

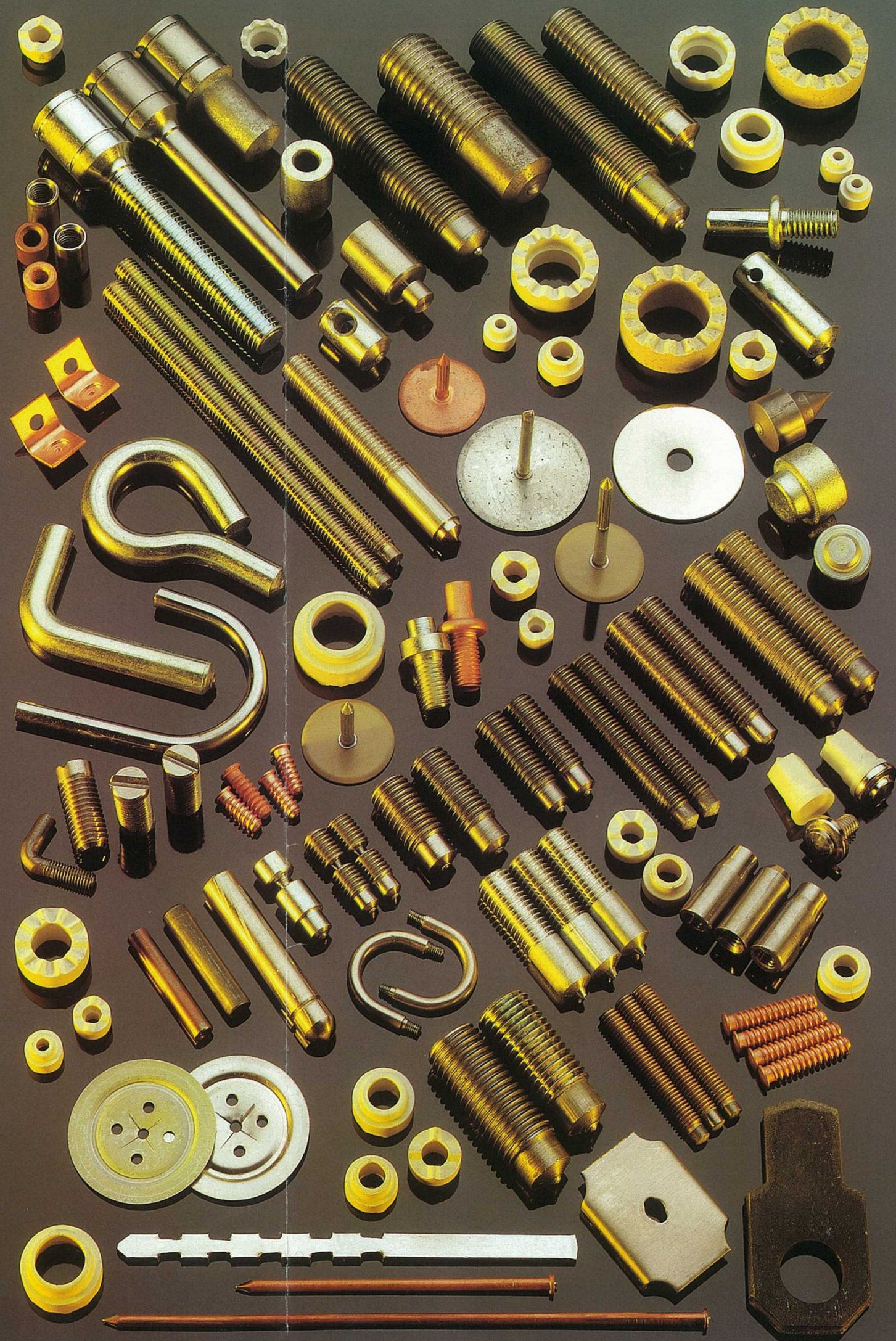
STUDWELDING

- fast to last

For optimum welding results Studfast DA Studwelding equipment, chucks and accessories should be used. For a demonstration of one of our British built studwelders, or advice on possible applications, contact our sales office.

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DA WELD STUDS



Some Specials: Made to Order

Drawn Arc "DA" Weld Studs

A symbol in the table indicates a stock item, the colour denotes the material as follows:

Technical Data:

During the Drawn Arc (DA) studwelding process there is a reduction in stud length and studs are manufactured with the appropriate welding allowance. This allowance varies according to stud diameter and material, as does the amount of flux deposited on the specially shaped weld end. The perfect weld is only achieved when enough power is used to give the correct Length After Weld "LAW".

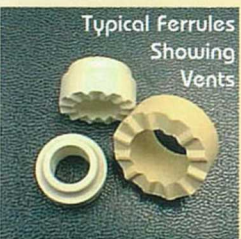
Typical DA Stud & Ferrule



The DA weld studs shown in the main table are self colour, threaded reduced base. Unthreaded studs, full base studs and tapped bosses are not stocked but can be made to order. Minimum order quantities will apply.

Minimum Order Quantities: The minimum order quantity for stock DA weld studs is 100 pieces.

Ceramic Ferrules: Each DA stud is supplied with a ceramic ferrule (arc shield), the function of which is to contain the weld fillet and draw impurities from the weld zone. The ferrule can only be used once. The outside diameter of this ferrule may be used for template location purposes, see below.



Plated Studs: DA studs can be supplied with a Zinc Di-Chromate, Cadmium or Copper plating. Plated studs are not stocked & minimum order quantities will apply. Weld ends are left unplated as Zinc and Cadmium are weld contaminants.

Stud Materials: Weld studs are manufactured from the following materials:

- Mild Steel: BS970 Part 1 040 A04 (Restricted specification)
- Stainless Steel: BS970 type 304S11

Thread Fit: All DA weld stud threads are rolled to a 6g free fit to BS 3643 part 2 ISO Metric Screw Threads.

To facilitate speedy processing of your order or enquiry please indicate quantity, diameter, 'LAW', material and finish required.

Templates: For accurate stud location templates should be used. Templates may be manufactured from either Tufnol, or for harder wear, from sheet metal.

When welding DA studs the holes in the templates should be big enough to accept the outside diameter (OD) of the ceramic ferrules shown in table opposite (note tolerances).

Templates should be spaced away from the parent material to allow the ferrule vents to draw impurities from the weld zone. This space should not allow the ferrule shoulder to fit under the template.

Further free advice is available on the manufacture of these templates from our sales office or local representative.

Data sheets covering weld strengths, weldability and safe tightening torques are available upon request.

Metric Threaded ▲ = Mild Steel ▲ = Stainless Steel LAW = Length After Weld

Stud Ø	M6 x 1.0	M8 x 1.25	M10 x 1.5	M12 x 1.75	M16 x 2.0
20x12	▲	▲			
25x16	▲	▲			
30x16		▲	▲	▲	
20	▲	▲	▲	▲	
25	▲	▲	▲	▲	
30	▲	▲	▲	▲	▲
35		▲	▲	▲	▲
40	▲	▲	▲	▲	▲
45			▲	▲	▲
50		▲	▲		▲
55				▲	
60			▲		▲
65				▲	
75				▲	

Price Breaks Occur At The Following Order Quantities for Stock Studs Only

	100	500	1000	2000	5000	10000
▲		▲	▲	▲	▲	▲
▲	▲	▲	▲	▲	▲	-

Ferrule Dimensions (mm)

Stud Ø	M6	M8	M10	M12	M16
OD	13.50	16.00	19.20	21.00	26.00
H	6.50	7.00	8.00	8.00	11.50

OD = (Ferrule) Outside Diameter H = Height to Shoulder Tolerances OD+/-0.5 H+/-0.4



L \ Ø	M5	M6	M8
10		▲	
12	▲	▲	
16	▲	▲	▲
20	▲	▲	▲
25	▲	▲	▲
30			▲

Projection Weld Bolts to Rover Engineering standard 06.02.105 Issue 2 April 1990.

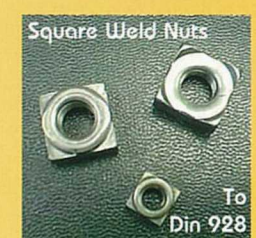
L = Length excluding flange.



Both Zintec & Plastic coated are available. With a 38mm outside diameter these are stocked to suit 3mm pins.



Mild Steel Square weld nuts are stocked in M5, M6 & M8, Hex weld nuts are specials and sufficient delivery time should be allowed.



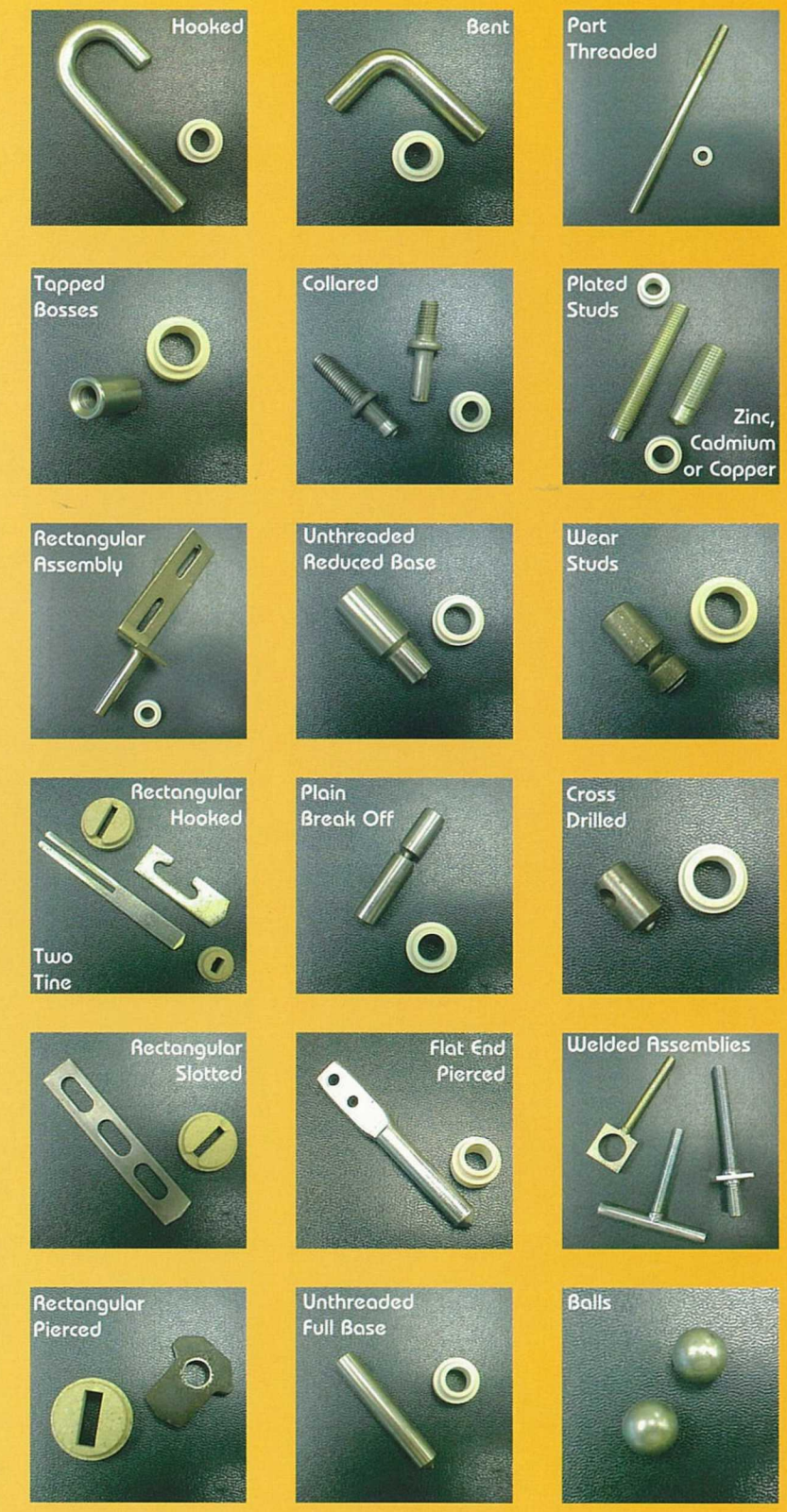
USEFUL NOTES

Sales Contact: _____

Technical Contact: _____

Progress Contact: _____

Tel: 01604 790901 **Fax: 01604 492946**



Conditions of Sale: Our standard terms and conditions of sale apply to all transactions, a copy of these is enclosed with this literature. Further copies of these conditions are available upon request.

Minimum Order Charge: £20.00 plus carriage and VAT at the current rate.

Carriage: All prices quoted are ex works, carriage will be charged extra.

Certificates of Conformity: are available for all goods. These are chargeable and, if required, must be requested at time of order.