

 **SCHÖLER**

WELDING STUDS

DRAWN ARC STUD WELDING
SHORT CYCLE STUD WELDING



Welding studs

Drawn arc stud welding
Short cycle stud welding



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1. Welding studs for drawn arc stud welding

1.1 Technical information

Materials

Non-alloyed steels

Our threaded studs, internally threaded studs, non-threaded studs and similar welding elements are made from steel, strength class 4.8 (suitable for welding) (according to DIN EN ISO 898-1) with excellent weldability. Mechanical properties: yield strength (R_{el}) $\geq 340 \text{ N/mm}^2$, tensile strength (R_m) $\geq 420 \text{ N/mm}^2$, elongation (A_5) $\geq 14\%$.

Shear connectors are made from S235J2+C450. Mechanical properties: yield strength (R_{el}) $\geq 350 \text{ N/mm}^2$, tensile strength (R_m) $\geq 450 \text{ N/mm}^2$, elongation (A_5) $\geq 15\%$.

Stainless steels

Our threaded studs, internally threaded studs, non-threaded studs and similar welding elements are made from A2-50 (suitable for welding) according to DIN EN ISO 3506-1 (mechanical properties: yield point ($R_{p0,2}$) $\geq 210 \text{ N/mm}^2$, tensile strength (R_m) $\geq 500 \text{ N/mm}^2$, elongation (A_L) $\geq 0,6d$) and 1.4571 (suitable for welding) according to DIN EN ISO 3506-1 (mechanical properties: yield point ($R_{p0,2}$) $\geq 210 \text{ N/mm}^2$, tensile strength (R_m) $\geq 500 \text{ N/mm}^2$, elongation (A_L) $\geq 0,6d$) as well as from 1.4541 and 1.5415 (16Mo3).

The material specifications conform with DIN EN ISO 13918 and DIN EN ISO 14555. For welding studs from other materials please send us your inquiry or contact us.

On demand, the material properties can be verified by an inspection document (test report, inspection certificate) according to DIN EN 10204.

We are pleased to inform you about weldability to different base materials and welding parameters.

Dimensions

Welding studs dimensions are given in the measurement tables (all dimensions in mm). All standardised welding studs conform to DIN EN ISO 13918. Not standardised welding studs are supplied according to DIN EN ISO 13918. Special welding elements, which are not described, are delivered upon request.

Dimensions that are not listed in the measurement tables are delivered upon request.

The nominal length (l_2) always corresponds to the length after welding. Depending on the diameter the length before welding (l_1) is larger by a weld allowance of 1 to 5 mm.

Flux (aluminium ball) and weld pool backing

According to DIN EN ISO 13918 welding studs for drawn arc stud welding standardly have an aluminium ball at the welding tip. This serves as flux for improved ignition and stabilization of the electric arc as well as for deoxidising the weld pool.

For weld pool backing standardly ceramic ferrules are used. Accordingly, suitable ceramic ferrules are included in every stud shipment. A ceramic ferrule can only be used once; it is removed from the stud after welding by striking at it.

Up to a diameter of 10 mm shielding gas can be used as an alternative for weld pool backing. Upon request, we therefore deliver studs without aluminium ball at the welding tip and without ceramic ferrules.

Surface protection

Usually our welding studs are supplied in bright condition. On demand, the following surface treatments are possible (coating thicknesses according to DIN EN ISO 4042):

1. galvanically zinc-plated
2. hot zinc dipped
3. zinc flake coated flZnnc-600h
4. galvanically copper-base-coated and nickel-plated
5. galvanically copper-plated

The surface treatments 1, 2 and 3 have a negative impact on the welding quality and are therefore removed from the welding tip.



Threads

The threads of the studs are cold rolled (tolerance limit 6g). For surface-treated studs the tolerance limit 6h can be reached.

The thread of hot zinc dipped studs is not true to gauge. For hot zinc dipped studs nuts with allowance for interference have to be used.

We deliver studs with special threads upon request.

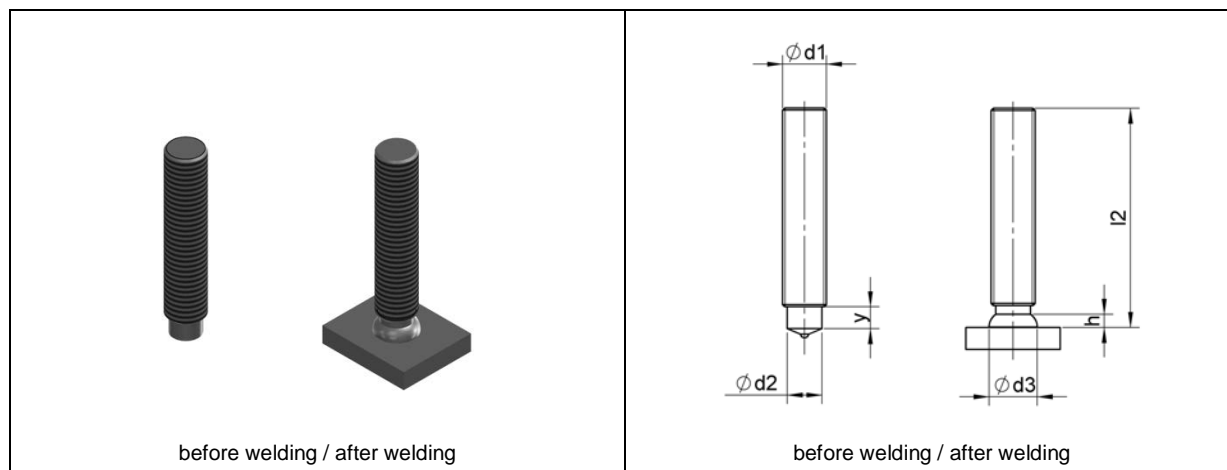
Weld fillet

During drawn arc stud welding a fillet forms between welding element and base material. The dimensions of the weld fillet are defined by the used ceramic ferrule and the welding parameters. The dimensions that are given in the measurement tables are approximate values. The diameter of the weld fillet is always bigger than the nominal diameter of the welding element.

Accessories for stud welding guns

Accessories for stud welding guns (chuck, ferrule grip, foot piece etc.) have to be adjusted to the welding element. The accessories which are to be used for the individual welding studs can be found in chapter 3.

1.2 Threaded stud with reduced shaft (type RD acc. to DIN EN ISO 13918)



The threaded stud type RD is threaded almost to the top of the welding tip which is reduced to about the core diameter of the thread. Thus the fillet diameter will only be slightly (0,5-1 mm) bigger than the external diameter of the thread. It is worthy of note that the reduction of the welding tip diminishes the bearing force of the stud by approximately 15% in comparison to the type MPF/PD/MD. Thus - if necessary - the next bigger diameter should be chosen.

Dimensions						Material (item number)			Ceramic ferrule
d ₁	l ₂	y _{min} ¹	d ₂	d ₃ [*]	h ²	Steel 4.8	A2-50	1.4571	
M6	15-100	4	4,7	7	2,5	41-06-XXX	42-06-XXX	43-06-XXX	RF 6
M8	15-100	4	6,2	9	2,5	41-08-XXX	42-08-XXX	43-08-XXX	RF 8 (KSR-F 8 ²)
M10	15-100	5	7,9	11,5	3	41-10-XXX	42-10-XXX	43-10-XXX	RF 10 (KSR-F 10 ²)
M12	20-100	6	9,5	13,5	4	41-12-XXX	42-12-XXX	43-12-XXX	RF 12
M16	25-100	7,5	13,2	16,8	5	41-16-XXX	42-16-XXX	43-16-XXX	RF 16
M16	25-100	11	13,2	16,1	5	41-16-XXX-LY	42-16-XXX-LY	43-16-XXX-LY	RF 16 (flat Form)
M20	30-100	15	16,5	23	6	41-20-XXX	42-20-XXX	43-20-XXX	RF 20 (flat Form)
M24	50-100	15	20	28	7	41-24-XXX	42-24-XXX	43-24-XXX	UF 20

¹Other y-dimensions available upon request.

²for l₂ < 20 mm

*d₃ and h are approximate values.

Upon request: without aluminium ball at the welding tip (as standard according to DIN EN ISO 13918 with aluminium ball (see explanation in chapter 1.1)).

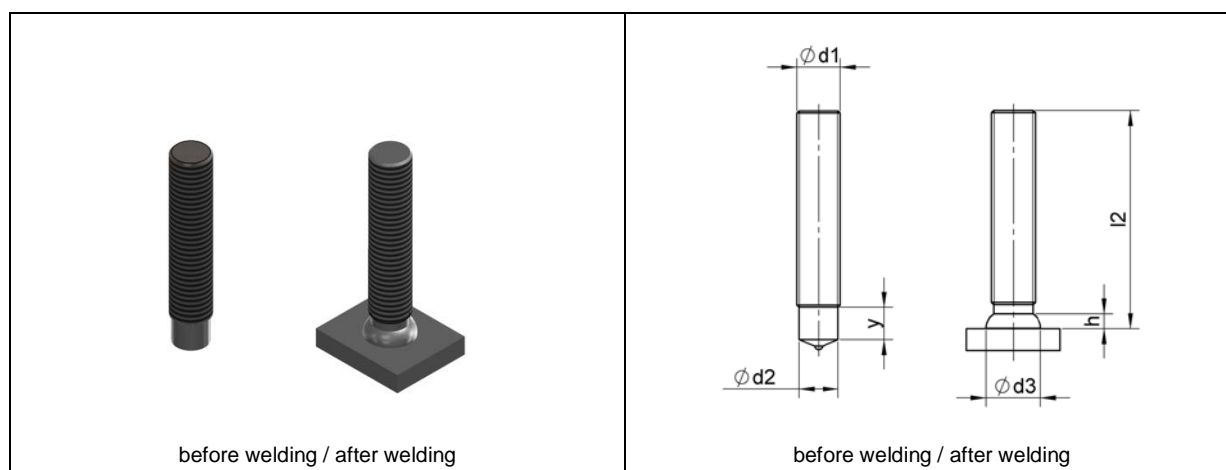
In the item number XXX has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.3 Threaded stud (type MPF)



The threaded stud type MPF is threaded to approximately the top of the welding tip. The diameter of the unthreaded stud section on the welding tip corresponds to the pitch diameter of the thread. Thus the diameter of the weld-fillet is approximately 3-4 mm larger than the external diameter of the thread.

Dimensions						Material (item number)			Ceramic ferrule
d ₁	l ₂	y -0/+0,5	d ₂	d ₃ *	h*	Steel 4.8	A2-50	1.4571	
M6	15-100	3	5,3	8,5	4	46-06-XXX-MPF	47-06-XXX-MPF	48-06-XXX-MPF	UF 6
M8	15-100	6	7,1	10	3	46-08-XXX-MPF	47-08-XXX-MPF	48-08-XXX-MPF	KSP-F 8
M10	15-100	7	8,95	12,5	3,4	46-10-XXX-MPF	47-10-XXX-MPF	48-10-XXX-MPF	KSP-F 10
M12	20-100	8	10,8	14,5	4,2	46-12-XXX-MPF	47-12-XXX-MPF	48-12-XXX-MPF	KSP-F 12
M16	30-100	11	14,6	17,8	5,8	46-16-XXX-MPF	47-16-XXX-MPF	48-16-XXX-MPF	KSP-F 16
M20	35-100	13	18,3	22,5	6,6	46-20-XXX-MPF	47-20-XXX-MPF	48-20-XXX-MPF	KSP-F 20

*d₃ and h are approximate values.

Upon request: without aluminium ball at the welding tip (as standard according to DIN EN ISO 13918 with aluminium ball (see explanation in chapter 1.1)).

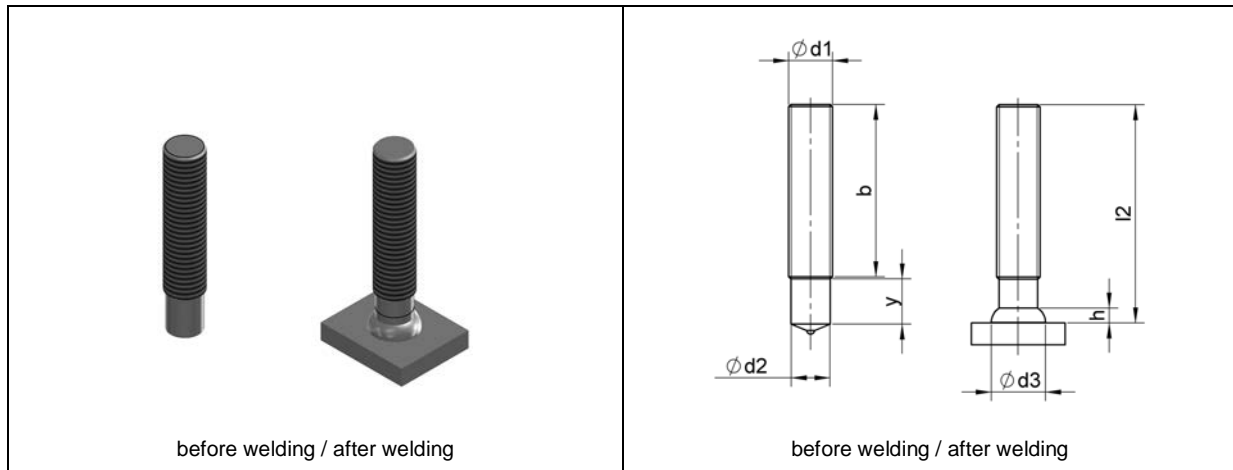
In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.4 Threaded stud with partial thread (type PD acc. to DIN EN ISO 13918)



The threaded stud type PD has a partial thread. The diameter of the unthreaded stud section on the welding tip corresponds to the pitch diameter of the thread. Thus the diameter of the weld-fillet is approximately 3-4 mm larger than the external diameter of the thread.

Dimensions							Material (item number)			Ceramic ferrule
d ₁	l ₂	y _{min}	b	d ₂	d ₃ *	h*	Steel 4.8	A2-50	1.4571	
M6	15 ≤ l ₂ < 35	9	-	5,3	8,5	3,5	46-06-XXX	47-06-XXX	48-06-XXX	PF 6
	35 ≤ l ₂ < 60	-	20							
	60 ≤ l ₂ < 160	-	40							
M8	20 ≤ l ₂ < 50	9	-	7,1	10	3,5	46-08-XXX	47-08-XXX	48-08-XXX	PF 8
	50 ≤ l ₂ < 160	-	40							
M10	20 ≤ l ₂ < 50	9,5	-	8,95	12,5	4	46-10-XXX	47-10-XXX	48-10-XXX	PF 10
	50 ≤ l ₂ < 140	-	40							
	140 ≤ l ₂ < 160	-	80							
M12	25 ≤ l ₂ < 50	11,5	-	10,8	15,5	4,5	46-12-XXX	47-12-XXX	48-12-XXX	PF 12
	50 ≤ l ₂ < 140	-	40							
	140 ≤ l ₂ < 160	-	80							
M16	30 ≤ l ₂ < 55	13,5	-	14,6	19,5	6	46-16-XXX	47-16-XXX	48-16-XXX	PF 16
	55 ≤ l ₂ < 100	-	40							
	100 ≤ l ₂ < 160	-	80							
M20	35 ≤ l ₂ < 50	15,5	-	18,3	24,5	7	46-20-XXX	47-20-XXX	48-20-XXX	KSP-F 20
	50 ≤ l ₂ < 55	-	35							
	55 ≤ l ₂ < 80	-	40							
	80 ≤ l ₂ < 100	-	50							
M24	50 ≤ l ₂ < 55	20	-	22	30	10	46-24-XXX	47-24-XXX	48-24-XXX	UF 22
	55 ≤ l ₂ < 60	-	30							
	60 ≤ l ₂ < 70	-	40							
	70 ≤ l ₂ < 100	-	50							
	100 ≤ l ₂ < 160	-	70							

*d₃ and h are approximate values.

Upon request: without aluminium ball at the welding tip (as standard according to DIN EN ISO 13918 with aluminium ball (see explanation in chapter 1.1)).

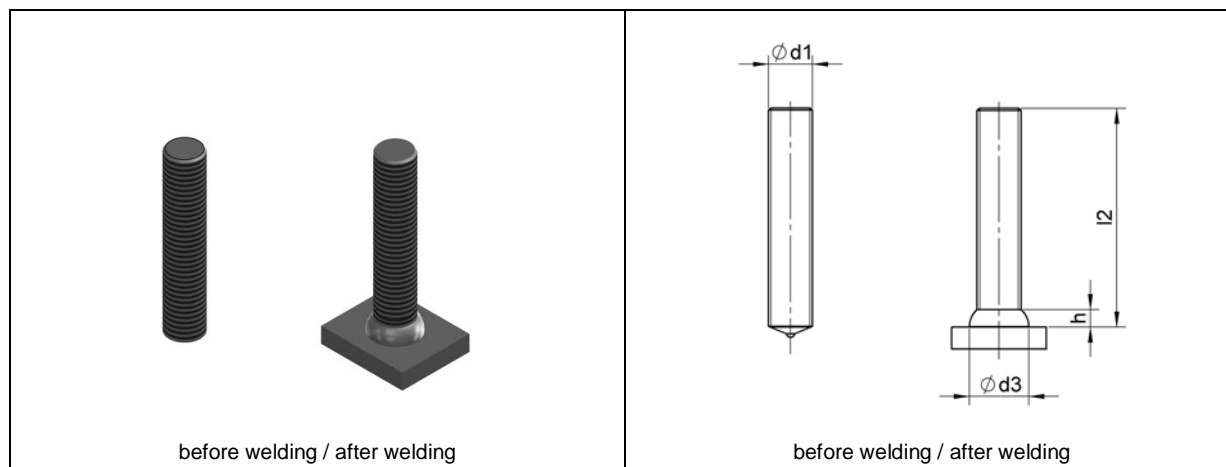
In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.5 Threaded stud with full thread (type MD)



The threaded stud type MD corresponds to the threaded studs MPF and PD, but is threaded almost to the top of the welding tip. Thus after welding the stud is threaded up to the weld-fillet. The diameter of the weld-fillet is approximately 3-4 mm larger than the external diameter of the thread.

Dimensions				Material (item number)			Ceramic ferrule
d_1	l_2	d_3^*	h^*	Steel 4.8	A2-50	1.4571	
M6	15-100	8,5	4	44-06-XXX	54-06-XXX	54-1-06-XXX	UF 6
M8	15-100	11	4	44-08-XXX	54-08-XXX	54-1-08-XXX	UF 8
M10	15-100	13	4	44-10-XXX	54-10-XXX	54-1-10-XXX	UF 10
M12	20-100	16	5	44-12-XXX	54-12-XXX	54-1-12-XXX	UF 12
M16	25-100	21	7	44-16-XXX	54-16-XXX	54-1-16-XXX	UF 16
M20	30-100	26	7	44-20-XXX	54-20-XXX	54-1-20-XXX	UF 20

* d_3 and h are approximate values.

Upon request: without aluminium ball at the welding tip (as standard according to DIN EN ISO 13918 with aluminium ball (see explanation in chapter 1.1)).

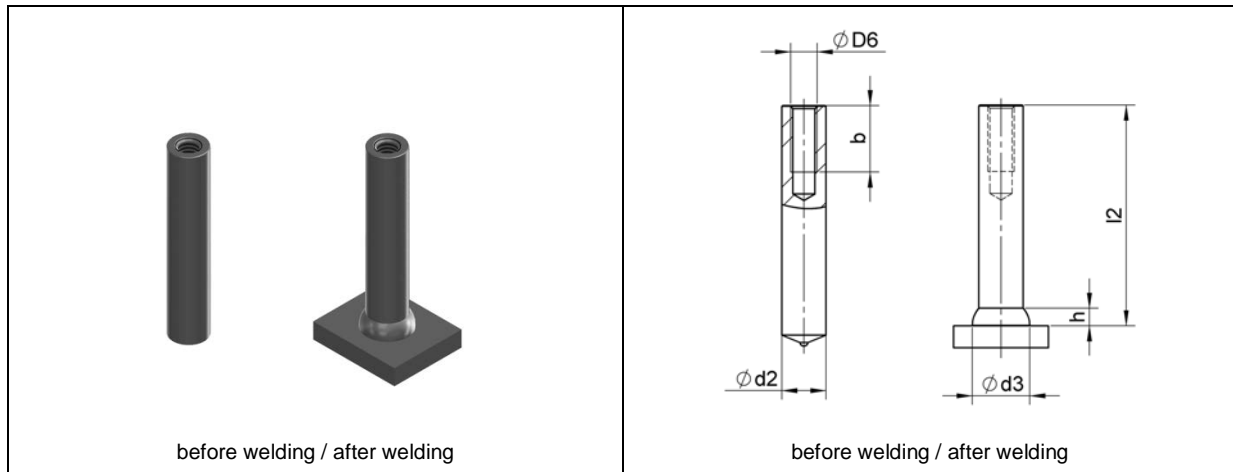
In the item number **XXX** has to be replaced by the respective welding element length l_2 (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.6 Internally threaded stud (type ID acc. to DIN EN ISO 13918)



Dimensions						Material (item number)			Ceramic ferrule
D ₆	b	d ₂	l ₂	d ₃ ¹	h ²	Steel 4.8	A2-50	1.4571	
M5	7	10	15-100	13	4	61-10-XXX-M5X7	62-10-XXX-M5X7	62-3-10-XXX-M5X7	UF 10 (KSN-F 10 ¹)
M6	9 (7 ¹)	10	15-100	13	4	61-10-XXX-M6X7 ¹ 61-10-XXX-M6X9	62-10-XXX-M6X7 ¹ 62-10-XXX-M6X9	62-3-10-XXX-M6X7 ¹ 62-3-10-XXX-M6X9	UF 10 (KSN-F 10 ¹)
M8	12 (8 ¹)	12	15-100	16	5	61-12-XXX-M8X8 ¹ 61-12-XXX-M8X12	62-12-XXX-M8X8 ¹ 62-12-XXX-M8X12	62-3-12-XXX-M8X8 ¹ 62-3-12-XXX-M8X12	UF 12 (KSN-F 12 ¹)
M8	12 (8 ¹)	14,6	15-100	18,5	6	61-14,6-XXX-M8X8 ¹ 61-14,6-XXX-M8X12	62-14,6-XXX-M8X8 ¹ 62-14,6-XXX-M8X12	62-3-14,6-XXX-M8X8 ¹ 62-3-14,6-XXX-M8X12	KSP-F 16
M10	15 (8 ²)	14,6	15-100	18,5	6	61-14,6-XXX-M10X8 ² 61-14,6-XXX-M10X15	62-14,6-XXX-M10X8 ² 62-14,6-XXX-M10X15	62-3-14,6-XXX-M10X8 ² 62-3-14,6-XXX-M10X15	KSP-F 16
M10	15 (8 ²)	16	20-100	21	7	61-16-XXX-M10X8 ² 61-16-XXX-M10X15	62-16-XXX-M10X8 ² 62-16-XXX-M10X15	62-3-16-XXX-M10X8 ² 62-3-16-XXX-M10X15	UF 16
M12	18	18,3	25-100	23	7	61-18,3-XXX-M12X18	62-18,3-XXX-M12X18	62-3-18,3-XXX-M12X18	KSP-F 20
M16	24	22	40-100	28	10	61-22-XXX-M16X24	62-22-XXX-M16X24	62-3-22-XXX-16X24	UF 22

¹for l₂ < 20 mm, ²for l₂ < 25 mm

*d₃ and h are approximate values.

Upon request: without aluminium ball at the welding tip (as standard according to DIN EN ISO 13918 with aluminium ball (see explanation in chapter 1.1)).

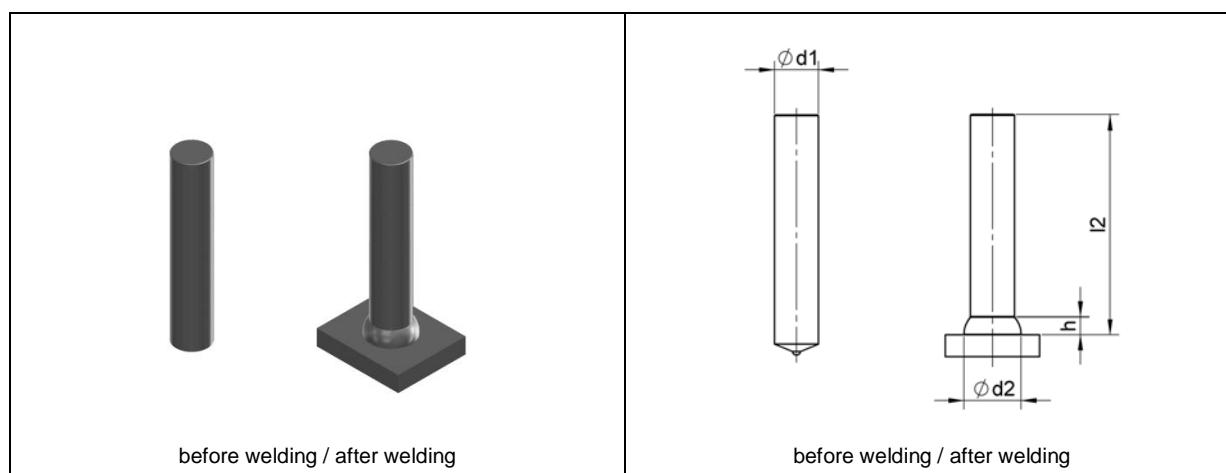
In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.7 Non-threaded stud (type UD acc. to DIN EN ISO 13918)



Dimensions				Material (item number)			Ceramic ferrule
d_1	l_2	d_3^*	h^*	Steel 4.8	A2-50	1.4571	
6	15-100	8,5	4	56-06-XXX	57-06-XXX	58-06-XXX	UF 6
8	15-100	11	4	56-08-XXX	57-08-XXX	58-08-XXX	UF 8
10	15-100	13	4	56-10-XXX	57-10-XXX	58-10-XXX	UF 10 (KSN-F 10 ¹)
12	15-100	16	5	56-12-XXX	57-12-XXX	58-12-XXX	UF 12 (KSN-F 12 ¹)
14,6	20-100	18,5	6	56-14,6-XXX	57-14,6-XXX	58-14,6-XXX	KSP-F 16
16	30-100	21	7	56-16-XXX	57-16-XXX	58-16-XXX	UF 16
20	40-100	26	9	56-20-XXX	57-20-XXX	58-20-XXX	UF 20
22	40-100	28	10	56-22-XXX	57-22-XXX	58-22-XXX	UF 22

¹for $l_2 < 20$ mm

* d_2 and h are approximate values.

Upon request: without aluminium ball at the welding tip (as standard according to DIN EN ISO 13918 with aluminium ball (see explanation in chapter 1.1)).

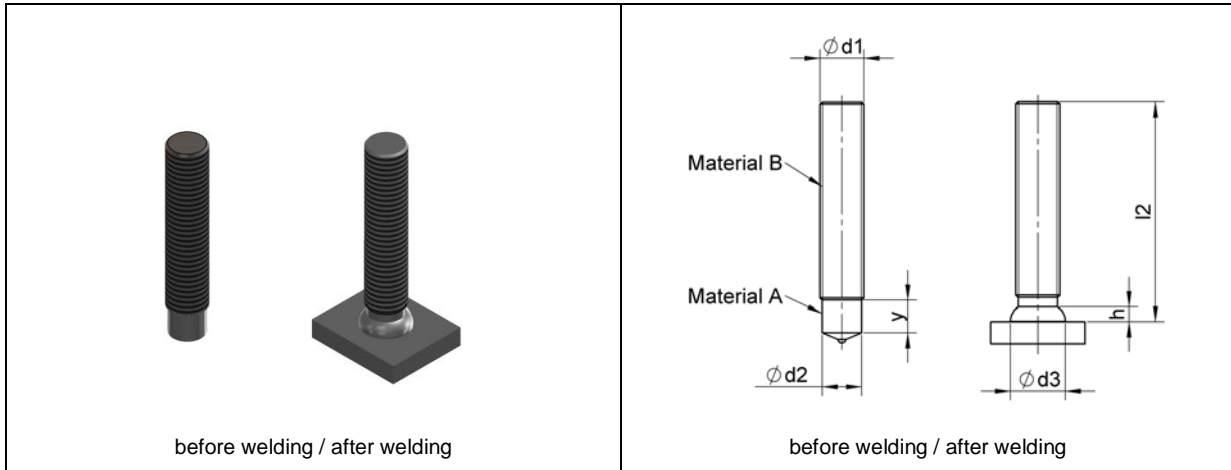
In the item number **XXX** has to be replaced by the respective welding element length l_2 (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.8 Bimetallic threaded stud (type MPF-DUO)



The threaded stud type MPF-DUO consists of two different materials. It is threaded to approximately the top of the welding tip. The diameter of the unthreaded stud section on the welding tip corresponds to the pitch diameter of the thread. Thus the diameter of the weld-fillet is approximately 3-4 mm larger than the external diameter of the thread.

Dimensions						Material (item number)		Ceramic ferrule
d_1	l_2	y	d_2	d_3^*	h^*	A: steel 4.8, B: 1.4571	A: steel 4.8, B: A2-50	
M8	15-100	6	7,1	10	3	78-14-08-XXX-PF	78-12-08-XXX-PF	KSP-F 8
M10	20-100	7	8,95	12,5	3,4	78-14-10-XXX-PF	78-12-10-XXX-PF	KSP-F 10
M12	20-100	8	10,5	14,5	4,2	78-14-12-XXX-PF	78-12-12-XXX-PF	KSP-F 12
M16	30-100	11	14,6	17,8	5,8	78-14-16-XXX-PF	78-12-16-XXX-PF	KSP-F 16

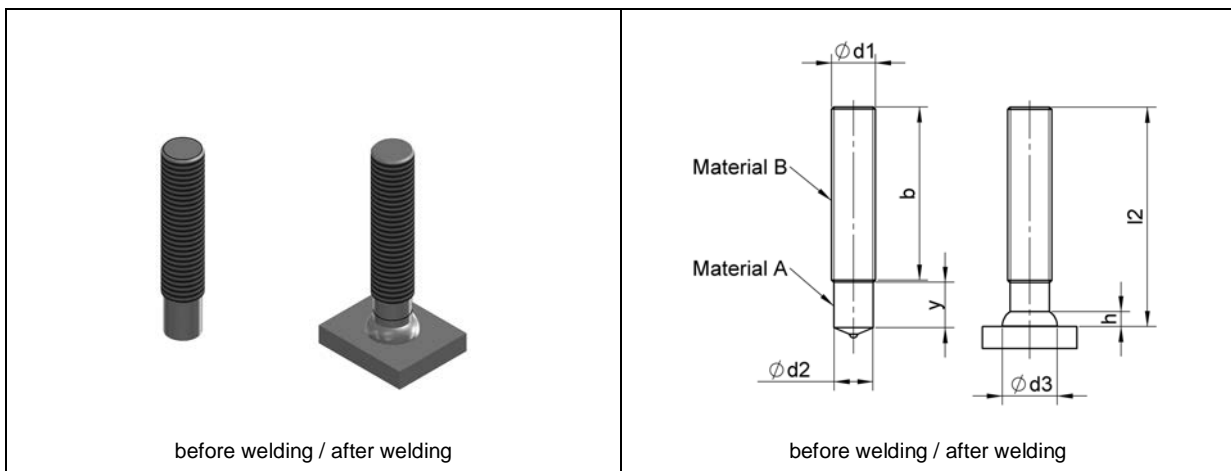
* d_3 and h are approximate values.

In the item number **XXX** has to be replaced by the respective welding element length l_2 (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

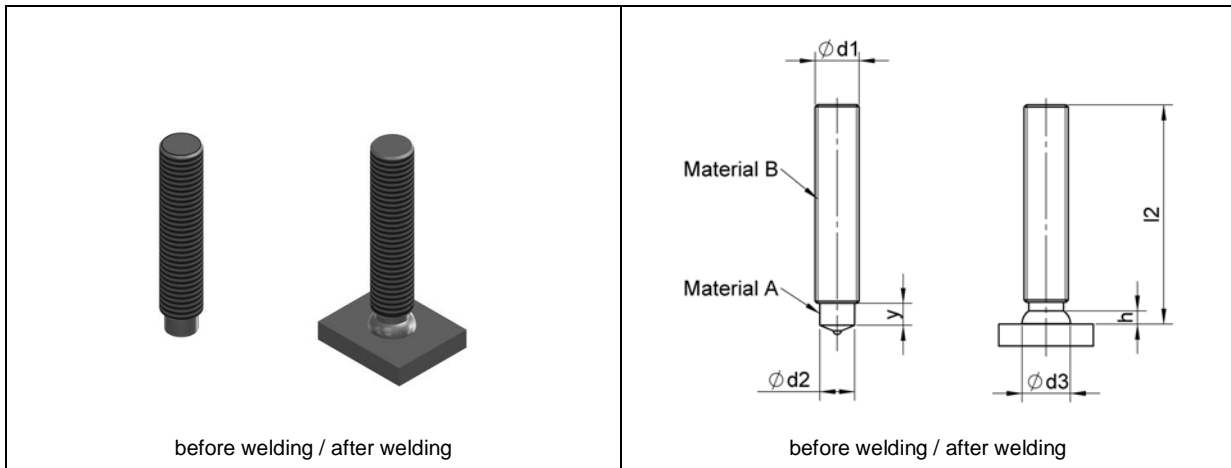
1.9 Bimetallic threaded stud with partial thread (type PD-DUO)



The threaded stud type PD-DUO consists of two different materials. It has a partial thread. The diameter of the unthreaded stud section on the welding tip corresponds to the pitch diameter of the thread. Thus the diameter of the weld-fillet is approximately 3-4 mm larger than the external diameter of the thread.

Available dimensions and materials available upon request.

1.10 Bimetallic threaded stud with reduced shaft (type RD-DUO)



The threaded stud type RD-DUO consists of two different materials. It is threaded almost to the top of the welding tip which is reduced to about the core diameter of the thread. Thus the fillet diameter will only be slightly (0,5-1 mm) bigger than the external diameter of the thread. It is worthy of note that the reduction of the welding tip diminishes the bearing force of the stud by approximately 15% in comparison to the type MPF/PD/MD. Thus - if necessary - the next bigger diameter should be chosen.

Dimensions						Material (item number)		Ceramic ferrule
d_1	l_2	y_{min}^1	d_2	d_3^*	h^*	A: steel 4.8, B: 1.4571	A: steel 4.8, B: A2-50	
M8	15-100	4	6,2	9	2,5	78-14-08-XXX-R	78-12-08-XXX-R	RF 8 (KSR-F 8 ²)
M10	20-100	5	7,9	11,5	3	78-14-10-XXX-R	78-12-10-XXX-R	RF 10
M12	20-100	6	9,5	13,5	4	78-14-12-XXX-R	78-12-12-XXX-R	RF 12
M16	25-100	7,5	13,2	16,8	5	78-14-16-XXX-R	78-12-16-XXX-R	RF 16
M16	25-100	11	13,2	16,1	5	78-14-16-XXX-R	78-12-16-XXX-R	RF 16 (flat Form)

¹Other y-dimensions available upon request.

²for $l_2 < 20$ mm

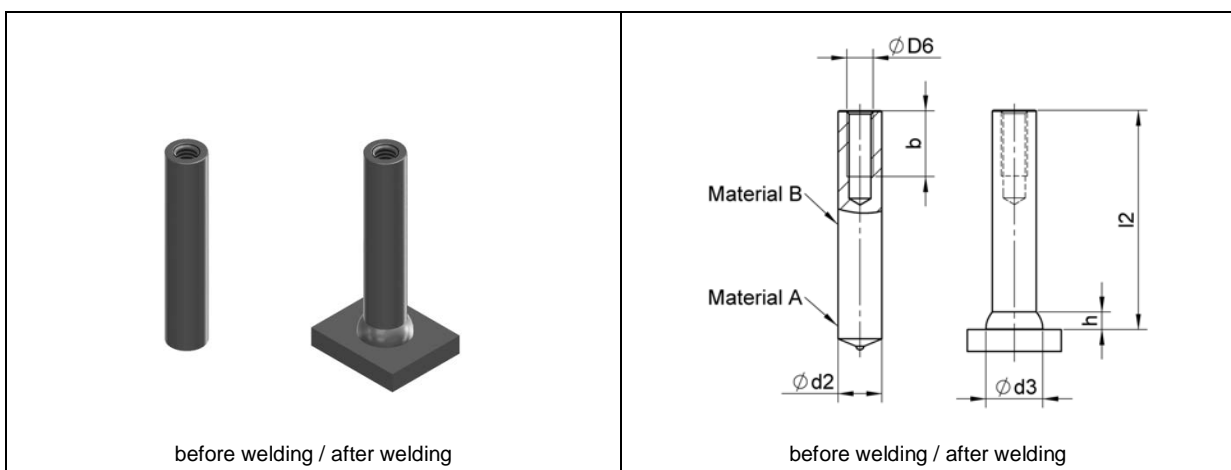
* d_3 and h are approximate values.

In the item number XXX has to be replaced by the respective welding element length l_2 (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

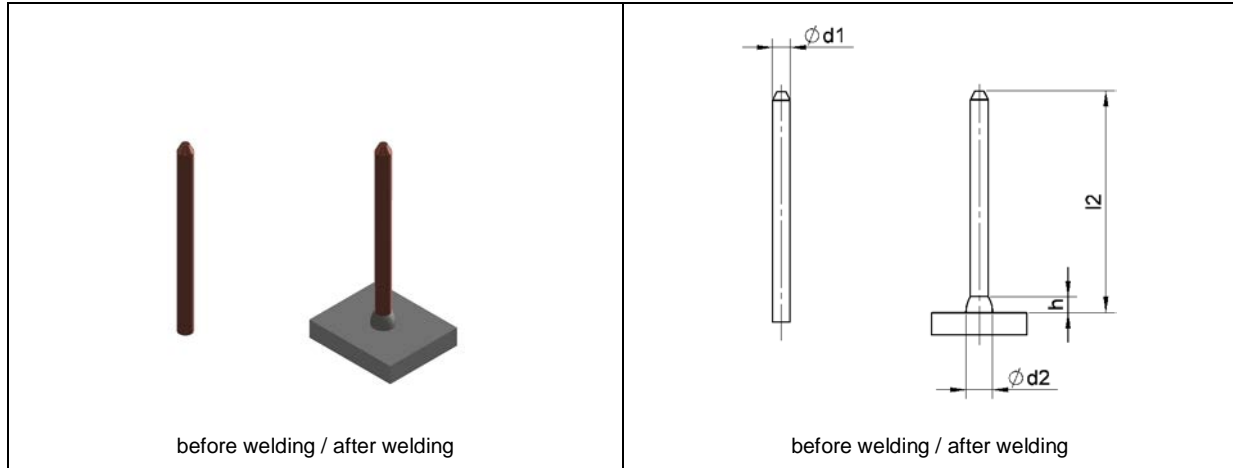
1.11 Bimetallic internally threaded stud (type ID-DUO)



Available dimensions and materials available upon request.

1.12 Insulation pins and clips

1.12.1 Insulation pin (type ISA)



Insulation pin - one-sided with grinded tip

Dimensions				Material (item number)					[Ceramic ferrule ¹]
d ₁	l ₂	d ₂	h	Steel 4.8 copper-plated	1.4301	1.4541	1.4571	1.5415 (16Mo3)	
3	35-450	6	3,5	66-03-XXX	67-03-XXX	70-03-XXX	74-03-XXX	68-03-XXX	[UF 4 ¹ / K 5 ¹]
4	60-450	6	3,5	66-04-XXX	67-04-XXX	70-04-XXX	74-04-XXX	68-04-XXX	[UF 4 ¹ / K 5 ¹]
5	60-450	8	3,5	66-05-XXX	67-05-XXX	70-05-XXX	74-05-XXX	68-05-XXX	[UF 5 ¹ / K 5 ¹]
6	60-450	8,5	4	66-06-XXX	67-06-XXX	70-06-XXX	74-06-XXX	68-06-XXX	[UF 6 ¹ / K 6 ¹]

*d₂ and h are approximate values.

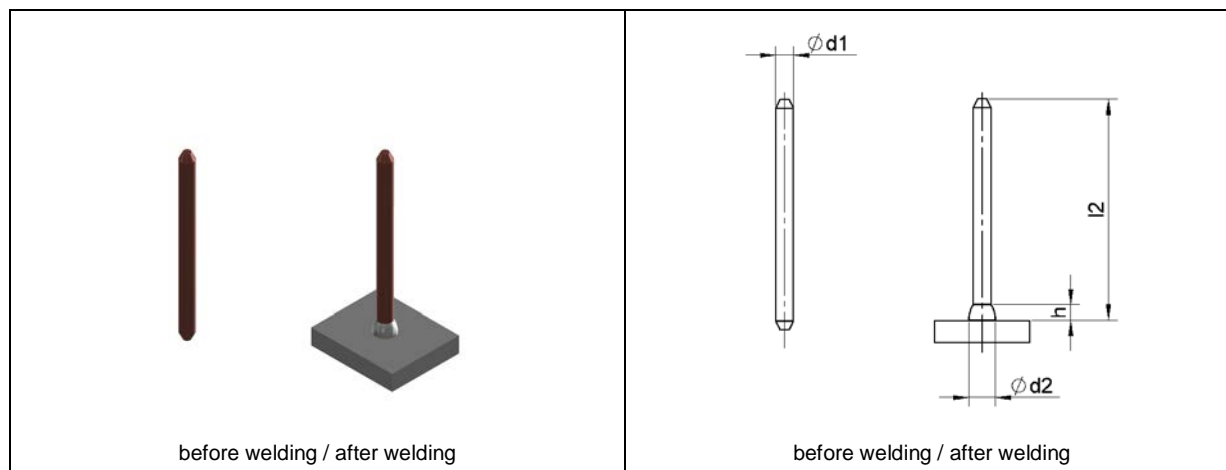
¹Insulation pins are generally welded without ceramic ferrules. Ceramic ferrules are only used for special applications. If ceramic ferrules shall be used, either type UF or type K can be chosen.

In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.12.2 Insulation pin (type ISB)



Insulation pin - two-sided with grinded tip

Dimensions				Material (item number)					[Ceramic ferrule ¹]
d ₁	l ₂	d ₂	h	Steel 4.8 copper-plated	1.4301	1.4541	1.4571	1.5415 (16Mo3)	
3	50-450	6	3,5	66-03-XXX-BS	67-03-XXX-BS	70-03-XXX-BS	74-03-XXX-BS	68-03-XXX-BS	[UF 4 ¹ / K 5 ¹]
4	50-450	6	3,5	66-04-XXX-BS	67-04-XXX-BS	70-04-XXX-BS	74-04-XXX-BS	68-04-XXX-BS	[UF 4 ¹ / K 5 ¹]
5	50-450	8	3,5	66-05-XXX-BS	67-05-XXX-BS	70-05-XXX-BS	74-05-XXX-BS	68-05-XXX-BS	[UF 5 ¹ / K 5 ¹]
6	50-450	8,5	4	66-06-XXX-BS	67-06-XXX-BS	70-06-XXX-BS	74-06-XXX-BS	68-06-XXX-BS	[UF 6 ¹ / K 6 ¹]

*d₂ and h are approximate values.

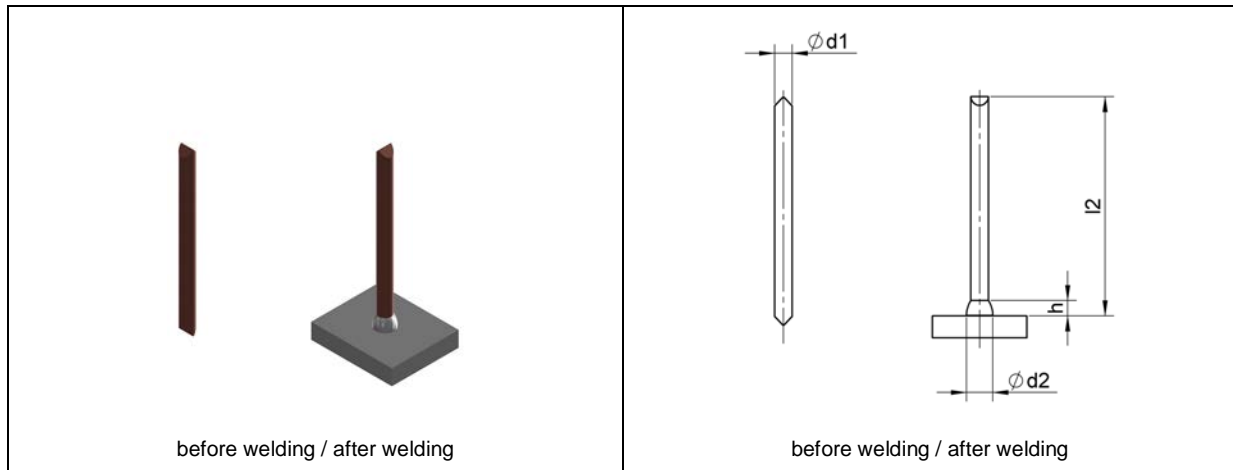
¹Insulation pins are generally welded without ceramic ferrules. Ceramic ferrules are only used for special applications. If ceramic ferrules shall be used, either type UF or type K can be chosen.

In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.12.3 Insulation pin (type ISMS)



Insulation pin - two-sided with chisel tip

Dimensions				Material (item number)					[Ceramic ferrule ¹]
d ₁	l ₂	d ₂ [*]	h [*]	Steel 4.8 copper-plated	1.4301	1.4541	1.4571	1.5415 (16Mo3)	
3	20-450	6	3,5	66-03-XXX-MS	67-03-XXX-MS	70-03-XXX-MS	74-03-XXX-MS	68-03-XXX-MS	[UF 4 ¹ / K 5 ¹]
4	60-450	6	3,5	66-04-XXX-MS	-	-	-	-	[UF 4 ¹ / K 5 ¹]
5	60-120	8	3,5	66-05-XXX-MS	-	-	-	-	[UF 5 ¹ / K 5 ¹]

*d₂ and h are approximate values.

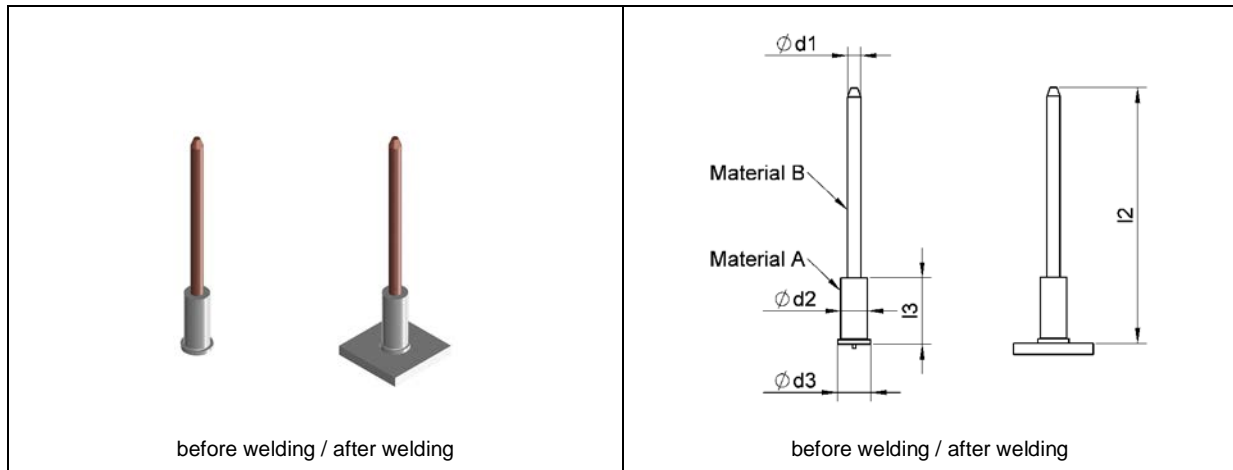
¹Insulation pins are generally welded without ceramic ferrules. Ceramic ferrules are only used for special applications. If ceramic ferrules shall be used, either type UF or type K can be chosen.

In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.12.4 Bimetallic insulation pin (type VBS)



The bimetallic insulation pin VBS consists of an aluminium tapped blind hole stud with a pressed-in insulation pin one-sided with grinded tip.

Application area: insulation on aluminium base material

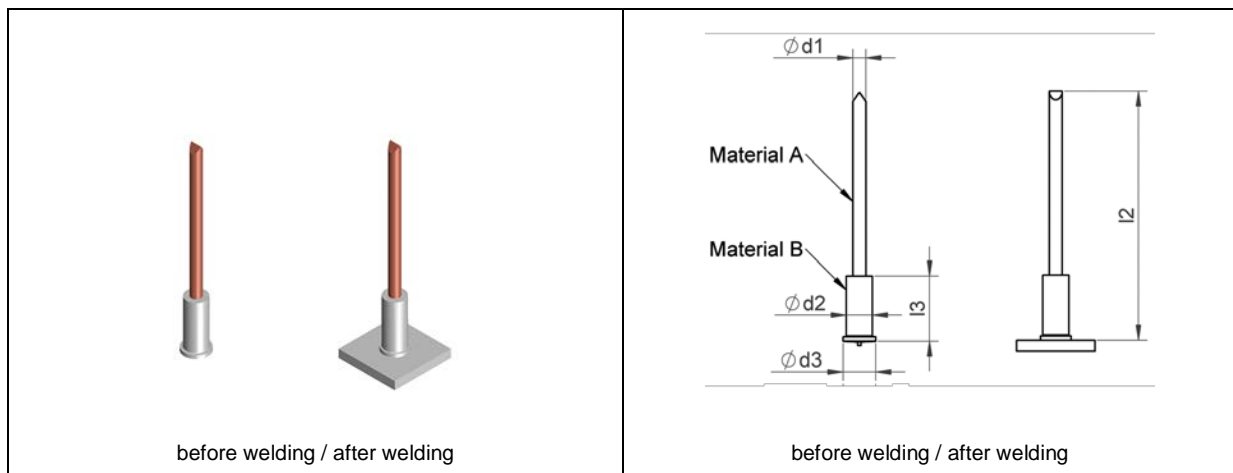
Dimensions					Material (item number)		
d_1	l_2	d_2	l_3	d_3	A: AlMg3, B: Steel 4.8 copper-plated	A: AlMg3, B: 1.4301	A: AlMg3, B: 1.4571
3	30-200	6	15	7,5	241-03-XXX	242-03-XXX	247-03-XXX

In the item number **XXX** has to be replaced by the respective welding element length l_2 (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.12.5 Bimetallic insulation pin (type VBS-MS)



The bimetallic insulation pin VBS-MS consists of an aluminium tapped blind hole stud with a pressed-in insulation pin one-sided with chisel tip.

Application area: insulation on aluminium base material

Dimensions					Material (item number)		
d_1	l_2	d_2	l_3	d_3	A: AlMg3, B: Steel 4.8 copper-plated	A: AlMg3, B: 1.4301	A: AlMg3, B: 1.4571
3	30-200	6	15	7,5	241-03-XXX-MS	242-03-XXX-MS	247-03-XXX-MS

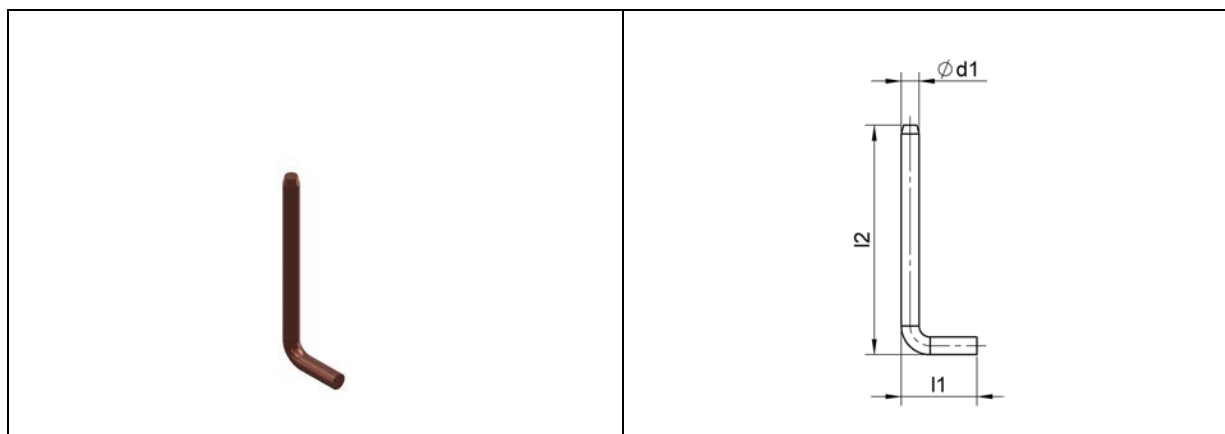
In the item number **XXX** has to be replaced by the respective welding element length l_2 (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Not listed dimensions and materials available upon request.



1.12.6 Insulation pin (type ISH)



Insulation pin - angled (for manual welding)

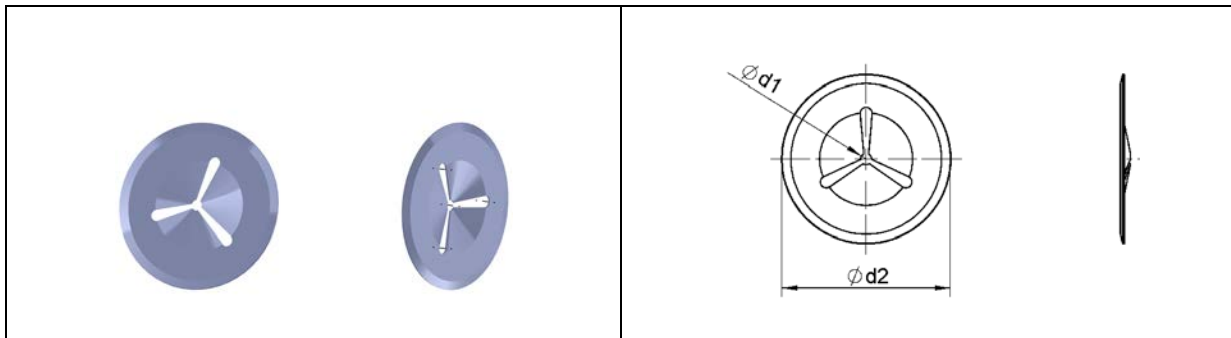
Dimensions			Material (item number)				
d ₁	l ₂	l ₁	Steel 4.8 copper-plated	1.4301	1.4541	1.4571	1.5415 (16Mo3)
3	upon request	upon request	66-03-XXX-ISH-XX	67-03-XXX-ISH-XX	70-03-XXX-ISH-XX	74-03-XXX-ISH-XX	68-03-XXX-ISH-XX
4	upon request	upon request	66-04-XXX-ISH-XX	67-04-XXX-ISH-XX	70-04-XXX-ISH-XX	74-04-XXX-ISH-XX	68-04-XXX-ISH-XX
5	upon request	upon request	66-05-XXX-ISH-XX	67-05-XXX-ISH-XX	70-05-XXX-ISH-XX	74-05-XXX-ISH-XX	68-05-XXX-ISH-XX

In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm) and **XX** by the respective angled length l₁.

Explanations to the used materials can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

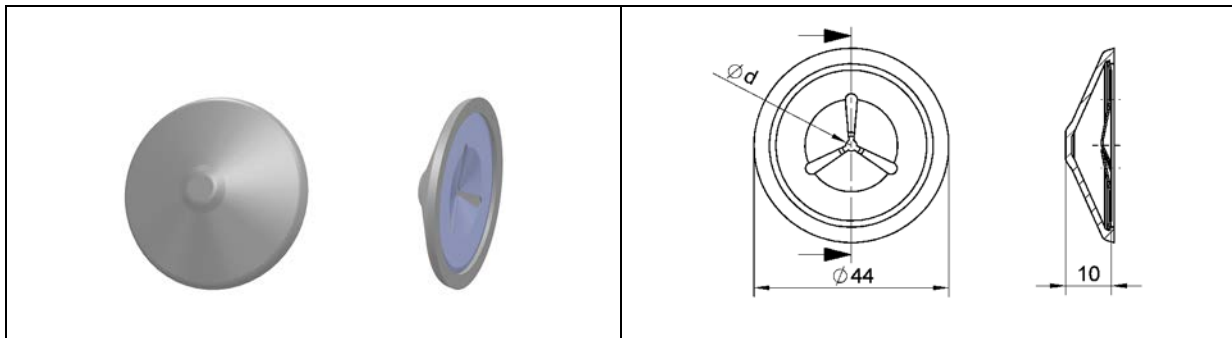
1.12.7 Clip for insulation pin (type R)



Dimensions		Material (item number)	
d_1	d_2	Steel zinc-plated	1.4310
2	38	49-12-002	49-22-002
3	38	49-13-003	49-23-003
4	38	49-14-004	49-24-004
5	38	49-15-005	49-25-005
6	38	49-16-006	49-26-006
8	38	49-18-008	49-28-008
9,5	38	49-19-009,5	49-29-009,5
12	38	49-12-012	49-22-012
3	60	49-13-003-ST2K70-D60	49-23-003-4301-D60
4	60	49-14-004-ST2K70-D60	49-24-004-4301-D60
5	60	49-15-005-ST2K70-D60	49-25-005-4301-D60
6	60	49-16-006-ST2K70-D60	49-26-006-4301-D60

Not listed dimensions and materials available upon request.

1.12.8 Clip with plastic cap for insulation pin (type W)

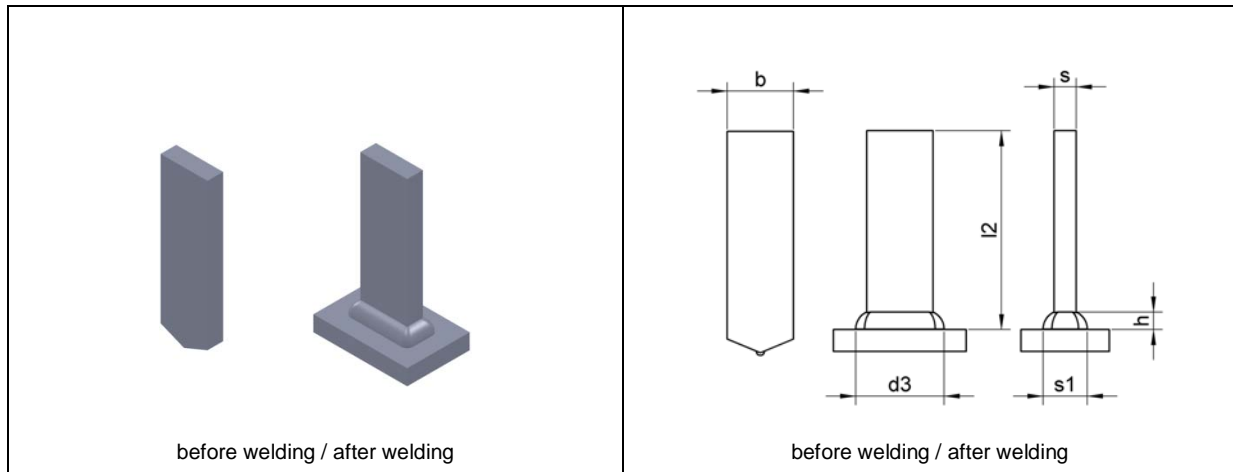


Dimensions	Material (item number)			
d	Steel zinc-plated with plastic cap (white)	Steel zinc-plated with plastic cap (black)	1.4310 with plastic cap (white)	1.4310 with plastic cap (black)
2	49-52-002	49-52-002-SCHWARZ	49-62-002	49-62-002-SCHWARZ
3	49-53-003	49-53-003-SCHWARZ	49-63-003	49-63-003-SCHWARZ
4	49-54-004	49-54-004-SCHWARZ	49-64-004	49-64-004-SCHWARZ
5	49-55-005	49-55-005-SCHWARZ	49-65-005	49-65-005-SCHWARZ

Plastic cap: halogen free, self-extinguishing

Not listed dimensions and materials available upon request.

1.13 Rectangular stud (type A)



Dimensions						Material (item number)		Ceramic ferrule
b	s	l ₂	d ₃ *	h*	s ₁ *	Steel 4.8	A2-50	
15	3	20-100	18	4	6	77-15-3-XXX	77-2-15-3-XXX	KF 15x3
15	5	20-100	20	4	10	77-15-5-XXX	77-2-15-5-XXX	KF 15x5
25	3	25-100	28	4	6	77-25-3-XXX	77-2-25-3-XXX	KF 25x3
25	5	25-100	28	4	10	77-25-5-XXX	77-2-25-5-XXX	KF 25x5

*d₃, h and s₁ are approximate values.

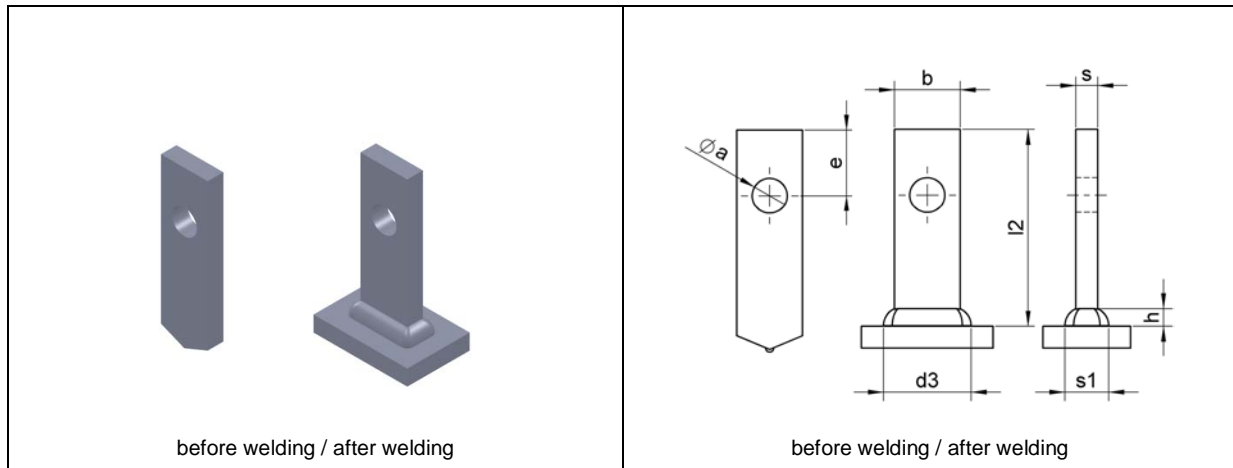
In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.14 Rectangular stud (type B)



Dimensions								Material (item number)		Ceramic ferrule
b	s	l ₂	a	e	d ₃ [*]	h [*]	s ₁ [*]	Steel 4.8	A2-50	
15	3	20-100	6	15 (10 ¹)	18	4	6	77-15-3-XXX-a-e	77-2-15-3-XXX-a-e	KF 15x3
15	5	20-100	8	15 (10 ¹)	20	4	10	77-15-5-XXX-a-e	77-2-15-5-XXX-a-e	KF 15x5
25	3	25-100	8	15	28	4	6	77-25-3-XXX-a-e	77-2-25-3-XXX-a-e	KF 25x3
25	5	25-100	8	15	28	4	10	77-25-5-XXX-a-e	77-2-25-5-XXX-a-e	KF 25x5

¹for l₂ < 25 mm

*d₃, h and s₁ are approximate values.

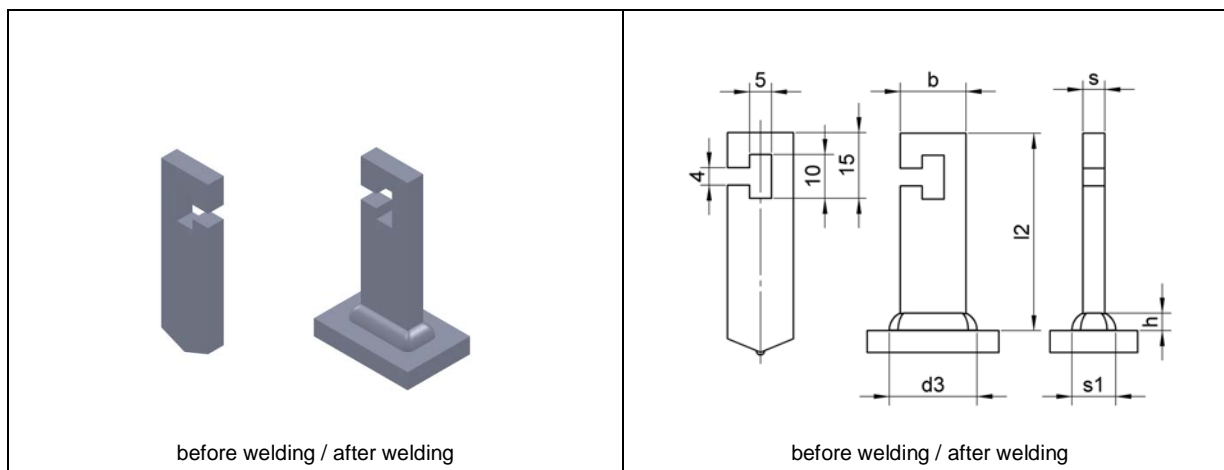
In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.15 Rectangular stud (type C)



Dimensions						Material (item number)		Ceramic ferrule
b	s	l ₂	d ₃ *	h*	s ₁ *	Steel 4.8	A2-50	
15	3	20-100	18	4	6	77-15-3-XXX-C	77-2-15-3-XXX-C	KF 15x3
15	5	20-100	20	4	10	77-15-5-XXX-C	77-2-15-5-XXX-C	KF 15x5
25	3	25-100	28	4	6	77-25-3-XXX-C	77-2-25-3-XXX-C	KF 25x3
25	5	25-100	28	4	10	77-25-5-XXX-C	77-2-25-5-XXX-C	KF 25x5

*d₃, h and s₁ are approximate values.

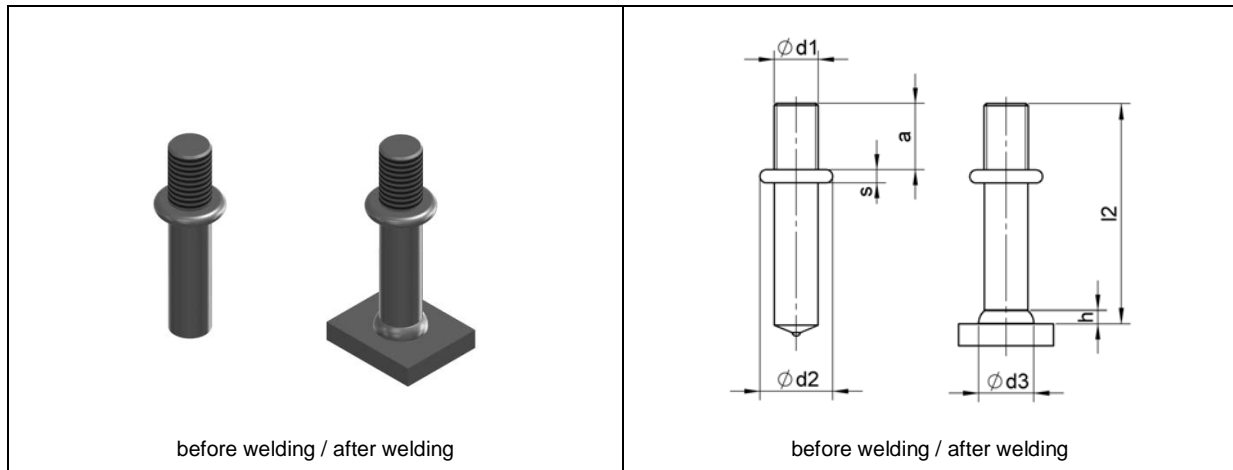
In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.16 Threaded collar stud (type KRB)



Dimensions							Material (item number)		Ceramic ferrule
d ₁	l ₂	a	d ₂	s	d ₃ *	h*	Steel 4.8	A2-50	
M8	40-100	15	upon request	upon request	10	3,5	50-KRB-2-08-XXX	50-KRB-1-08-XXX	PF 8
M10	40-100	15	upon request	upon request	12,5	4	50-KRB-2-10-XXX	50-KRB-1-10-XXX	PF 10
M12	40-100	15	upon request	upon request	15,5	4,5	50-KRB-2-12-XXX	50-KRB-1-12-XXX	PF 12

*d₃ and h are approximate values.

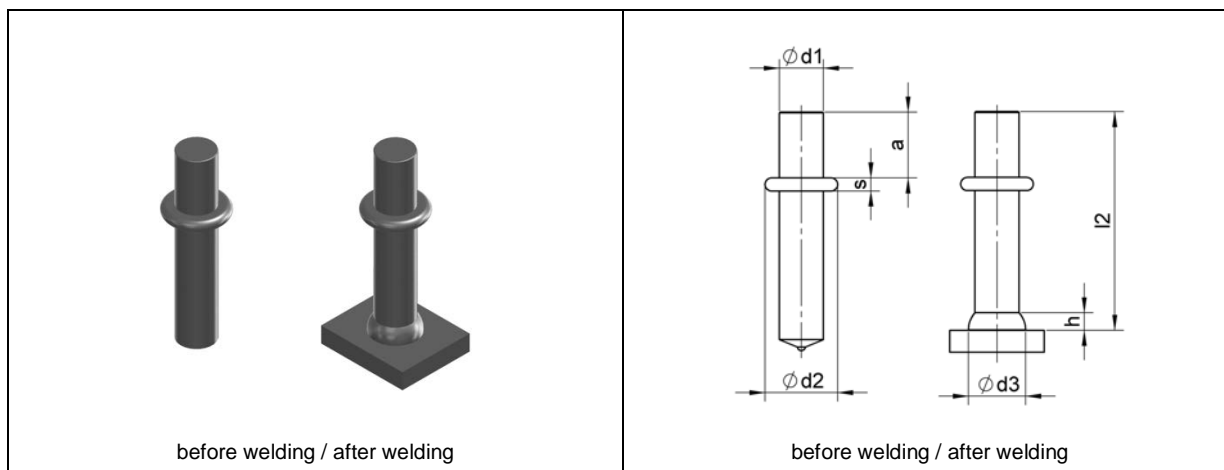
In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.17 Collar stud (type KRS)



Dimensions							Material (item number)		Ceramic ferrule
d ₁	l ₂	a	d ₂	s	d ₃	h	Steel 4.8	A2-50	
8	30-60	15	upon request	upon request	11	4	50-KRS-2-08-XXX	50-KRS-1-08-XXX	UF 8
10	30-60	15	upon request	upon request	13	4	50-KRS-2-10-XXX	50-KRS-1-10-XXX	UF 10
12	30-60	15	upon request	upon request	16	5	50-KRS-2-12-XXX	50-KRS-1-12-XXX	UF 12

*d₃ and h are approximate values.

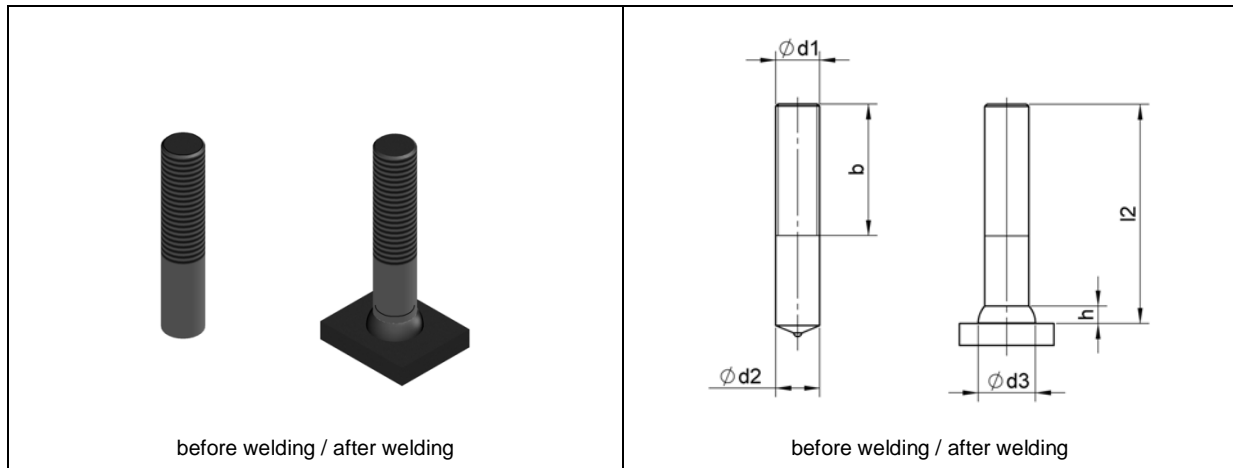
In the item number **XXX** has to be replaced by the respective welding element length l₂ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

Not listed dimensions and materials available upon request.

1.18 Threaded stud (type M)



Dimensions						Material (item number)			Ceramic ferrule
d_1	l_2	d_2	b	d_3	h	Steel 4.8	A2-50	1.4571	
M8	upon request	8	upon request	11	4	46-08-XXX-XX-M	47-08-XXX-XX-M	48-08-XXX-XX-M	UF 8
M10	upon request	10	upon request	13	4	46-10-XXX-XX-M	47-10-XXX-XX-M	48-10-XXX-XX-M	UF 10
M12	upon request	12	upon request	16	5	46-12-XXX-XX-M	47-12-XXX-XX-M	48-12-XXX-XX-M	UF 12
M16	upon request	16	upon request	21	7	46-16-XXX-XX-M	47-16-XXX-XX-M	48-16-XXX-XX-M	UF 16
M20	upon request	20	upon request	26	9	46-20-XXX-XX-M	47-20-XXX-XX-M	48-20-XXX-XX-M	UF 20

* d_3 and h are approximate values.

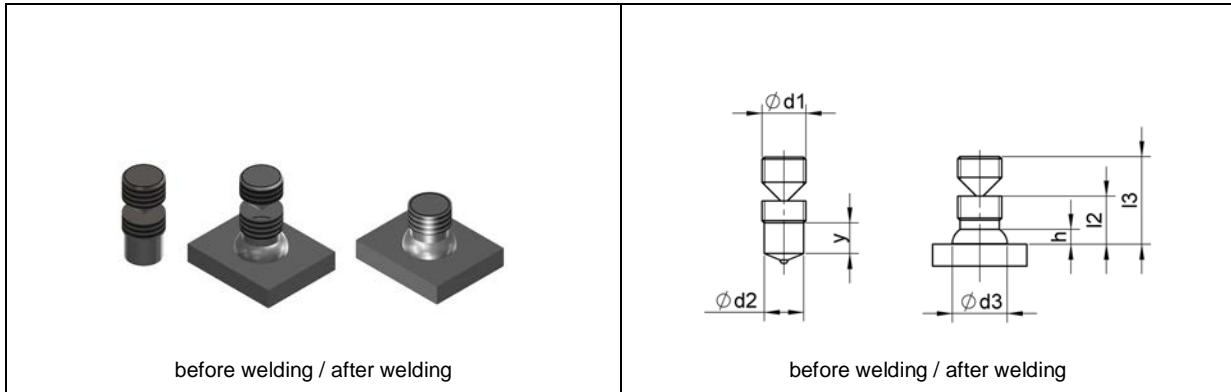
In the item number **XXX** has to be replaced by the respective welding element length l_2 (e.g. 030 for 30 mm) and **XX** by the respective thread length b .

Explanations to the used materials can be found in chapter 1.1.

Available surface treatments can be found in chapter 1.1.

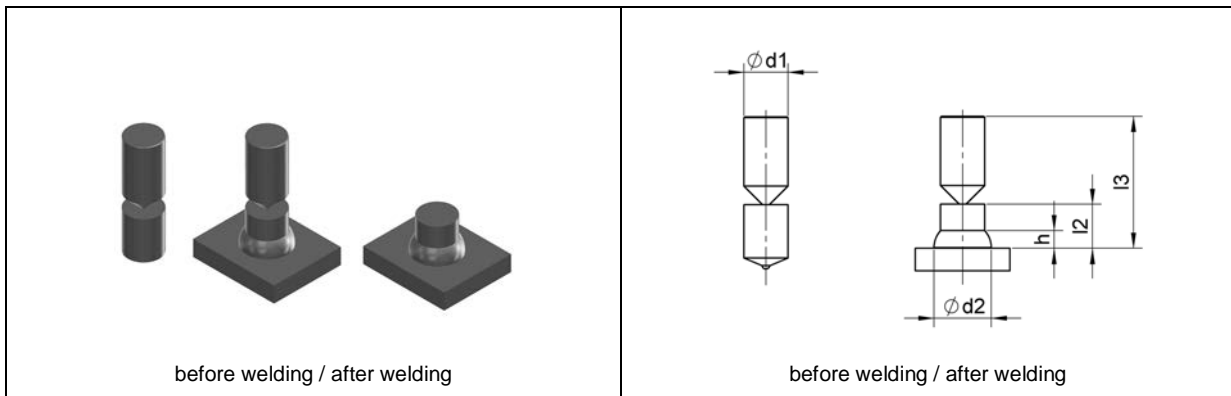
Not listed dimensions and materials available upon request.

1.19 Threaded knock-off stud (type AB-MPF)



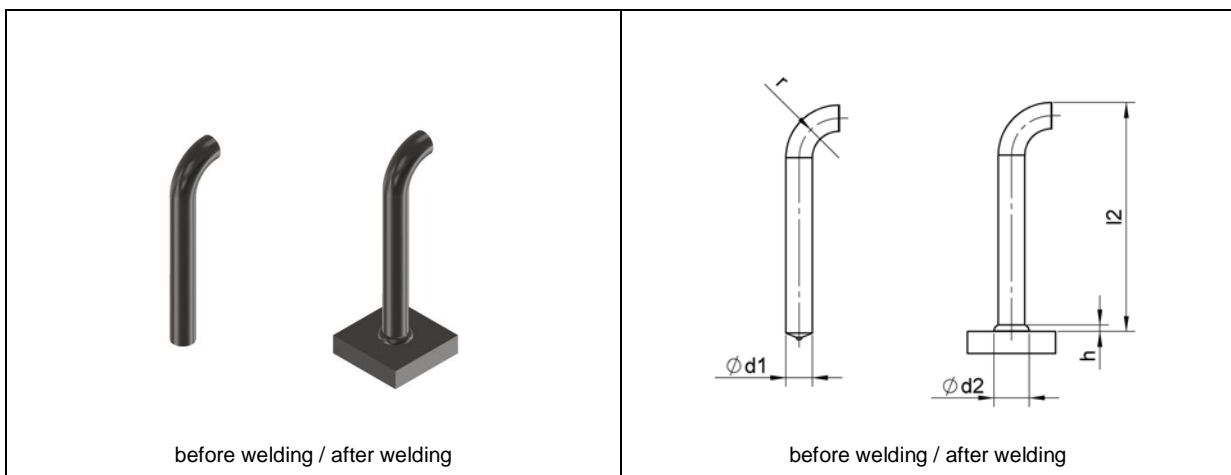
Available dimensions and materials as well as other stud types (e.g. RD, MD) available upon request.

1.20 Knock-off stud



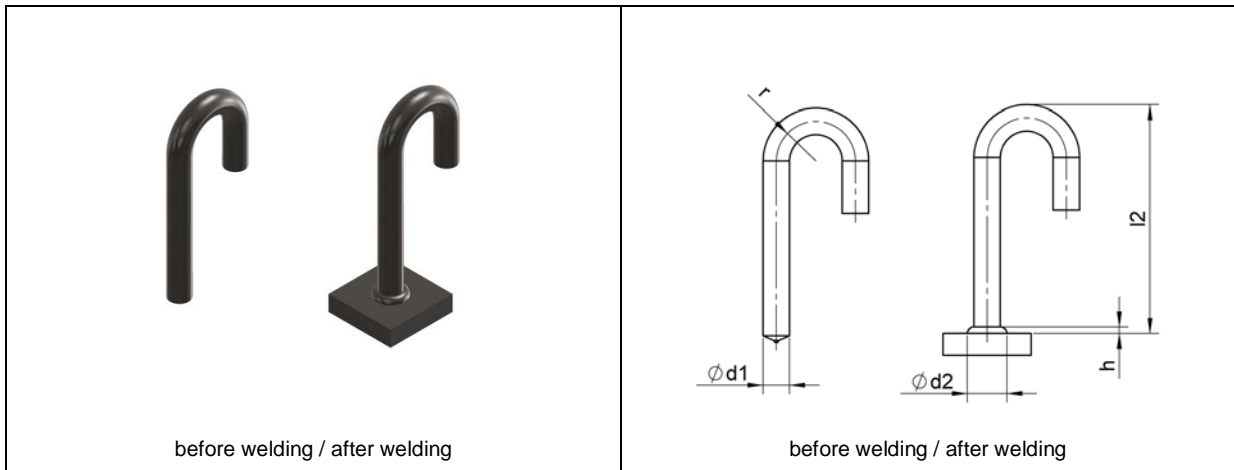
Available dimensions and materials available upon request.

1.21 Curved stud



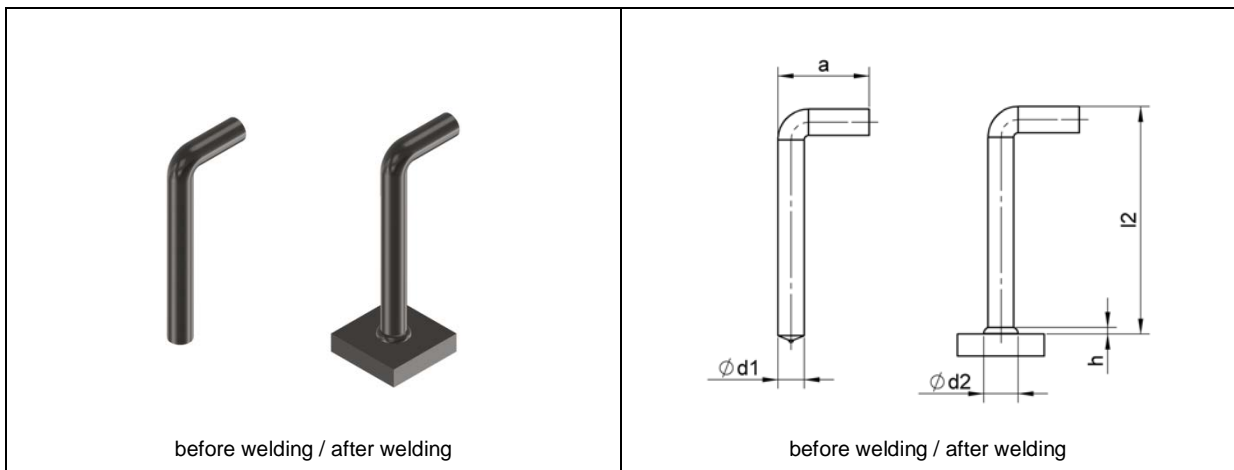
Available dimensions and materials available upon request.

1.22 J-bolt stud



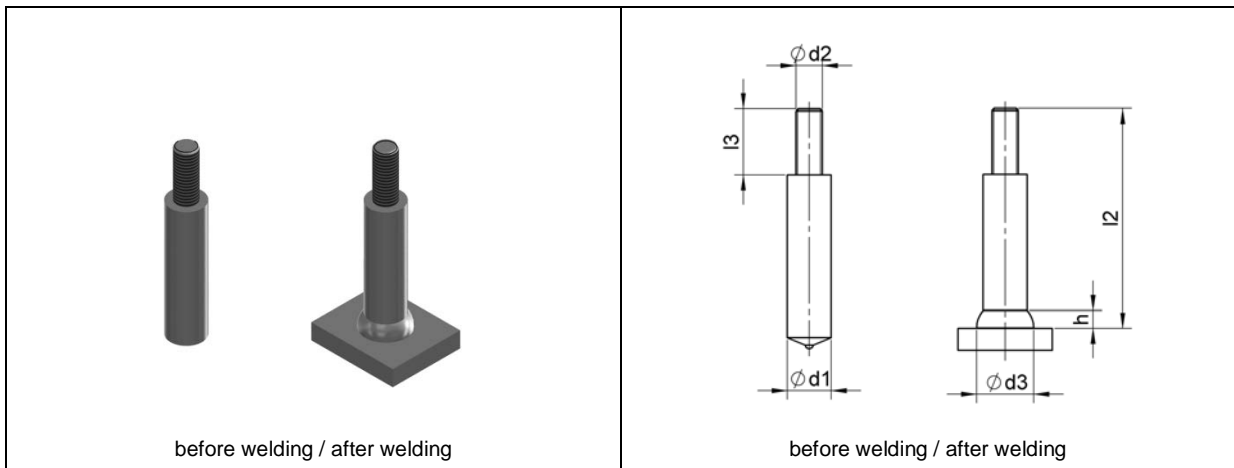
Available dimensions and materials available upon request.

1.23 Bent stud



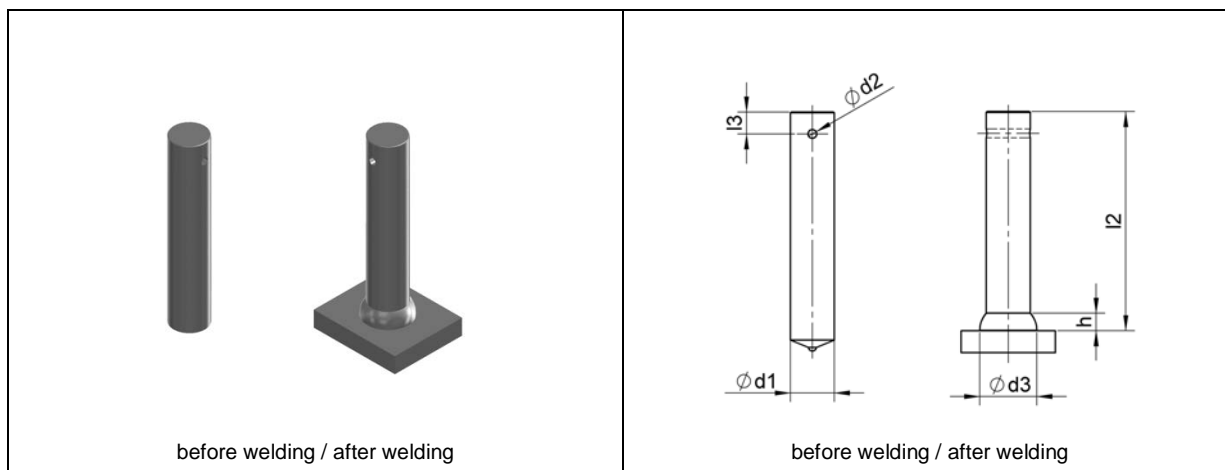
Available dimensions and materials available upon request.

1.24 Stepped stud



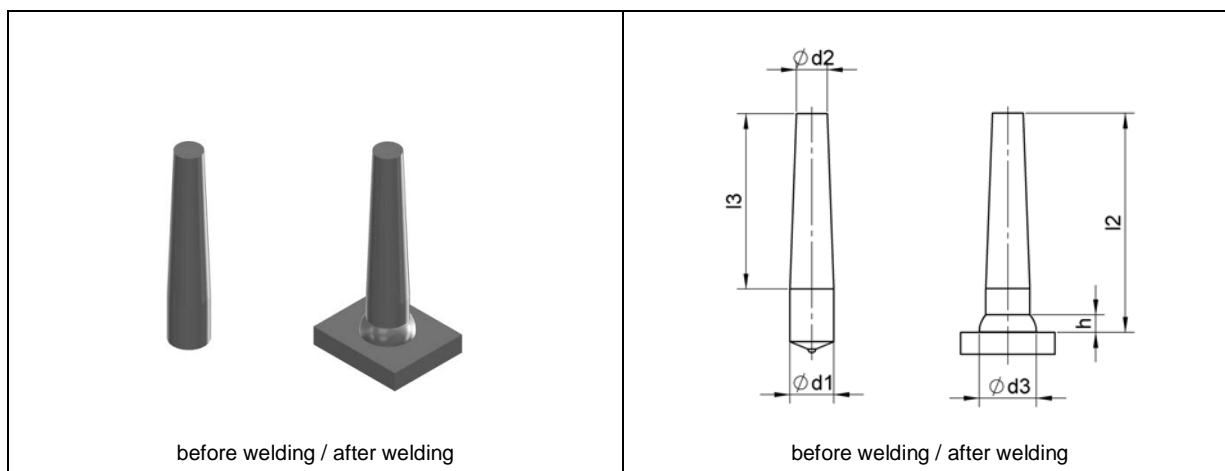
Available dimensions and materials available upon request.

1.25 Locking stud



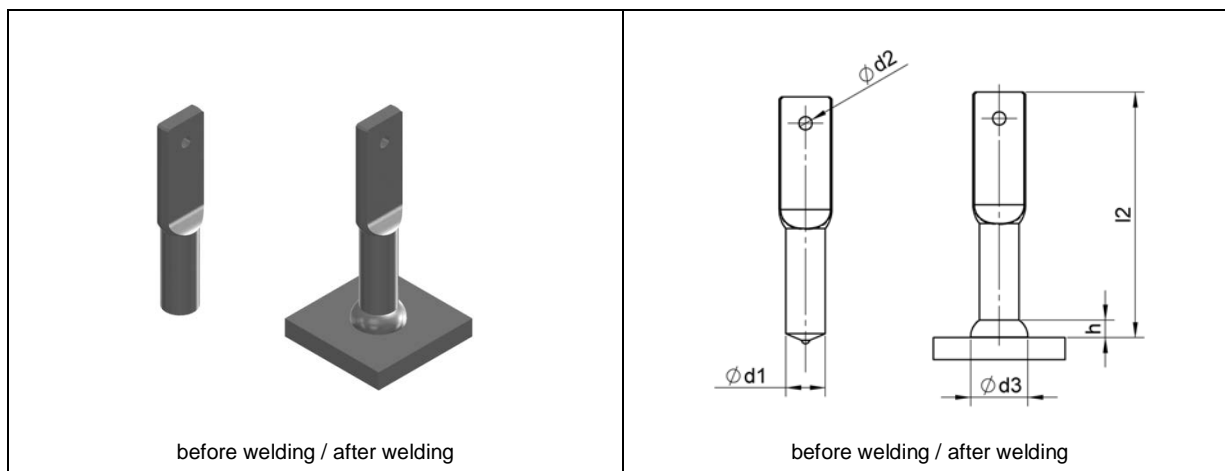
Available dimensions and materials available upon request.

1.26 Cone stud



Available dimensions and materials available upon request.

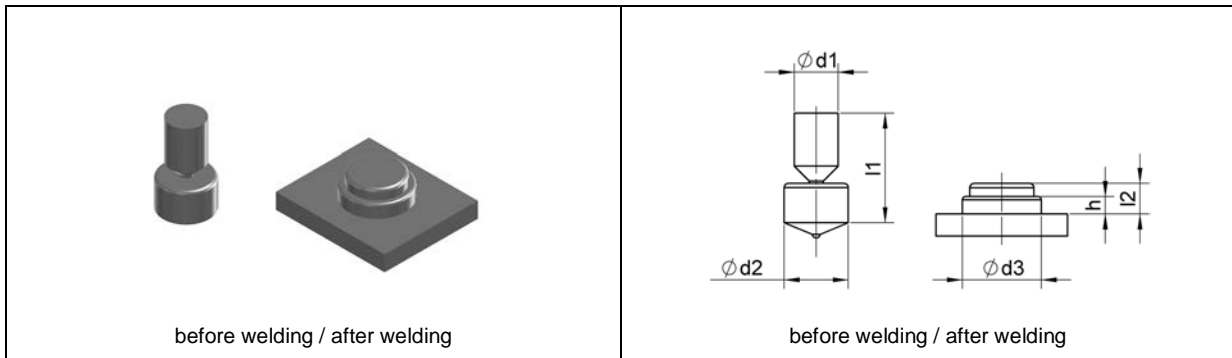
1.27 Flat-ended stud



Available dimensions and materials available upon request.

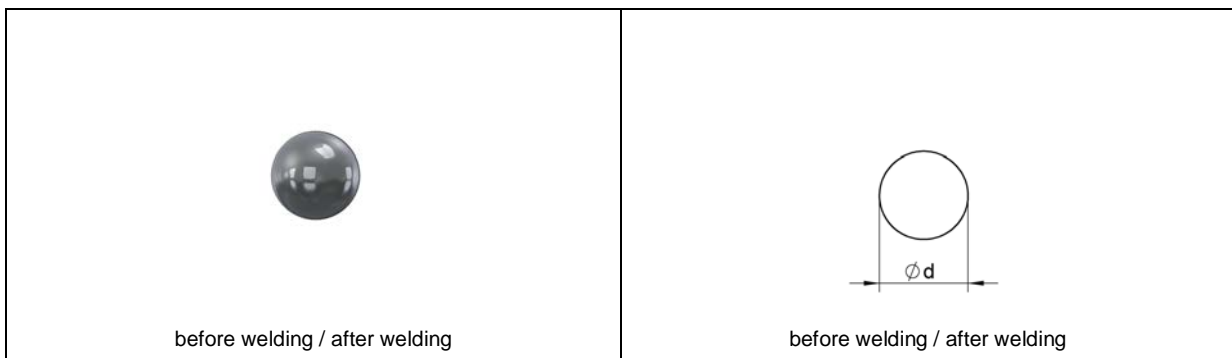


1.28 Anti-skid knock-off stud



Available dimensions and materials available upon request.

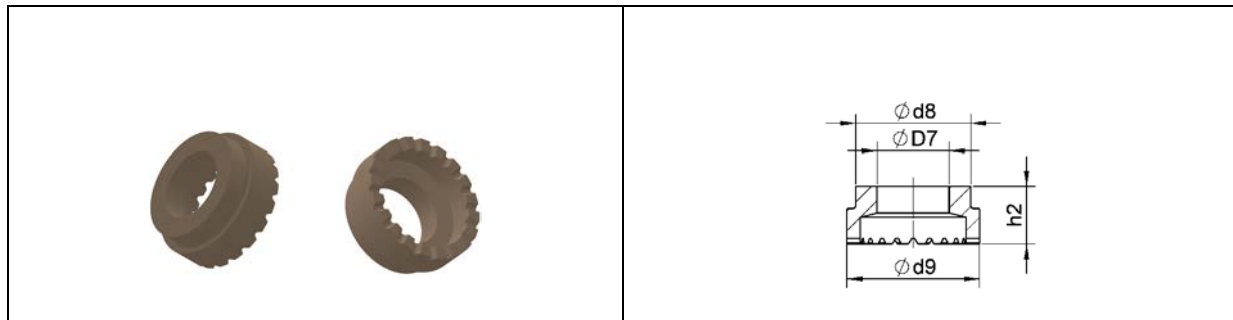
1.29 Ball



Available dimensions and materials available upon request.

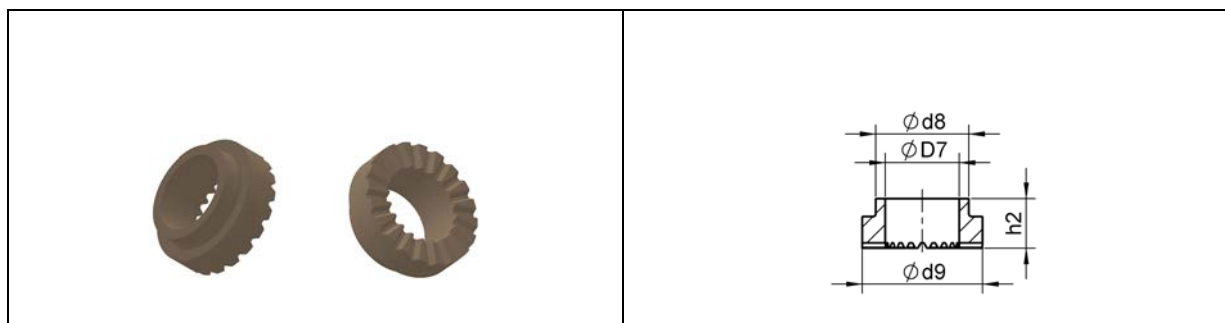
1.30 Ceramic ferrules

1.30.1 Ceramic ferrule for shear connectors, internally threaded studs and non-threaded studs (type UF acc. to DIN EN ISO 13918)



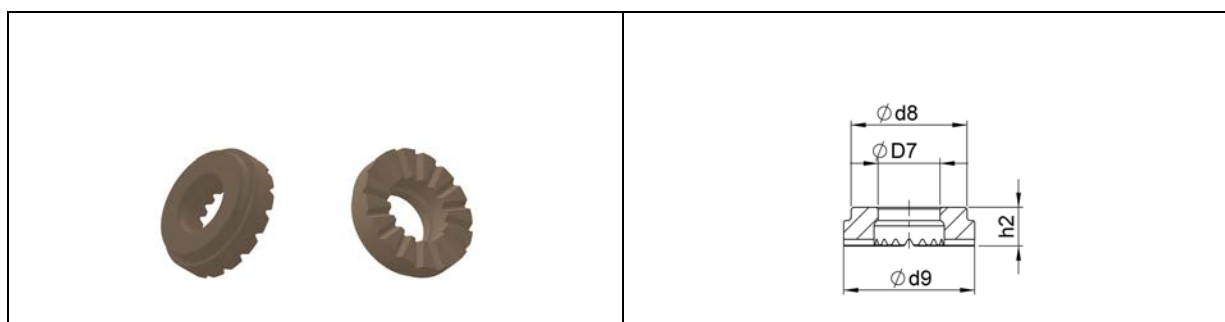
Description	Dimensions				Item number
	D_7 -0/+0,5	d_8 -1/+1	d_9 -1/+1	h_2	
UF 4	4,2	9,5	11,5	≈ 8,7	75-00-004
UF 5	5,2	9,5	11,5	≈ 8,7	75-00-005
UF 6	6,2	9,5	11,5	≈ 8,7	75-00-006
UF 8	8,2	11	15	≈ 8,7	75-00-008
UF 10	10,2	15	17,8	≈ 10	75-00-010
UFN 10	10,2	16,5	20	≈ 9,9	75-00-010-N
UF 12	12,2	16,5	20	≈ 10,7	75-00-012
UF 13	13,1	20	22,2	≈ 11	75-00-013
UF 16	16,3	26	30	≈ 13	75-00-016
UF 19	19,4	26	30,8	≈ 16,7	75-00-019
UF 20	20,4	26,1	32,8	≈ 14,2	75-00-020
UF 22 flat	22,8	30,7	38,5	≈ 14	75-00-022-F
UF 22	22,8	30,7	38,5	≈ 18,5	75-00-022
UF 25	26,0	35,5	41	≈ 21	75-00-025

1.30.2 Ceramic ferrule for threaded studs with reduced shaft (type RF acc. to DIN EN ISO 13918)



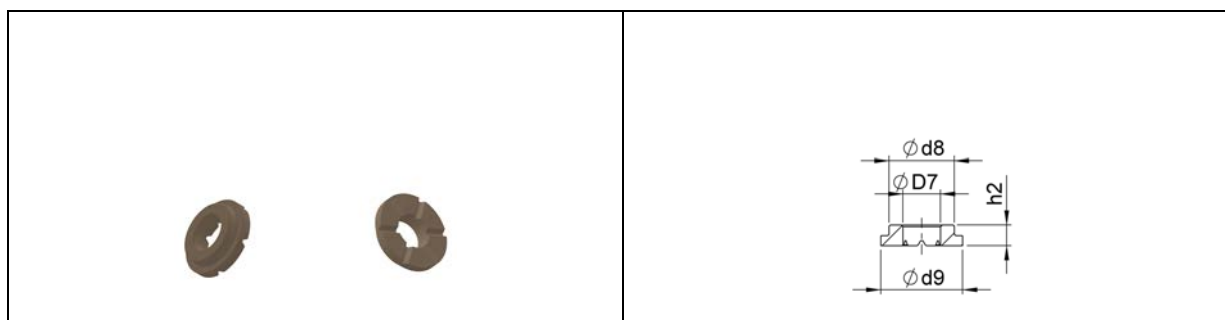
Description	Dimensions				Item number
	D_7 -0/+0,4	d_8 -1/+1	d_9 -1/+1	h_2	
RF 5	5,2	9,5	11,5	≈ 7,9	71-00-005
RF 6	6,2	9,5	12,2	≈ 10	71-00-006
RF 8	8,2	12	15,3	≈ 9	71-00-008
RF 10	10,2	15	18,5	≈ 11,5	71-00-010
RF 12	12,2	17	20	≈ 13	71-00-012
RF 16	16,3	20,5	26,5	≈ 15,3	71-00-016

1.30.3 Ceramic ferrule for threaded studs with reduced shaft, flat form (type RF (flat form) acc. to DIN EN ISO 13918)



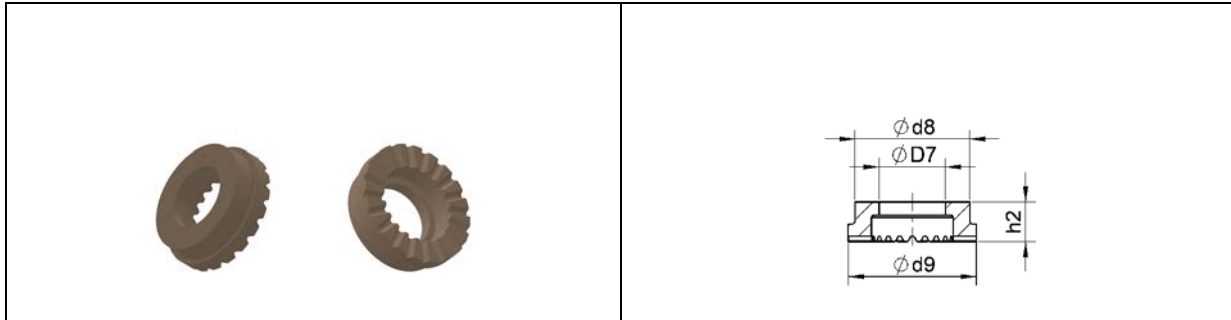
Description	Dimensions				Item number
	D_7 -0/+0,4	d_8 -1/+1	d_9 -1/+1	h_2	
RF 16 (flat form)	14	26,2	32,5	≈ 8,8	71-00-016-F
RF 20 (flat form)	17,5	26,2	32,5	≈ 9	71-00-020-F

1.30.4 Ceramic ferrule for threaded studs with reduced shaft (type KSR-F)



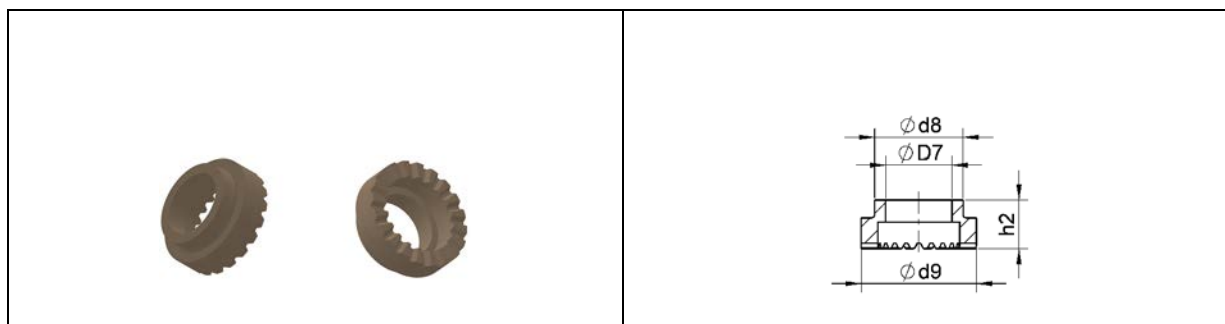
Description	Dimensions				Item number
	D_7 -0/+0,4	d_8 -1/+1	d_9 -1/+1	h_2	
KSR-F 8	8,4	14,8	17,8	≈ 4,7	71-00-008-F-N
KSR-F 10	10,3	14,5	19	≈ 6,7	71-00-010-F-N

1.30.5 Ceramic ferrule for threaded studs (type KSP-F)



Description	Dimensions				Item number
	D_7 -0,4/+0,4	d_8 -1/+1	d_9 -1/+1	h_2	
KSP-F 8	7,8	14,6	17,6	≈ 5	72-00-008-F
KSP-F 10	9,6	16,5	20	≈ 5,5	72-00-010-F
KSP-F 12	11	20	23,4	≈ 5,7	72-00-012-F
KSP-F 16	15,5	26	29	≈ 9	72-00-016-F-H
KSP-F 20	19,3	30,7	33,8	≈ 10	72-00-020-F

1.30.6 Ceramic ferrule for threaded studs (type PF acc. to DIN EN ISO 13918)



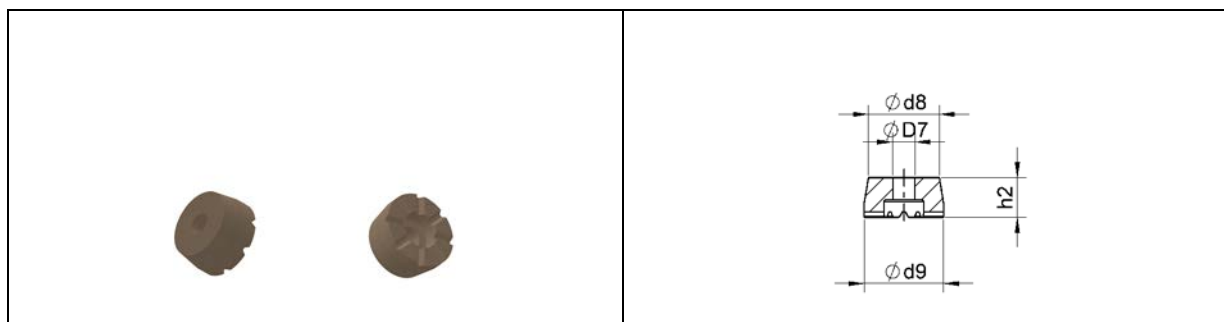
Description	Dimensions				Item number
	D_7 -0/+0,5	d_8 -1/+1	d_9 -1/+1	h_2	
PF 6	5,6	9,5	11,5	≈ 6,5	72-00-006
PF 8	7,4	11,5	15	≈ 6,5	72-00-008
PF 10	9,2	15	17,8	≈ 6,5	72-00-010
PF 12	11,1	16,5	20	≈ 9	72-00-012
PF 16	15,0	20	26	≈ 11	72-00-016

1.30.7 Ceramic ferrule for internally threaded studs and non-threaded studs (type KSN-F)



Description	Dimensions				Item number
	D_7 -0/+0,5	d_8 -1/+1	d_9 -1/+1	h_2	
KSN-F 10	10,25	14,8	17,8	≈ 7,4	75-00-010-F
KSN-F 12	12,25	20	23,2	≈ 6,3	75-00-012-F

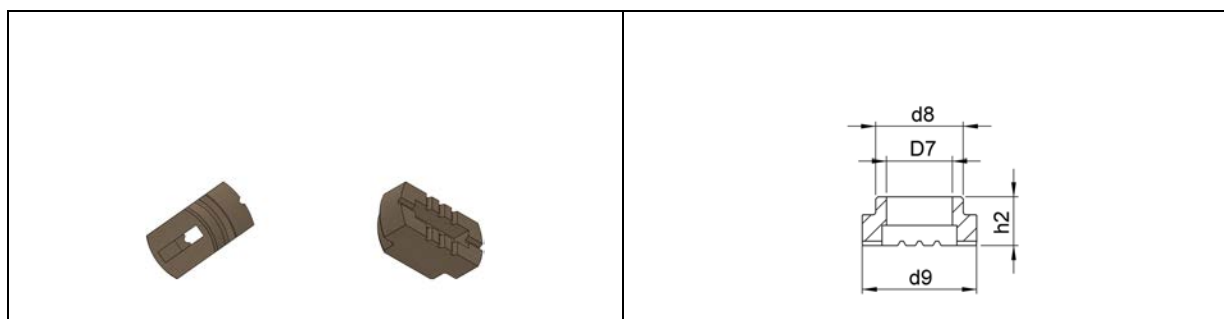
1.30.8 Permanent ceramic ferrule for insulation pins (type K)



A permanent ceramic ferrule can be used for approx. 100 weldings of insulation pins.

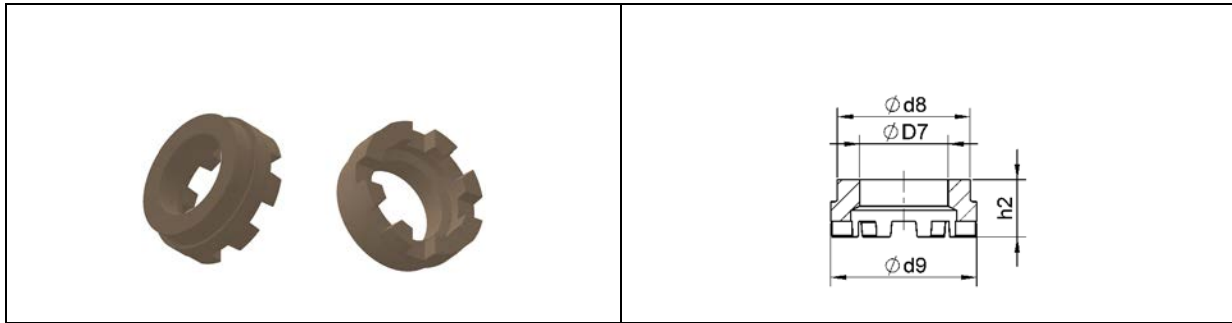
Description	Dimensions				Item number
	D_7 -0/+0,5	d_8 -1/+1	d_9 -1/+1	h_2	
K 5	5,3	16,2	18	≈ 9	75-00-005-K5
K 6	6,3	16,2	18	≈ 9	75-00-006-K6

1.30.9 Ceramic ferrule for rectangular studs (type KF)



Description	Dimensions				Item number
	D_7 -0,7/+0,7	d_8 -1/+1	d_9 -1/+1	h_2	
KF 15x3	16	20,5	26,5	≈ 11	71-00-153
KF 15x5	16	20,5	26,5	≈ 11	71-00-155
KF 25x3	25,5	30,5	35,5	≈ 13	71-00-253
KF 25x5	25,5	30,5	35,5	≈ 13	71-00-255

1.30.10 Special ceramic ferrule (welding through metal deck) for shear connectors (type UFD)



Special ceramic ferrule for welding through metal deck (welding of shear connectors through thin, mostly zinc-plated deck sheets onto the top belt of a steel beam).

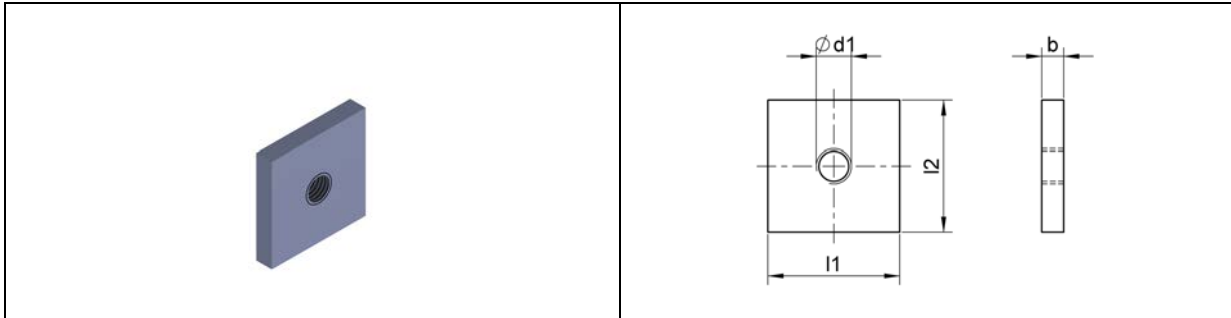
When welding through zinc-plated deck sheets there are high amounts of degasification through zinc evaporation. The special ceramic ferrule type UFD with larger combustion chamber and larger degasification slots considerably improves the welding result.

Description	Dimensions				Item number
	D_7 -0/+0,5	d_8 -1/+1	d_9 -1/+1	h_2	
UFD 16	16,5	25,5	30,2	≈ 17,7	75-00-016-D
UFD 19	20,5	30,8	33,8	≈ 15,2	75-00-019-D

Not listed dimensions available upon request.

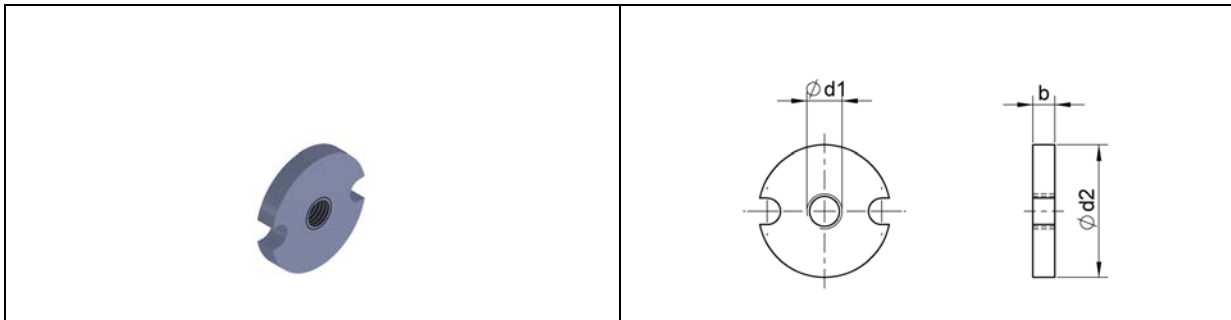
1.31 Fixing accessories

1.31.1 Threaded plate



Available dimensions and materials available upon request.

1.31.2 Disk nut

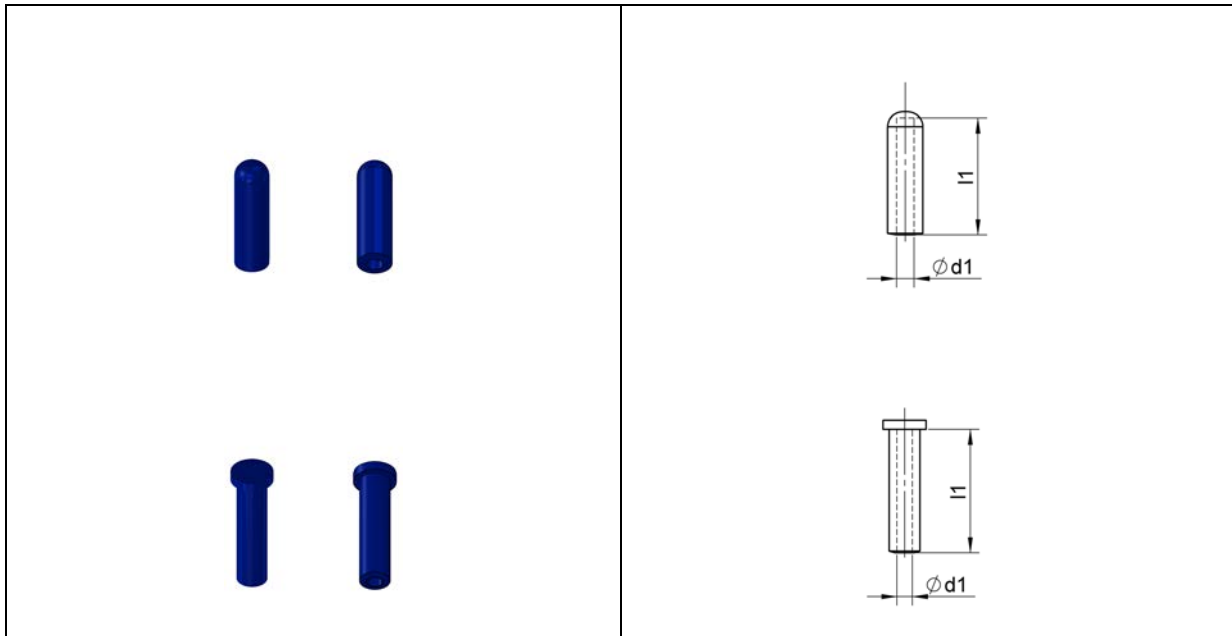


Available dimensions and materials available upon request.

1.32 Silicone cover caps

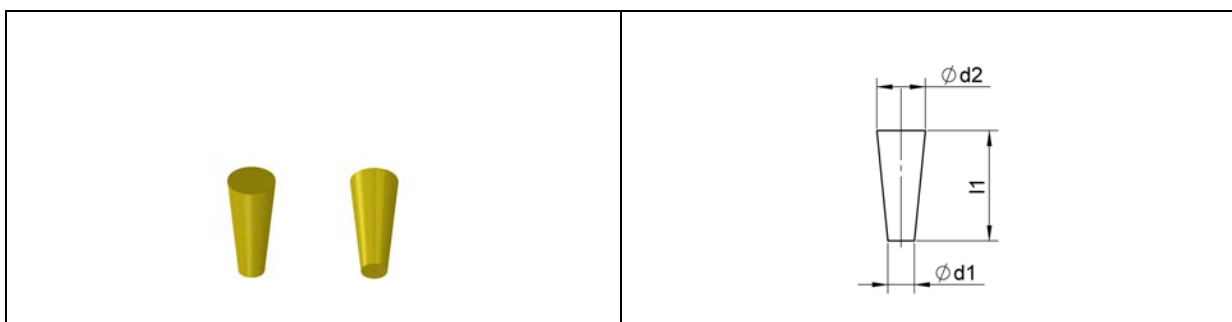
Silicone cover caps protect the mechanical important areas of the welding elements during painting and powder coating as well as during the burning-in process (permanent temperature $\leq 210^{\circ}\text{C}$, short temperature $\leq 300^{\circ}\text{C}$).

1.32.1 Silicone cover caps for threaded studs and non-threaded studs



Available dimensions available upon request.

1.32.2 Silicone cover caps for internally threaded studs



Available dimensions available upon request.



2. Welding studs for short cycle stud welding

2.1 Technical information

Materials

Our welding studs are standardly made from the following materials:

- steel, strength class 4.8 (suitable for welding) (according to DIN EN ISO 898-1) with excellent weldability
Mechanical properties: yield strength (R_e) ≥ 340 N/mm², tensile strength (R_m) ≥ 420 N/mm², elongation (A_5) $\geq 14\%$
- stainless steel A2-50 (suitable for welding) according to DIN EN ISO 3506-1
Mechanical properties: yield point ($R_{p0,2}$) ≥ 210 N/mm², tensile strength (R_m) ≥ 500 N/mm², elongation (A_L) $\geq 0,6d$
- stainless steel 1.4571 (suitable for welding) according to DIN EN ISO 3506-1
Mechanical properties: yield point ($R_{p0,2}$) ≥ 210 N/mm², tensile strength (R_m) ≥ 500 N/mm², elongation (A_L) $\geq 0,6d$

The material specifications conform with DIN EN ISO 13918 and DIN EN ISO 14555. For welding studs from other materials please send us your inquiry or contact us.

On demand, the material properties can be verified by an inspection document (test report, inspection certificate) according to DIN EN 10204.

We are pleased to inform you about weldability to different base materials and welding parameters.

Dimensions

Welding studs dimensions are given in the measurement tables (all dimensions in mm). All standardised welding studs conform to DIN EN ISO 13918. Not standardised welding studs are supplied according to DIN EN ISO 13918. Special welding elements, which are not described, are delivered upon request.

Dimensions that are not listed in the measurement tables are delivered upon request.

Surface protection

Standardly our welding studs made from steel 4.8 are supplied with an electrolytic copper plating of 4-8 μm (according to DIN EN ISO 4042) as corrosion protection. Other surface treatments are possible upon request.

Threads

The threads of the studs are cold rolled (tolerance limit 6g). For surface-treated studs the tolerance limit 6h can be reached. We deliver studs with special threads upon request.

Stud flange

Welding studs for short cycle stud welding have a closely tolerated cold formed flange. The diameter of the flange is always bigger than the external diameter of the welding element (see following drawings and measurement tables). The flange increases the surface area of the stud. Consequently, the stress at the point of weld is reduced and this results in a higher quality of the stud welded joint.

Upon request, it is possible to deliver welding studs with flange dimensions other than the ones listed and welding studs without flange. However, we can only recommend the limited use of welding studs without flange – depending on the welded joint requirements. Please contact us for this.

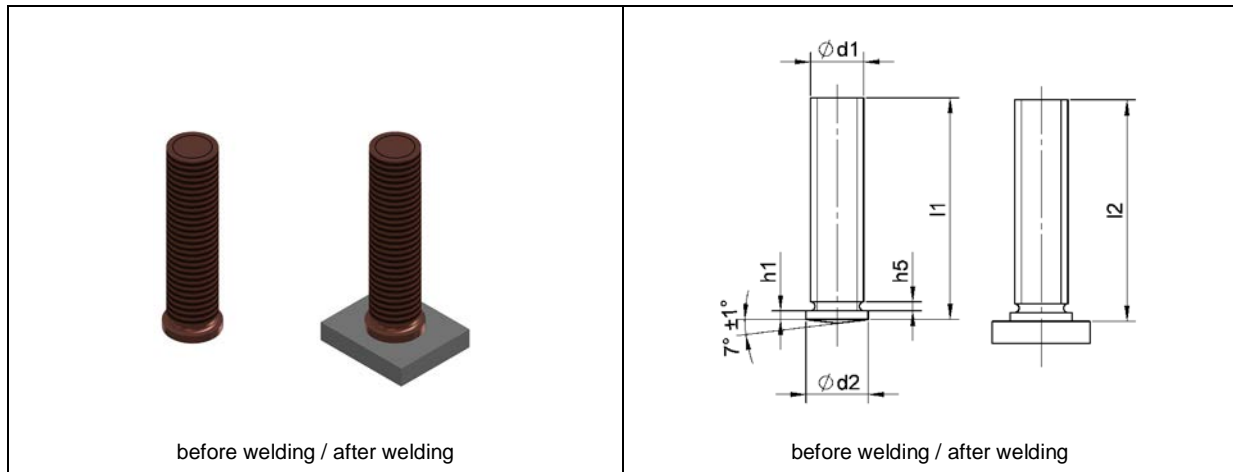
Welding face

Welding studs for short cycle stud welding have a cold formed conical welding face with dimensions closely controlled. The exact dimensions of the welding face are decisive for proper welding results.

Accessories for stud welding guns

Accessories for stud welding guns have to be adjusted to the welding element. The accessories which are to be used for the individual welding studs can be found in chapter 4.

2.2 Threaded stud (type PS acc. to DIN EN ISO 13918)



Dimensions					Material (item number)		
d ₁	l ₁	d ₂ ±0,2	h ₅ max.	h ₁	Steel 4.8 copper-plated	A2-50	1.4571
M3	6-30	4	0,6	0,7-1,4	17-03-XXX	18-03-XXX	181-03-XXX
M4	6-40	5	0,6	0,7-1,4	17-04-XXX	18-04-XXX	181-04-XXX
M5	6-45	6	1,0	0,7-1,4	17-05-XXX	18-05-XXX	181-05-XXX
M6	8-60	7	1,0	0,7-1,4	17-06-XXX	18-06-XXX	181-06-XXX
M8	10-60	9	1,5	0,8-1,4	17-08-XXX	18-08-XXX	181-08-XXX
M10	15-60	11	2,0	0,8-1,4	17-10-XXX	18-10-XXX	181-10-XXX

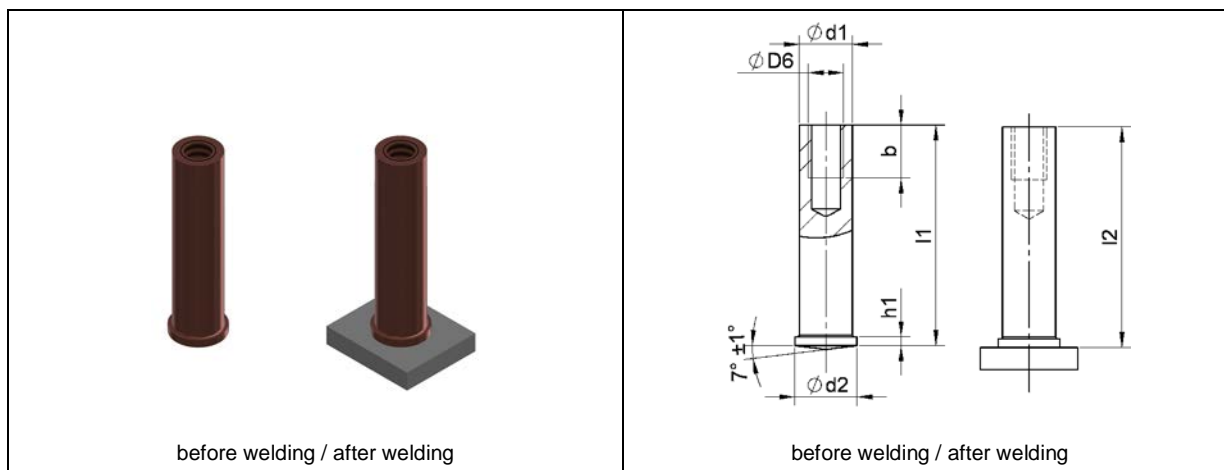
*l₂ (length after welding) depends on l₁ and the welding energy.

In the item number **XXX** has to be replaced by the respective welding element length l₁ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 2.1.

Not listed dimensions and materials available upon request.

2.3 Internally threaded stud (type IS acc. to DIN EN ISO 13918)



Dimensions						Material (item number)	
d_1 ±0,1	l_1	D_6	b min.	d_2 ±0,2	h_1	Steel 4.8 copper-plated	A2-50
5	6-30	M3	5 (4 ¹)	6,0	0,7-1,4	37-35-XXX	38-35-XXX
6	8-40	M4	5	7,0	0,7-1,4	37-46-XXX	38-46-XXX
7,1	10-40	M5	6	9,0	0,8-1,4	37-57-XXX	38-57-XXX
8	15-40	M6	10	9,0	0,8-1,4	37-68-XXX	38-68-XXX

¹for $l_2 < 8$ mm

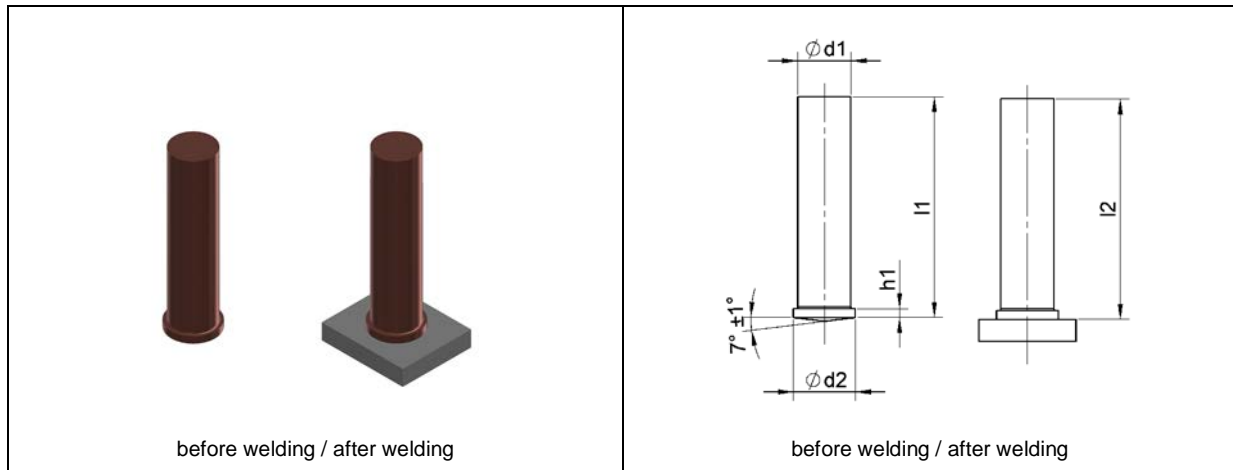
* l_2 (length after welding) depends on l_1 and the welding energy.

In the item number **XXX** has to be replaced by the respective welding element length l_1 (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 2.1.

Not listed dimensions and materials available upon request.

2.4 Non-threaded stud (type US acc. to DIN EN ISO 13918)



Dimensions				Material (item number)		
d ₁	l ₁	d ₂ ±0,2	h ₁	Steel 4.8 copper-plated	A2-50	1.4571
3	6-30	4	0,7-1,4	27-03-XXX	28-03-XXX	281-03-XXX
4	6-40	5	0,7-1,4	27-04-XXX	28-04-XXX	281-04-XXX
5	6-45	6	0,7-1,4	27-05-XXX	28-05-XXX	281-05-XXX
6	8-60	7	0,7-1,4	27-06-XXX	28-06-XXX	281-06-XXX
7,1	10-60	9	0,8-1,4	27-07,1-XXX	28-07,1-XXX	281-07,1-XXX
8	15-60	9	0,8-1,4	27-08-XXX	28-08-XXX	281-08-XXX

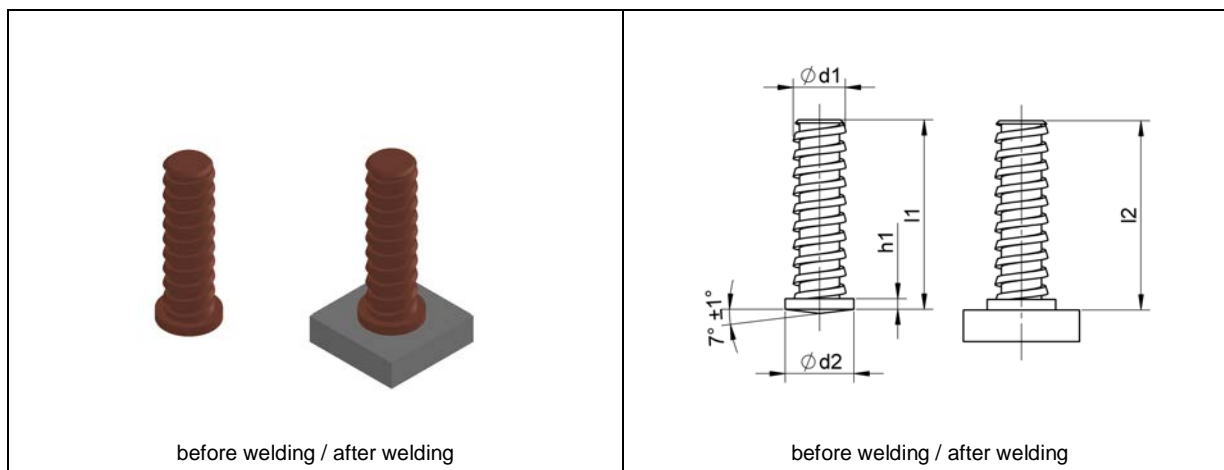
*l₂ (length after welding) depends on l₁ and the welding energy.

In the item number **XXX** has to be replaced by the respective welding element length l₁ (e.g. 030 for 30 mm).

Explanations to the used materials can be found in chapter 2.1.

Not listed dimensions and materials available upon request.

2.5 Fir tree stud



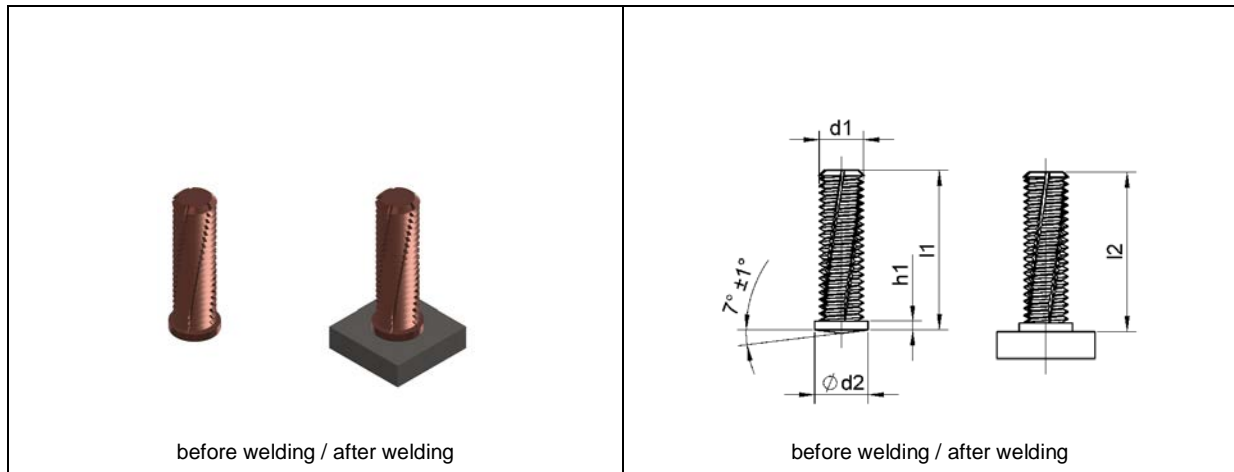
Dimensions				Material (item number)	
d ₁	l ₁	d ₂ ±0,2	h ₁	Steel 4.8 copper-plated	A2-50
5	9	6	0,7-1,4	07-05-009	08-05-009
5	14,2	6	0,7-1,4	07-05-014,2	08-05-014,2
5	18	6	0,7-1,4	07-05-018	08-05-018
5	25	6	0,7-1,4	07-05-025	08-05-025

*l₂ (length after welding) depends on l₁ and the welding energy.

Explanations to the used materials can be found in chapter 2.1.

Not listed dimensions and materials available upon request.

2.6 Colour groove stud



Dimensions				Material (item number)	
d ₁	l ₁	d ₂ ±0,2	h ₁	Steel 4.8 copper-plated	A2-50
M4	upon request	5	0,7-1,4	17-LN-04-XXX	18-LN-04-XXX
M5	upon request	6	0,7-1,4	17-LN-05-XXX	18-LN-05-XXX
M6	upon request	7	0,7-1,4	17-LN-06-XXX	18-LN-06-XXX
M8	upon request	9	0,8-1,4	17-LN-08-XXX	18-LN-08-XXX

*l₂ (length after welding) depends on l₁ and the welding energy.

In the item number **XXX** has to be replaced by the respective welding element length l₁ (e.g. 030 for 30 mm).

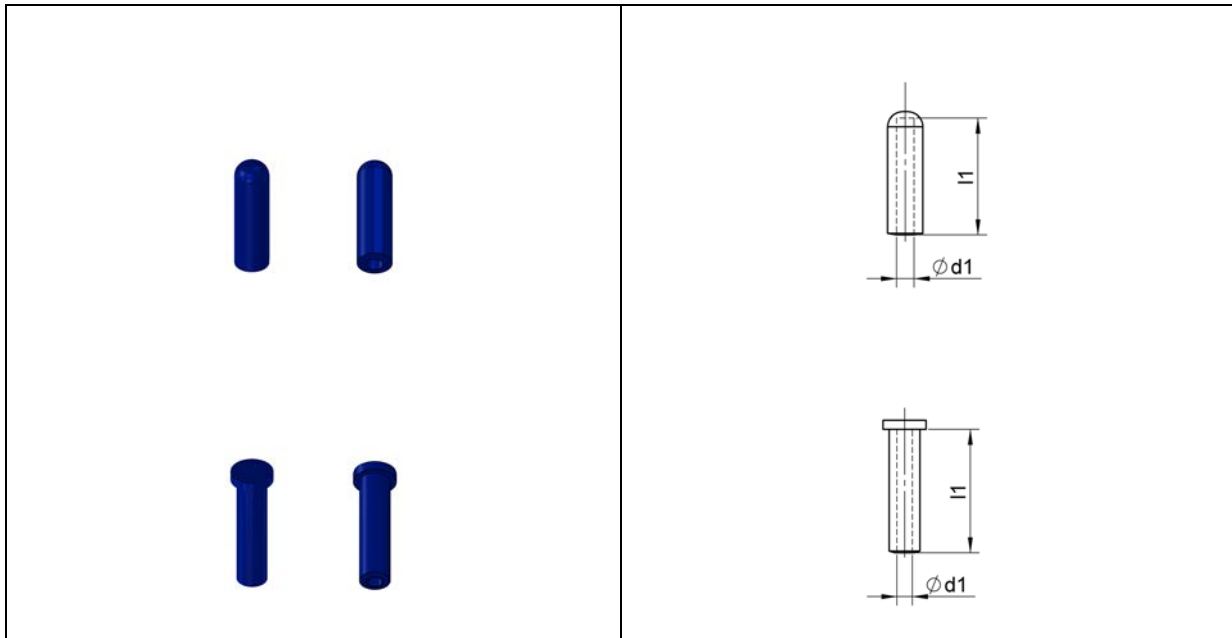
Explanations to the used materials can be found in chapter 2.1.

Not listed dimensions and materials available upon request.

2.7 Silicone cover caps

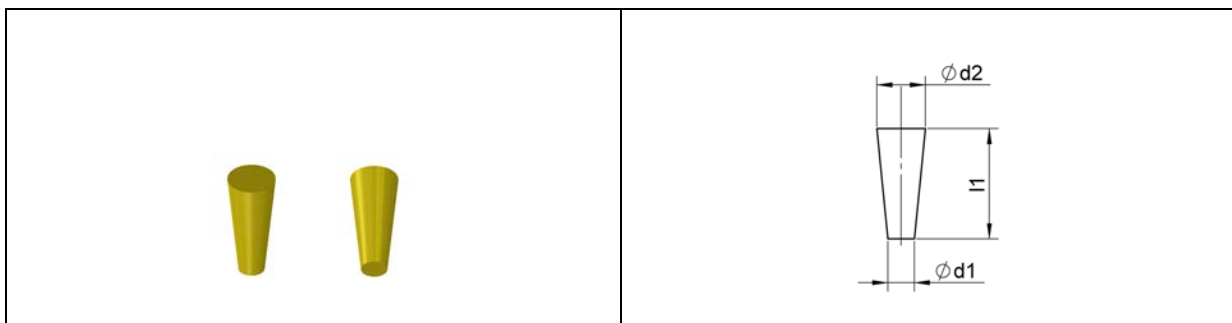
Silicone cover caps protect the mechanical important areas of the welding elements during painting and powder coating as well as during the burning-in process (permanent temperature $\leq 210^{\circ}\text{C}$, short temperature $\leq 300^{\circ}\text{C}$).

2.7.1 Silicone cover caps for threaded studs and non-threaded studs



Available dimensions available upon request.

2.7.2 Silicone cover caps for internally threaded studs



Available dimensions available upon request.



Annex: Accessories and wear parts for stud welding guns

**3. Accessories and wear parts for stud welding guns
for drawn arc welding studs**

3.1 Shear connector (type SD1)

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
10	l ₂ ≤ 50 l ₂ > 50	83-65-190	83-45-165 83-46-165	PHM-160/161, GD 16/19/22/25: 83-42-029
13	l ₂ ≤ 50 l ₂ > 50	83-65-254	83-45-199 83-46-199	PHM-160/161, GD 16/19/22/25: 83-42-044
16	l ₂ ≤ 50 l ₂ > 50	83-65-317 ¹ / 83-71-317 ²	83-45-261 83-46-261	PHM-160/161, GD 16/19/22/25: 83-42-044
19	l ₂ ≥ 50	83-65-317 ¹ / 83-71-317 ²	83-46-261	GD 19/22/25: 83-42-044
22	l ₂ ≥ 75	83-65-349 ¹ / 83-71-349 ²	83-46-307	GD 22/25: 83-42-044
25	l ₂ ≥ 75	83-65-409 ¹ / 83-71-409 ²	83-46-355	GD 25: 83-42-044

¹Chuck made of steel nickel-plated, ²chuck made of copper

3.2 Threaded stud (type RD, RD-DUO)

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
M6	l ₂ < 20 l ₂ ≥ 20	83-50-006-4 83-50-006	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M8	l ₂ < 20 l ₂ ≥ 20	83-50-008	65-09-00 65-08-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M10	l ₂ < 20 l ₂ ≥ 20	25-30-00 83-50-010	65-09-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M12	l ₂ < 20 l ₂ ≥ 20	25-31-00 83-55-012	65-10-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M16 (y ≥ 7,5)	l ₂ < 30 l ₂ ≥ 30	25-99-00 83-55-016	65-11-00	PHM-12: 83-41-029 PHM-160/161, GD 16/19/22/25: 83-40-029
M16 (y ≥ 11)	l ₂ < 30 l ₂ ≥ 30	25-99-00 83-55-016	65-12-00	PHM-12: 83-41-029 PHM-160/161, GD 16/19/22/25: 83-40-029
M20	l ₂ ≥ 30	83-55-020	65-12-00	GD 19/22/25: 83-40-029
M24	l ₂ ≥ 50	25-46-00	65-12-00	GD 22/25: 83-40-029



3.3 Threaded stud (type MPF, MPF-DUO)

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
M6	l ₂ < 20 l ₂ ≥ 20	83-50-006-4 83-50-006	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M8	l ₂ < 20 l ₂ ≥ 20	25-29-00 83-50-008	65-09-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M10	l ₂ < 20 l ₂ ≥ 20	25-30-00 83-50-010	65-10-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M12	l ₂ < 25 l ₂ ≥ 25	25-31-00 83-55-012	65-11-00	PHM-12: 83-41-029 PHM-160/161, GD 16/19/22/25: 83-40-029
M16	l ₂ ≥ 30	83-55-016	65-12-00	PHM-160/161, GD 16/19/22/25: 83-40-029
M20	l ₂ ≥ 35	83-55-020	65-13-00	GD 19/22/25: 83-40-044

3.4 Threaded stud (type PD)

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
M6	> 15	83-50-006	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M8	> 20	83-50-008	65-08-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M10	> 20	83-50-010	65-09-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M12	> 25	83-55-012	65-10-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M16	> 30	83-55-016	65-11-00	PHM-160/161, GD 16/19/22/25: 83-40-029
M20	> 35	83-55-020	65-13-00	GD 19/22/25: 83-40-044
M24	> 50	25-46-00	65-13-00	GD 22/25: 83-40-044

3.5 Threaded stud (type MD)

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
M6	15-100	83-50-006	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M8	15-100	83-50-008	65-08-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M10	15-100	83-50-010	65-09-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M12	20-100	83-55-012	65-10-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M16	25-100	83-55-016	65-12-00	PHM-160/161, GD 16/19/22/25: 83-40-029
M20	30-100	83-55-020	65-12-00	GD 19/22/25: 83-40-029



3.6 Internally threaded stud (type ID), non-threaded stud (type UD)

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
6	l ₂ < 20 l ₂ ≥ 20	83-50-006-4 83-50-006	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
8	l ₂ < 20 l ₂ ≥ 20	83-50-008-4 83-50-008	65-08-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
10	l ₂ < 20 l ₂ ≥ 20	25-97-00 83-50-010	65-09-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
12	l ₂ < 25 l ₂ ≥ 25	25-31-00 83-55-012	65-10-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
14,6	l ₂ < 30 l ₂ ≥ 30	26-90-00 26-48-00	65-12-00	PHM-160/161, GD 16/19/22/25: 83-40-029
16	l ₂ < 30 l ₂ ≥ 30	25-99-00 83-55-016	65-12-00	PHM-160/161, GD 16/19/22/25: 83-40-029
18,3	l ₂ < 30 l ₂ ≥ 30	83-55-018-5 83-55-018	65-13-00	GD 19/22/25: 83-40-044
20	l ₂ ≥ 40	83-55-020	65-12-00	GD 22/25: 83-40-044
22	l ₂ ≥ 40	25-15-00	65-13-00	GD 22/25: 83-40-044

3.7 Insulation pin (type ISA, ISB, ISMS)

Stud dimensions		Gun accessories			
d ₁	l ₂	Chuck (item number)	Supporting tube (item number)	Teflon insert (item number)	Foot piece (Gun type: item number)
3	20 ≤ l ₂ < 65 65 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-003 83-45-003 83-90-003	80-11-002	80-11-003	PHM-12: 83-41-035 PHM-160/161, GD 16/19/22/25: 83-40-035
4	50 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-004 83-85-004	80-11-002	80-11-003	PHM-12: 83-41-035 PHM-160/161, GD 16/19/22/25: 83-40-035
5	50 ≤ l ₂ < 65 65 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-005 83-40-005 83-85-005	80-11-002	80-11-003	PHM-12: 83-41-035 PHM-160/161, GD 16/19/22/25: 83-40-035
6	50 ≤ l ₂ < 110 l ₂ ≥ 110	83-50-006-25 83-85-006	80-11-002	80-11-003	PHM-12: 83-41-035 PHM-160/161, GD 16/19/22/25: 83-40-035

Alternatively, when using ceramic ferrules type UF:

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
3	20 ≤ l ₂ < 65 65 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-003 83-45-003 83-90-003	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
4	50 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-004 83-85-004	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
5	50 ≤ l ₂ < 65 65 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-005 83-40-005 83-85-005	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
6	50 ≤ l ₂ < 110 l ₂ ≥ 110	83-50-006-25 83-85-006	65-07-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022



Alternatively, when using permanent ceramic ferrules type K:

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
3	20 ≤ l ₂ < 65 65 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-003 83-45-003 83-90-003	65-31-01	PHM-12: 83-41-022-M22
4	50 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-004 83-85-004	65-31-01	PHM-12: 83-41-022-M22
5	50 ≤ l ₂ < 65 65 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-005 83-40-005 83-85-005	65-31-01	PHM-12: 83-41-022-M22
6	50 ≤ l ₂ < 110 l ₂ ≥ 110	83-50-006-25 83-85-006	65-31-01	PHM-12: 83-41-022-M22

3.8 Bimetallic insulation pin (type VBS, VBS-MS)

Stud dimensions		Gun accessories			
d ₁	l ₂	Chuck (item number)	Supporting tube (item number)	Teflon insert (item number)	Foot piece (Gun type: item number)
3	20 ≤ l ₂ < 65 65 ≤ l ₂ < 110 l ₂ ≥ 110	83-25-003 83-45-003 83-90-003	80-11-002	80-11-003	PHM-12: 83-41-035 PHM-160/161, GD 16/19/22/25: 83-40-035

3.9 Rectangular stud (type A, B, C)

Stud dimensions			Gun accessories		
b	s	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
15	3	≥ 20	83-03-015	65-11-00	PHM-160/161, GD 16/19/22/25: 83-40-029
15	5	≥ 20	83-05-015	65-11-00	PHM-160/161, GD 16/19/22/25: 83-40-029
25	3	≥ 25	83-03-025	65-13-00	PHM-160/161, GD 16/19/22/25: 83-40-044
25	5	≥ 25	83-05-025	65-13-00	PHM-160/161, GD 16/19/22/25: 83-40-044

3.10 Threaded stud (type M)

Stud dimensions		Gun accessories		
d ₁	l ₂	Chuck (item number)	Ferrule grip (item number)	Foot piece (Gun type: item number)
M8	≥ 15	83-50-008	65-08-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M10	≥ 20	83-50-010	65-09-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M12	≥ 20	83-55-012	65-10-00	PHM-12: 83-41-022 PHM-160/161, GD 16/19/22/25: 83-40-022
M16	≥ 30	83-55-016	65-12-00	PHM-160/161, GD 16/19/22/25: 83-40-029
M20	≥ 40	83-55-020	65-12-00	GD 19/22/25: 83-40-029



**4. Accessories and wear parts for stud welding guns
 for short cycle welding studs**

**4.1 Threaded stud (type PS), internally threaded stud (type IS), non-threaded stud (type US),
 fir tree stud, colour groove stud**

For stud welding guns PHM-10, PHM-1A:

Stud dimensions		Gun accessories
d ₁	l ₂	Chuck (item number)
M3 / 3	l ₂ ≤ 40 l ₂ > 40 ¹	82-50-003
M4 / 4	l ₂ ≤ 40 l ₂ > 40 ¹	82-50-004
M5 / 5	l ₂ ≤ 40 l ₂ > 40 ¹	82-50-005
M6 / 6	l ₂ ≤ 40 l ₂ > 40 ¹	82-50-006
7,1	l ₂ ≤ 40 l ₂ > 40 ¹	82-50-071
M8 / 8	l ₂ ≤ 40 l ₂ > 40 ¹	82-50-008
M10	l ₂ ≤ 15 ¹	82-50-010

¹Besides chucks additional special accessories are necessary (for M3-M8 resp. Ø3-8 for lengths > 40 mm, for M10 for all lengths). Please contact us for this.



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