

Steel Spot And Plug Weld Nugget Size: Rivian

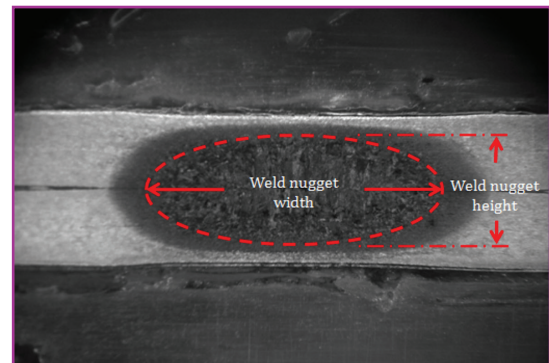


Rivian states in this document:

"DO NOT: Grind or sand weld nuggets flush unless noted in the repair procedure."

"All welding will require weld machine set up and destructive testing. Refer to: Welding Inspection & Testing."

"Use only approved GMA welding wire for repairs. This list of approved welding wire can be found in the Tools & Equipment Guidelines."



Did you know that many OEMs specify nugget size for spot and plug welds? This information is typically found within vehicle-specific repair procedures or can be found under general welding guidelines. Let's see what Rivian has to say.

Rivian provides general information pertaining to welding within their Collision Repair - Vehicle General Repair Guidelines document. This document is typically found linked within vehicle-specific collision repair procedures. Otherwise, it is found in vehicle-specific service manual under: Introduction - Collision Repair - General Information.

Spot Welding

Per the Collision Repair - Vehicle General Repair Guidelines:

"Match the original quantity and location(s) of factory spot-welds unless explicitly stated otherwise in the repair procedure."

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"Resistance spot welds should be placed adjacent to their original location(s) unless welding through multi-layer bonded joints."

"If welding through multi-layer bonded joints, place the spot weld through the existing spot weld location."

"All resistance welding must be performed before the structural adhesive cures."

"Use only spot-welder caps that produce weld nuggets matching the original size."



Plug Welding

Per the Collision Repair - Vehicle General Repair Guidelines:

"When determining plug weld hole size, refer to the vehicle specific repair procedures."

"GMA plug weld locations identified via fastener path(s) in repair procedures should replace the factory fastener locations that were separated during removal 1:1 along the path."

"Adhesive should be kept 25mm away from any MIG/MAG welds."

Where the spot weld and plug weld nugget size was not identified, refer to the Steel Spot And Plug Weld Nugget Size: UPDATE article. This article provides general guidelines.