



AWS Amendment Notice

The following Amendment has been made and incorporated into the current edition of this document.

2nd Printing: December, 2022

AWS Standard: C1.1M/C1.1:2019, *Recommended Practices for Resistance Welding*

Item Number: 1

Subject: The minimum weld button shear strength equation found in Tables 1, 4, and 5 (footnote d) has been amended as follows:

$$ST = \frac{(-6.36 \times 10^{-7} \times S^2 + 6.58 \times 10^{-4} \times S + 14.674) \times S \times 4 \times t^{1.5}}{1000}$$

Has been changed to:

$$ST = \frac{(-8.83 \times 10^{-7} \times S^2 + 1.34 \times 10^{-3} \times S + 1.514) \times S \times 4 \times t^{1.5}}{1000}$$

Tables 1, 4, and 5 (footnote d) now reads:

Minimum weld button shear strength determined as follows:

$$ST = \frac{(-8.83 \times 10^{-7} \times S^2 + 1.34 \times 10^{-3} \times S + 1.514) \times S \times 4 \times t^{1.5}}{1000}$$

ST = Shear Tension Strength (kN)

S = Base Metal Tensile Strength (MPa)

t = Material Thickness (mm)

The purpose of this amendment notice is to inform the public that a published standard has been technically corrected. An amendment is the correction of an error in substantive content in a published standard that had been inadvertently approved by the required approval procedures.

(Amendment Notice: October 6, 2022)

Item Number: 2

Subject: Table 1 header has been amended as follows:

- [72 ksi] has been changed to [50 ksi]

Table 1
Spot-Welding Parameters for Bare, Galvanneal, and Galvanized Low-Carbon Steel
<350 MPa [50 ksi] Ultimate Tensile Strength^{a, b, c, d}

Item Number: 3

Subject: Table of Contents: List of Tables: Table 4 title has been amended as follows:

- “350~700 MPa” has been changed to “350-700 MPa”

Title now reads:

“Spot-Welding Parameters for Bare, Galvanneal, and Galvanized Low-Carbon Steel
350-700 MPa [50–100 ksi] Ultimate Tensile Strength”

Item Number: 4

Subject: Table 4 header has been amended as follows:

- “[50–108 ksi]” has been changed to “[50–100 ksi]”

Table 4
Spot-Welding Parameters for Bare, Galvanneal, and Galvanized Low-Carbon
Steel 350–700 MPa [50–100 ksi] Ultimate Tensile Strength^{a,b,c,d,e}

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