

NELSON STUD WELDING FERRULE SPECIFICATION

Ceramic ferrules are an essential part of the standard drawn arc stud welding process. They are designed to encircle the weld stud to protect the weld arc 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 arc 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, FHL, S3L, and D3L** studs.

Nominal Stud Size	Inside Diameter A	Neck Diameter B	Major Diameter D	Height to Neck F	Height Overall M	Ferrule Part Number
#6	0.138	0.261	0.375	0.234	0.390	100101001
#8	0.164	0.291	0.375	0.234	0.390	100101002
#10	0.187	0.305	0.390	0.234	0.390	100101003
1/4	0.250	0.505	0.640	0.295	0.437	100101007
5/16	0.312	0.445	0.578	0.234	0.390	100101007
3/8	0.375	0.600	0.795	0.235	0.390	100101009
7/16	0.437	0.585	0.795	0.234	0.422	100101009
1/2	0.500	0.795	0.875	0.228	0.390	100101114
5/8	0.562	0.795	1.030	0.328	0.515	100101011
3/4	0.625	1.030	1.150	0.339	0.526	100101187
7/8	0.750	1.030	1.215	0.469	0.656	100101153
1-1/8	0.813	1.210	1.735	0.290	0.464	100101178
1 1/2	0.875	1.210	1.413	0.545	0.730	100101140
1	1.000	1.405	1.610	0.633	0.820	100101045
1-1/8	1.125	1.541	1.795	0.503	0.815	100101143
1-1/4	1.250	2.015	2.015	1.030	1.030	100101146

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

Nominal Stud Size	Inside Diameter A	Neck Diameter B	Major Diameter D	Height to Neck F	Height Overall M	Ferrule Part Number
1/4	0.250	0.380	0.455	0.265	0.390	100101006
3/8	0.375	0.505	0.640	0.234	0.390	100101008
1/2	0.500	0.650	0.795	0.250	0.438	100101010
5/8	0.625	0.795	1.030	0.328	0.515	100101012

Full Base – Low Profile, F-139 – These ferrules are available for **short studs**

Nominal Stud Size	Inside Diameter A	Neck Diameter B	Major Diameter D	Height to Neck F	Height Overall M	Ferrule Part Number
#10	0.187	0.305	0.390	0.125	0.250	100101063
1/4	0.250	0.370	0.455	0.125	0.250	100101077
5/16	0.312	0.505	0.596	0.125	0.250	100101030
3/8	0.375	0.585	0.675	0.125	0.250	100101031
7/16	0.437	0.650	0.740	0.125	0.261	100101032
1/2	0.500	0.795	0.875	0.174	0.330	100101033
1/2	0.500	0.901	1.030	0.125	0.312	100101119
5/8	0.625	0.901	1.030	0.187	0.375	100101126
3/4	0.750	1.210	1.413	0.203	0.390	100101133
5/8	0.375	0.795	0.875	0.190	0.281	100101101
1/2	0.500	1.062	1.187	0.125	0.281	100101122



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.

Visit our website www.NelsonStudWelding.com for a list of our standard stock products.

Nelson Stud Design Guide

Chris R Hendy, Roger P. Johnson



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