

#### NELSON STUD WELDING

#### FERRULE SPECIFICATION

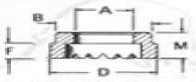
Ceramic ferrules are an essential part of the standard drawn are stud welding process. They are designed to encircle the weld stud to protect the weld are and limit it to a specific area of the base material. They also contain the molten weld metal and act as a mold to give a uniform shape to this metal, also called the weld flash. The term, weld flash, is used to distinguish the weld metal at the base of a stud from the weld metal deposited by other are welding processes, which is called weld fillet.

#### Standard Ferrules

These studs are intended for welding round studs perpendicular to flat surfaces.

Full Base - These standard ferrules are standard ferrules supplied with full weld base NBL, TBL, H4L, S3L, and D2L study.

Nominal Stud Size	Diameter A	Neck Diameter B	Major Diameter D	Height to Neck	Height Overall M	Ferrule Part Number
AS	0.138	0.261	0.325	0.234	0.390	100101001
48	0.164	9.291	0.375	0.234	10.390	100101000
301101	0.187	0.305	0.300	0.234	0.390	100101000
1/4	-0.250	0.505	0.640	0.296	0.437	100101067
5/16	0.342	0.445	0.578	0.234	0.390	100101007
3/8	0.375	0.650	0.795	0.226	0.390	100101099
7/16	0.437	0.565	0.765	0.234	0.422	100010110000
10	0.500	0.765	0.875	0.228	0.390	100101114
\$675-6	0.562	0.795	1.030	0.3288	0.515	100101011
5/9	0.625	1,030	1.150	0.339	0.526	100101187
3/4	0.780	1.030	1.215	0.469	0.656	100101152
13/16	0.813	1.210	1,735	0.2800	0.464	1.3 SECTION 15 17 17 18
7.00	0.875	1210	1.413	0.545	0.732	100101540
	1.000	17406	1,610	0.633	0.820	100101045
7-3-8-8	1.125	1.541	1.765	0.503	0.815	100101143
37594	1.250	2.015	2.095	1 (0.00)	1.030	100101146



To determine the ferrule grips, ferrule holders, or ferrule tubes that can be used with specific ferrule types, look at the neck diameter (inside diameter) of the ferrule, then look in the accessories catalog for ferrule grips, holders, or tubes to match that inside diameter.

Full Base – Thin Wall – These special order ferrules are available for full base study to accommodate special situations or futuring.

Nominal Stud Size	Inside Diameter A	Neck Diameter B	Major Diameter D	Height to Neck	Overall M	Ferrule Part Number
2.00	0.250	0.380	0.455	0.2865	0.390	100/10/1006
3/8	0.375	0.505	0.640	0.234	0.390	100101008
1/2	0.600	0.660	0.795	0.250	0.438	100101010
5/8	0.625	0.785	1.000	0.328	0.515	100101012

Full Base - Low Profile, F-139 - These femules are available for short study

Nominal Stud Size	Diameter A	Neck Diameter B	Major Diameter D	Height to Neck	Height Overall M	Ferrule Part Number
#10 ·	0.587	0.305	0.390	0.125	0.250	100101063
5.96	0.250	0.370	0.455	0.125	0.250	100101077
5/16	0.342	0.505	0.596	0.1(2)5	0.250	100101030
3/6	0.375	0.585	0.675	0.125	0.250	100101031
7716	0.437	0.650	0.740	0.10%	0.281	100101032
1/2	0.500	0.785	0.875	0.574	0.330	100101003
1/2	0.500	0.921	1.030	0.125	0.312	100101119
5/9	0.625	0.921	1.000	0.587	0.375	1001011126
3/4	0.750	1.210	1.413	0.200	0.390	100101133
5.8	0.375	0.765	0.875	-0.190	0.261	100101101
1/2	0.500	1.042	1.162	0.126	0.281	100101122

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# **Nelson Stud Design Guide**

Chris R Hendy, Roger P. Johnson

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