

# Weld Torque's

*The calibrated torque spanner provides a convenient method of testing welded studs. Whilst very valuable for this purpose it should not be regarded as a precise test instrument as frictional effects can produce wide variations (as much as 33%) in the stress applied at any given torque load.*

*The table below indicates the safe tightening torque, which may be applied to a Studfast weld stud when welded to a compatible good weldable quality material.*

*It should be noted that should either the stud or the nut be lubricated the figures shown in the table should be reduced by 30%.*

*A table of compatible materials is provided overleaf for "CD", "DA" & "SCDA" and should be consulted prior to welding and testing.*

## Capacitor Discharge Weld Studs

Dia	Mild Steel	Stainless Steel	Aluminium Alloy
M3	<b>0.58 Nm</b>	<b>0.98 Nm</b>	<b>0.39 Nm</b>
M4	<b>1.35 Nm</b>	<b>2.30 Nm</b>	<b>0.92 Nm</b>
M5	<b>2.67 Nm</b>	<b>4.56 Nm</b>	<b>1.82 Nm</b>
M6	<b>4.58 Nm</b>	<b>7.81 Nm</b>	<b>3.12 Nm</b>
M8	<b>12.06 Nm</b>	<b>20.55 Nm</b>	<b>8.22 Nm</b>
M10	<b>23.11 Nm</b>	<b>39.39 Nm</b>	

## Drawn Arc Weld Studs

Dia	Mild Steel	Stainless Steel
M5	<b>2.36 Nm</b>	<b>3.65 Nm</b>
M6	<b>4.05 Nm</b>	<b>6.25 Nm</b>
M8	<b>10.65 Nm</b>	<b>16.44 Nm</b>
M10	<b>20.41 Nm</b>	<b>31.51 Nm</b>
M12	<b>36.41 Nm</b>	<b>56.38 Nm</b>
M16	<b>86.06 Nm</b>	<b>132.89 Nm</b>
M20	<b>177.04 Nm</b>	<b>273.37 Nm</b>

## Short Cycle Weld Studs

Dia	Mild Steel CD Stud	Stainless Steel CD Stud
M3	<b>0.58 Nm</b>	<b>0.98 Nm</b>
M4	<b>1.35 Nm</b>	<b>2.30 Nm</b>
M5	<b>2.67 Nm</b>	<b>4.56 Nm</b>
M6	<b>4.58 Nm</b>	<b>7.81 Nm</b>
M8	<b>12.06 Nm</b>	<b>20.55 Nm</b>
M10	<b>23.11 Nm</b>	<b>39.39 Nm</b>
	<b>Mild Steel DA Stud</b>	<b>Stainless Steel DA Stud</b>
M5	<b>2.36 Nm</b>	<b>3.65 Nm</b>
M6	<b>4.05 Nm</b>	<b>6.25 Nm</b>
M8	<b>10.65 Nm</b>	<b>16.44 Nm</b>