in total.

Weld tags are to be placed as shown and one spot weld placed in the centre.

**The 1.2mm to 1.2 mm** steel tags require a 5mm nugget minimum. ( Indentation )



The burn ring diameter shall not exceed the nugget diameter.  
The Burn ring diameter should be able to fit into the weld indentation more than twice.



**The 2.5 mm to 2.5mm** requires a 8mm spotweld nugget.  
Burn ring diameter shall not exceed the nugget diameter .

**Welds will be tear tested**

