



STRSW Destructive Weld Testing Nugget Chart for Honda and Acura Vehicles

Material Thickness	Square Root of Thickness	Minimum Nugget	Material Thickness	Square Root of Thickness	Minimum Nugget
0.5	0.71	3.18	1.7	1.30	5.87
0.6	0.77	3.49	1.8	1.34	6.04
0.7	0.84	3.76	1.9	1.38	6.20
0.8	0.89	4.02	2.0	1.41	6.36
0.9	0.95	4.27	2.1	1.45	6.52
1.0	1.00	4.50	2.2	1.48	6.67
1.1	1.05	4.72	2.3	1.52	6.82
1.2	1.10	4.93	2.4	1.55	6.97
1.3	1.14	5.13	2.5	1.58	7.12
1.4	1.18	5.32	2.6	1.61	7.26
1.5	1.22	5.51	2.7	1.64	7.39
1.6	1.26	5.69	2.8	1.67	7.53

To determine minimum nugget size, use the thickness of the thinnest panel in the stack.
Formula to calculate is: minimum nugget = 4.5 x square root of the thinnest panel's thickness.