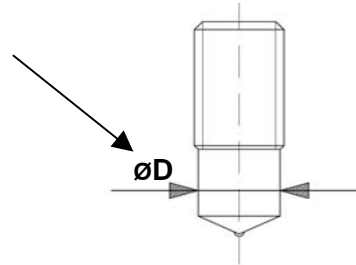


## Recommended values for drawn arc stud welding with ferrules

In the following diagram are recommended values for welding on metallic bright surfaces in flat position PA for unalloyed, low-alloyed and high-alloyed steel.

### Determination of the recommended values for example the stud MR16x35 and with help of diagram 1.1 in 5 points

- point **(A)** Determination of the weld diameter  $D=14,6\text{mm}$   
from it will be received  
point **(B)** the current intensity  $I = 1150\text{ A}$  and  
point **(C)** the welding time  $t = 570\text{ ms}$

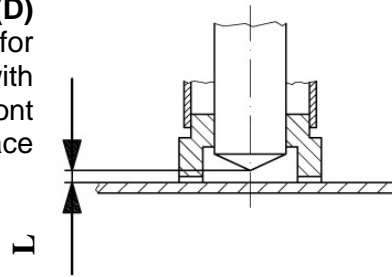


The protrusion **P** (picture 1.2) and the lift **L** (picture 1.1) will be taken out of table 1.1.

Type	Ø Stud [mm]	Lift L [mm]	Protrusion P [mm]
M6	~ 5	1,0	>1,5
M8	~ 6	1,5	>2,0
M10	~ 8	2,0	>2,5
M12	~ 10	2,0	>2,5
M16	~ 13	2,5	>3,0
M20	~ 17	3,0	>4,0

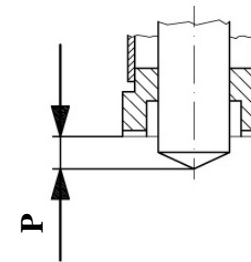
table 1.1

point **(D)**  
Lift for  
studs with  
conicle front  
surface



Picture 1.1

point **(E)**  
Protrusion for  
studs with  
conicle front  
surface



Picture 1.2

Earth polarity = plus

Until  $\varnothing 10\text{ mm}$  working without damping,  
from  $\varnothing 10\text{ mm}$  working with damping.

Before starting to weld, the weld-parameter had to adjust to the circumstances of the conditions of surface, the weld-position, the length of current power supply etc., by own tests.