

TRU-WELD



STANDARD WELD STUDS

A DIVISION OF *TFP* CORPORATION
460 LAKE RD.
MEDINA, OHIO 44256

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TRU-WELD Stud Welding

Since 1959 Tru-Weld has been an industry leader of weld stud sales and manufacturing. TRU-WELD manufactures weld stud fasteners for a vast variety of applications. From the small everyday handheld tools, yard machinery, etc. to automobiles, aircrafts, bridges, ocean liners, steel structure buildings and military vehicles; weld studs are all around us in our everyday lives.

Stud Welding

Simply stated, the process of "Stud Welding" is the fusing of a threaded or non-threaded metal shaft or stud to a workpiece with a high power electrical detonation - yielding a stronger bond than if it were forged or traditionally welded.

Full Service Manufacturing With our full in-house manufacturing facility, Heat Treating and Finishing departments, Tru-Weld will design and manufacture a weld stud to suit your specific needs and application.

Service, Quality and Competitive Pricing The three vital steps that make the business world go around. We believe that with uncompromised service, high quality manufacturing and competitive pricing, TRU-WELD will continue to retain our current and gain new customers around the world. Please contact us to see if we can add you as another satisfied customer.

Experience Since 1928 TFP Corp. has been manufacturing Cold-Formed Fasteners. And now 54 years later - since 1959 Tru-Weld has maintained industry leadership in weld stud sales, manufacturing and equipment.

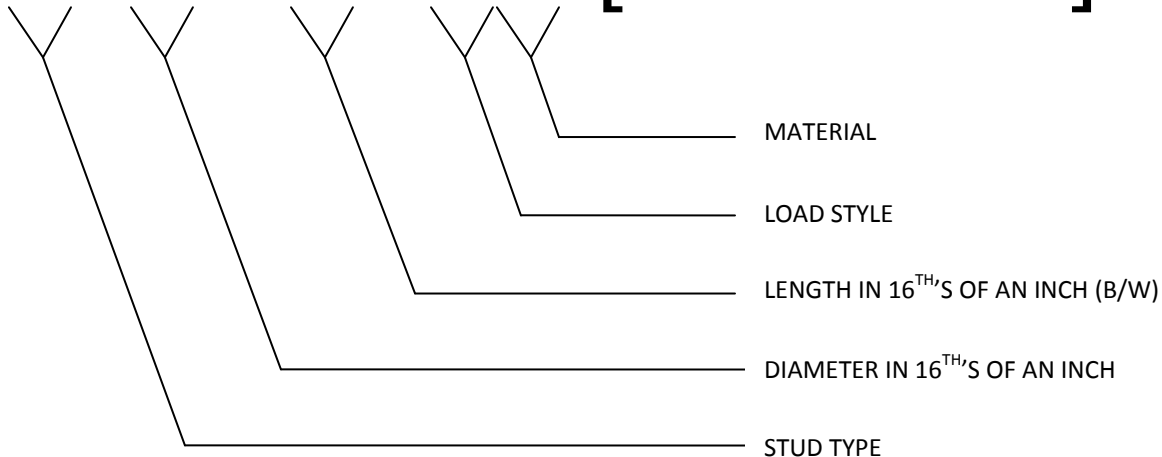
Our experienced Management and Staff is committed to provide the utmost in quality and service in every step of our production, while remaining competitive in the marketplace. It is our goal to meet our customer's needs more effectively than our competitors through a process of continuous quality improvement. Our long-standing relationship with our customers and suppliers is our key to continued success and growth. If we can be of any further assistance to you and your company, please do not hesitate to contact us.



TRU-WELD Stud Welding

TRU-WELD PART NUMBERS

CA08-098-11- [XX-XXX-X]



EXAMPLE (FROM ABOVE)
STUD TYPE – CONCRETE ANCHOR
DIAMETER – 1/2" (IN SIXTEENTH'S)
BEFORE WELD LENGTH – 6-1/8" (IN SIXTEENTH'S)
LOAD STYLE – BALL LOAD
MATERIAL – MILD STEEL (C1015)

STUD TYPE		LOAD STYLE		MATERIAL	
CODE	TYPE	CODE	TYPE	CODE	TYPE
CA	CONCRETE ANCHOR	0	NO LOAD	1	1010 thru 1020
CD	CAPACITOR DISCHARGE	1	BALL LOAD	2	302SS
CS	COLLAR STUD			3	ALUMINUM
DBA	DEFORMED BAR ANCHOR			4	304SS
DSC	DECKING SHEAR CONNECTOR			6	316SS
FER	FERRULE			8	1018
IT	INTERNAL TAP			9	430SS
NT	NO THREAD	PART NUMBER EXTENSIONS [XX-XXX-X] ARE RESERVED FOR STUDS THAT HAVE THREADED EXTENSIONS. APPLIES TO COLLAR STUDS, IT STUDS, SHOULDER STUDS, AND STACK STUDS. CD STUDS HAVE A 3 DIGIT EXTENSION ON END (INSTEAD OF 2) DENOTING FLANGED/NON-FLANGE, TIP, AND MATERIAL. LONE CHARACTER ON END DESIGNATES SPECIAL MARKING ON HEAD OR SPECIAL PACKAGING (I.E. IN CANS). "C" OR "F" ON END OF THREADED STUDS DESIGNATES UNC (COURSE) OR UNF (FINE) THREAD.			
PSR	PUNCHING SHEAR RESISTOR				
SC	SHEAR CONNECTOR				
TP	PARTIAL THREAD				
TR	THREADED – REDUCED WELD BASE				
TT	FULL THREAD				

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<http://www.weldstud.com>



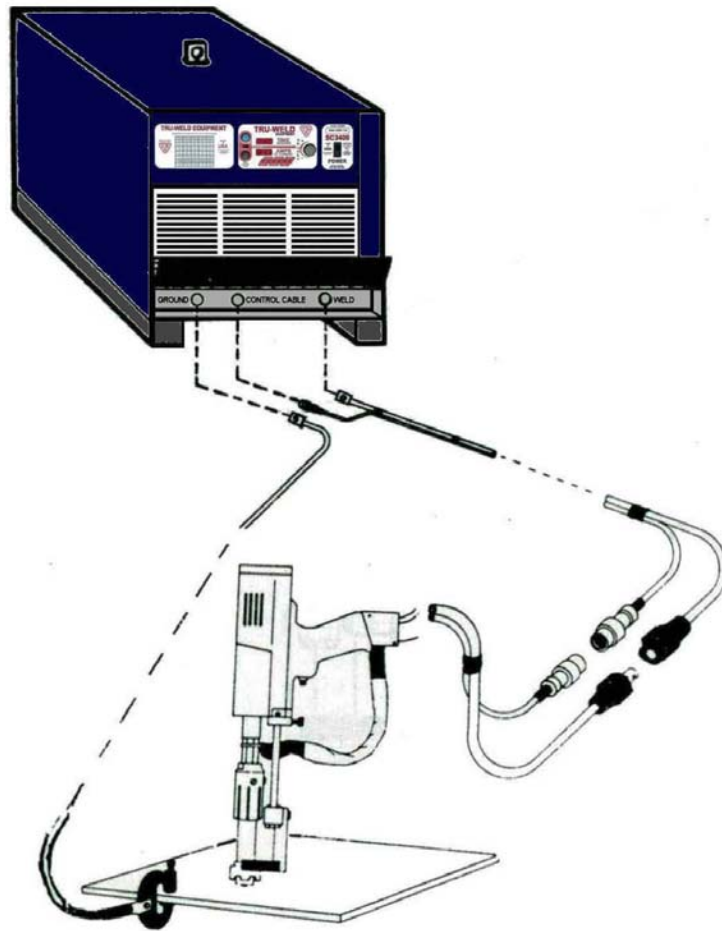
TRU-WELD *Stud Welding*

Transposition Chart

STUD DESCRIPTION	TRU-WELD TYPE	NELSON TYPE	ERICO/KSM TYPE	SWA TYPE
THREADED (PITCH DIAMETER, WELD BASE)	TP	CPL	PDB	PT
FULLY THREADED	TT	CFL	PD	FT
THREADED (REDUCED WELD BASE)	TR	CDL	RB	RB
NO THREAD	NT	NBL	SWP	NT
SHOULDER	S	SBL	SB	SB
COLLAR	CS	CKL	CL	CK
TAPPED	IT	TBL	FBP	TF
CONCRETE ANCHOR	CA	H-4L	HCA	HA
SHEAR CONNECTOR	SC	S-3L	SC	SC
CAPACITOR DISCHARGE	CD	ATA ATC ATS	CD	CD
DEFORMED BAR ANCHOR	DBA	D2L	DBA	DA
PSR STUDS	PSR	PSR		
THRU-DECK SHEAR CONNECTOR	DSC			



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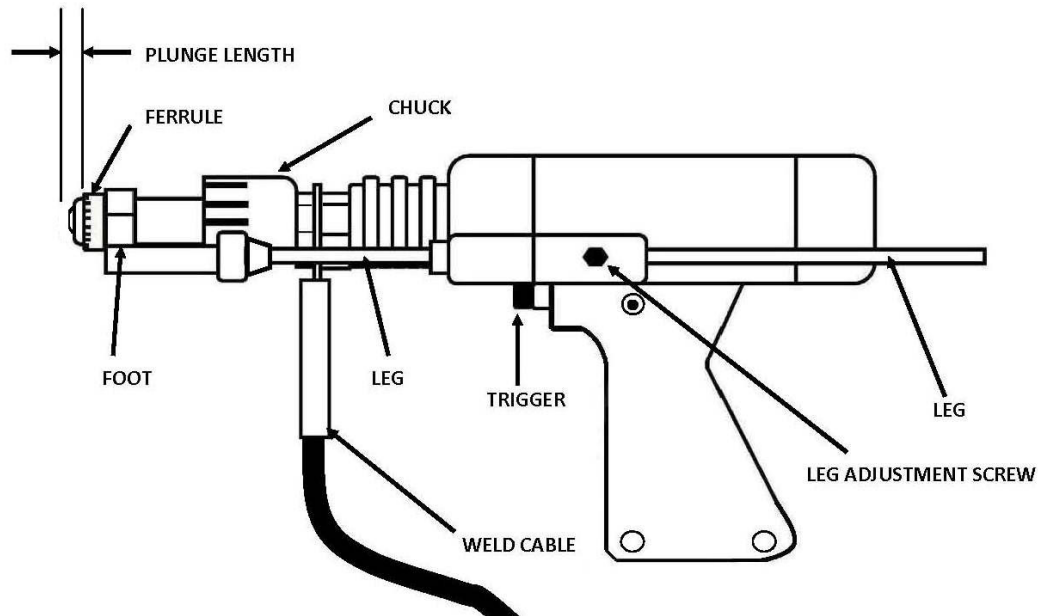


The typical power source for stud welding should have a constant current, open circuit voltage range of 70-100 VDC, rapid current rise time, and high current output for relatively short time periods. The control circuit of an arc stud welding system regulates arc duration throughout the welding cycle and provides adjustable controls for various stud diameters. The control circuit consists of a contactor, timing device, and current control. The weld time is a percentage of seconds or milliseconds, and the current is typically depicted as amperage. Weld time is determined by stud diameter.



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TRU-WELD ARC Stud Gun



The weld stud gun consists of the body, trigger, and lift mechanism. Stud gun accessories consist of the chuck or fastener holder, and an adjustable support leg for the ferrule holder (grip). The chuck and ferrule holder are easily changed to accommodate the various diameters of studs and ferrules to be used. An adjustment for the lift of the fastener is provided on the stud gun.

The portable, pistol grip design weld gun is offered in 3 capacities;

- 1) Light Duty (Stud diameters - 1/8 to 3/8)
- 2) Standard Duty (Stud diameters - 1/8 to 5/8)
- 3) Heavy Duty (Stud diameters – 1/8 to 1-1/4)

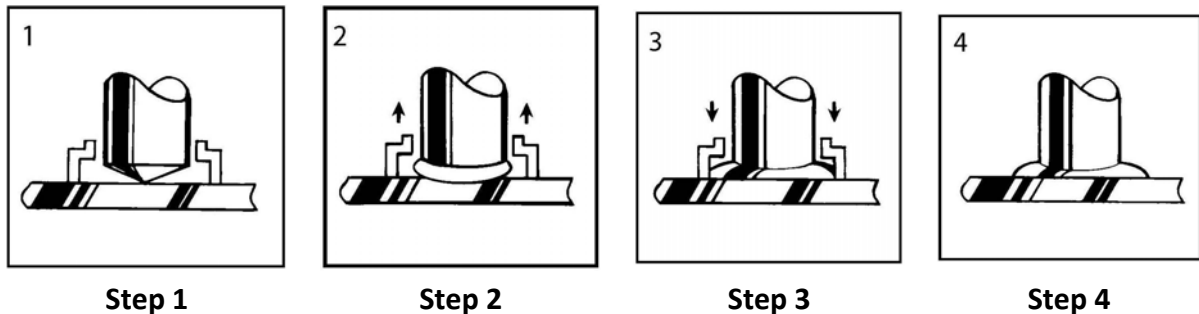


TRU-WELD *Stud Welding*

THE STUD WELDING PROCESS

Drawn Arc Stud Welding

Drawn Arc Stud Welding is generally used to weld large diameter fasteners to rougher and thicker base metals. Arc studs may be almost any shape and there are literally hundreds, however, they must have one end of the fastener designed for arc welding. Mild steel, stainless steel, and aluminum are applicable materials for arc stud welding.



- 1) The weld gun is positioned over the base material and the main gun spring is partially compressed.
- 2) The trigger is pressed and the stud lifts off the base, drawing an arc. The arc melts the end of the weld stud and the base material below. The arc shield (ferrule) concentrates the heat below the weld stud and contains the molten metal within the weld zone.
- 3) The main spring plunges the weld stud down into the molten pool of metal in the base material. The cycle is completed in less than a second and the resulting weld bond develops the full strength of the fastener in the weld zone.
- 4) The weld gun is withdrawn from the weld stud leaving and the ferrule. The ferrule is broken away and discarded.

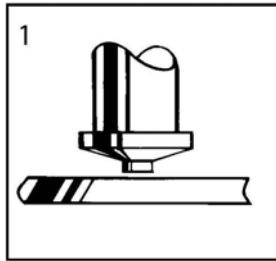


TRU-WELD *Stud Welding*

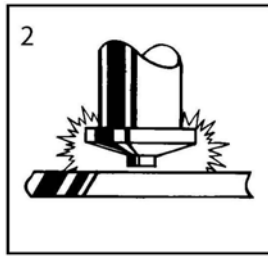
THE STUD WELDING PROCESS

Capacitor Discharge Stud Welding

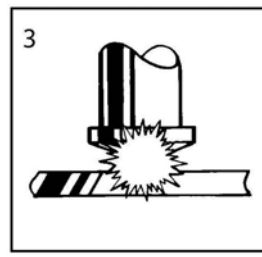
Capacitor Discharge (CD) stud welding is generally used to weld smaller diameter fasteners to thin base metals. Since the entire weld cycle is completed in milliseconds, welds can be made without pronounced distortion, burn-through or reverse side discoloration. As long as one end of the fastener is designed for CD welding, CD studs can be manufactured in almost any shape.



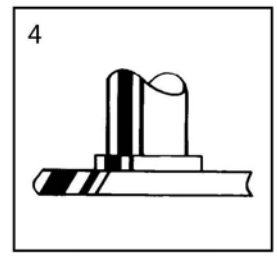
Step 1



Step 2



Step 3



Step 4

- 1) The weld gun and stud is positioned against the work plate. No ferrule is needed.
- 2) Stored energy discharged through special weld "timing" tip and the stud starts downward.
- 3) The stud is forced downward into the pool of molten metal.
- 4) Metal solidifies and weld is completed in a split second.



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STUD WELDING GUIDELINES

- Keep weld studs and ferrules clean and dry.
- Set the time for the appropriate weld base diameter (see chart below).
- Set the amperage for the appropriate weld base diameter (see chart below).
- Make sure the negative polarity is to the weld stud gun and ensure a good, clean ground connection.
- Align accessories so they are centered and adjust legs so that 1/8" to 1/4" of the stud protrudes beyond the ferrule.
- Make sure work surface is relatively clean so impurities do not affect weld.
- Test the welds at the beginning of each shift or change in stud. Bend two studs 30 degrees after cooling (AWS Bend Test).
- Check burn off (1/8" – 1/4"), color (silver blue and shiny), and weld fillet (360 degree).
- Visually inspect all welds.

STUD DIAMETER	TIME (Seconds)	CURRENT (Amps)
1/4	.20 - .25	350 – 450
5/16	.25 - .30	450 – 600
3/8	.33 - .40	525 – 700
7/16	.40 - .45	675 – 750
1/2	.50 - .55	750 – 925
5/8	.65 - .70	1100 – 1400
3/4	.85 - .90	1450 – 1750
7/8 (+)	1.00 – 1.20	1700 – 1950

STUD DIAMETER	STICK OUT
3/16 thru 1/2	1/8
5/8 thru 7/8	3/16
1" and over	3/16 – 1/4



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Concrete Anchor - Shipping Weight Chart

Stud Diameter	Stud Length	Lbs. Per 1000	Pieces Per Box	Pounds Per Box	Pieces Per Pallet	Pounds Per Pallet
1/4	1-1/8	22	2,000	47	54,000	1,269
	2-11/16	43	1,000	43	27,000	1,161
	3-1/8	49	1,000	49	27,000	1,323
	4-1/8	63	600	38	16,200	1,026
3/8	1-1/4	67	1,000	67	27,000	1,809
	1-3/8	70	1,000	70	27,000	1,890
	1-5/8	79	1,000	79	27,000	2,133
	2-1/8	93	700	65	18,900	1,758
	2-5/8	108	600	64	16,200	1,728
	3-1/8	124	500	62	13,500	1,674
	4-1/8	154	350	54	9,450	1,458
	5-1/8	183	300	55	8,100	1,485
	6-1/8	215	200	43	5,400	1,161
	8-1/8	280	125	35	3,375	945
1/2	1-1/8	113	600	68	16,200	1,836
	1-3/8	130	500	65	13,500	1,755
	1-1/2	136	500	68	13,500	1,836
	1-5/8	140	450	63	12,150	1,701
	2-1/8	167	400	67	10,800	1,809
	2-5/8	194	350	68	9,450	1,836
	3-1/8	227	300	68	8,100	1,836
	3-5/8	250	200	50	5,400	1,350
	4-1/8	280	200	56	5,400	1,512
	4-5/8	315	200	63	5,400	1,701
	5-1/8	333	150	50	4,050	1,350
	5-5/16	347	150	52	4,050	1,404
	6-1/8	400	125	50	3,375	1,350
	8-1/8	500	80	40	2,160	1,080
	1-7/16	203	400	81	10,800	2,187
5/8	1-11/16	237	325	77	8,775	2,079
	2-1/8	264	250	68	6,750	1,836
	2-3/16	284	250	71	6,750	1,917
	2-11/16	308	250	77	6,750	2,079
	3-3/16	350	200	70	5,400	1,890
	3-11/16	400	150	60	4,050	1,620
	4-3/16	440	150	66	4,050	1,782
	4-11/16	480	125	60	3,375	1,620
	5-3/16	530	100	53	2,700	1,431
	6-3/16	611	90	55	2,430	1,485
	6-9/16	650	80	52	2,160	1,404
	8-3/16	780	50	39	1,350	1,053
	10-3/16	970	100	97	900	873
	12-3/16	1,129	1,500	1,694	1,500	1,694

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Shear Connector - Shipping Weight Chart

Stud Diameter	Stud Length	Pounds Per 1000 Pieces	Pieces Per Box	Pounds Per Box	Pieces Per Pallet	Pounds Per Pallet
3/4	2-20	355	200	71	9,600	3,408
	2-11/16	420	150	63	7,200	3,024
	3-3/16	480	125	60	6,000	2,880
	3-3/8	504	125	63	6,000	3,024
	3-11/16	540	100	54	4,800	2,592
	3-7/8	570	100	57	4,800	2,736
	4-3/16	600	100	60	4,800	2,880
	4-3/8	620	100	62	4,800	2,976
	4-11/16	667	75	50	3,600	2,400
	4-7/8	693	75	52	3,600	2,496
	5-3/16	734	60	44	2,880	2,112
	5-3/8	750	60	45	2,880	2,160
	5-11/16	800	60	48	2,880	2,304
	5-7/8	817	60	49	2,880	2,352
	6-3/16	850	60	51	2,880	2,448
	6-3/8	884	60	53	2,880	2,544
	6-11/16	914	70	64	1,890	1,728
	7-3/16	983	60	59	1,620	1,593
	8-3/16	1,080	50	54	1,350	1,458
	9-3/16	1,230	100	123	900	1,107
	10-3/16	1,370	100	137	900	1,233
7/8	3-3/16	630	100	63	2,700	1,701
	3-11/16	740	100	74	2,700	1,998
	4-3/16	800	75	60	2,025	1,620
	4-11/16	878	80	71	2,160	1,917
	5-3/16	1,000	60	60	1,620	1,620
	5-11/16	1,050	60	63	1,620	1,701
	6-3/16	1,160	50	58	1,350	1,566
	6-11/16	1,240	50	62	1,350	1,674
	7-3/16	1,311	45	59	1,215	1,593
	8-3/16	1,475	40	59	1,080	1,593
	9-3/16	1,667	1,400	2,334	1,400	2,334
	10-3/16	1,800	1,000	1,800	1,000	1,800
1	3-1/4	894	75	67	2,025	1,809
	4-1/4	1,140	50	57	1,350	1,539
	5-1/4	1,340	50	67	1,350	1,809
	6-1/4	1,575	40	63	1,080	1,701
	7-1/4	1,800	40	72	1,080	1,944
	8-1/4	2,012	85	171	765	1,539
	9-1/4	2,240	50	112	450	1,008

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Estimated Weights for Threaded Studs In Pounds Per 1000 Pieces

Length	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	7/8"
3/4	8.3	12.8	18.8	25.5	34.5			
1	11.0	17.0	25.0	34.0	46.0	70.0		
1-1/4	13.8	21.3	31.3	42.5	57.5	87.5	133.8	
1-1/2	16.5	25.5	37.5	51.0	69.0	105.0	160.5	243.8
1-3/4	19.3	29.8	43.8	59.5	80.5	122.5	187.3	284.4
2	22.0	34.0	50.0	68.0	92.0	140.0	214.0	325.0
2-1/4	24.8	38.3	56.3	76.5	103.5	157.5	240.8	365.6
2-1/2	27.5	42.5	62.5	85.0	115.0	175.0	267.5	406.3
2-3/4	30.3	46.8	68.8	93.5	126.5	192.5	294.3	446.9
3	33.0	51.0	75.0	102.0	138.0	210.0	321.0	487.5
3-1/4	35.8	55.3	81.3	110.5	149.5	227.5	347.8	528.1
3-1/2	38.5	59.5	87.5	119.0	161.0	245.0	374.5	568.8
3-3/4	41.3	63.8	93.8	127.5	172.5	262.5	401.3	609.4
4	44.0	68.0	100.0	136.0	184.0	280.0	428.0	650.0
4-1/4	46.8	72.3	106.3	144.5	195.5	297.5	454.8	690.6
4-1/2	49.5	76.5	112.5	153.0	207.0	315.0	481.5	731.3
4-3/4	52.3	80.8	118.8	161.5	218.5	332.5	508.3	771.9
5	55.0	85.0	125.0	170.0	230.0	350.0	535.0	812.5

Estimated Weights of No Thread Studs in Pounds Per 1000 Pieces

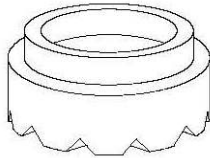
Length	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	7/8"
3/4	6.0	10.5	16.4	23.5	31.9	41.7			
1	8.0	14.0	21.8	31.3	42.5	55.6	86.6		
1-1/4	10.0	17.5	27.3	39.1	53.1	69.5	108.3	156.0	
1-1/2	12.0	21.0	32.7	47.0	63.8	83.4	129.9	187.2	254.0
1-3/4	14.0	24.5	38.2	54.8	74.4	97.3	151.6	218.4	297.5
2	16.0	28.0	43.6	62.6	85.0	111.2	173.2	249.6	340.0
2-1/4	18.0	31.5	49.1	70.4	95.6	125.1	194.9	280.8	382.5
2-1/2	20.0	35.0	54.5	78.3	106.3	139.0	216.5	312.0	425.0
2-3/4	22.0	38.5	60.0	86.1	116.9	152.9	238.2	343.2	467.5
3	24.0	42.0	65.4	93.9	127.5	166.8	259.8	374.4	510.0
3-1/4	26.0	45.5	70.9	101.7	138.1	180.7	281.5	405.6	552.5
3-1/2	28.0	49.0	76.3	117.4	148.8	194.7	303.1	436.8	595.0
3-3/4	30.0	52.5	81.8	125.2	159.4	208.5	324.8	468.0	637.5
4	32.0	56.0	87.2	128.6	170.0	222.4	346.4	499.2	680.0
4-1/4	34.0	59.5	92.7	133.0	180.6	236.3	368.1	530.4	722.5
4-1/2	36.0	63.0	98.1	140.9	191.3	250.2	389.7	561.6	765.0
4-3/4	38.0	66.5	103.6	148.7	201.9	264.1	411.4	592.8	807.5
5	40.0	70.0	109.0	156.5	212.5	278.0	433.0	624.0	850.0



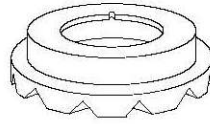
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STANDARD FERRULES

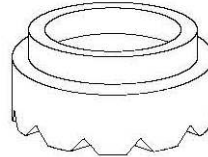
SUPPLIED WITH TRU-WELD STUDS



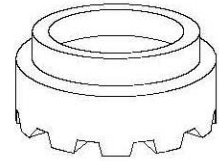
F₁
(Standard Duty)



C
(Collar Stud)



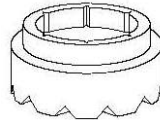
FHD
(Heavy Duty)



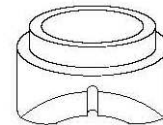
TD
(Thru Deck)



P
(Pitch Diameter Stud)



R
(Reduced Base)



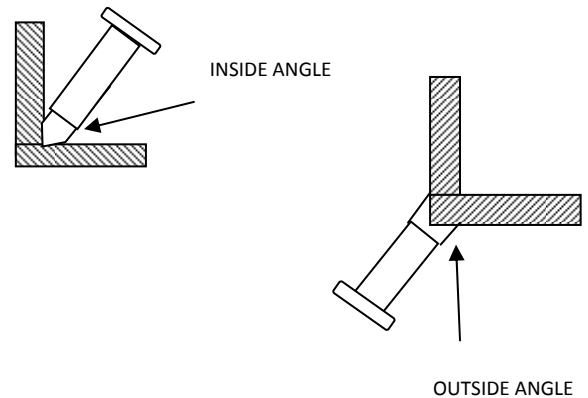
A₂
(Angle Ferrule)

THE TRU-WELD FERRULE (ARC SHIELD) IS SPECIALLY DESIGNED TO WITHSTAND HEAT SHOCK AS WELL AS REASONABLY HIGH TEMPERATURES WITHOUT MELTING OR BREAKING. THE TRU-WELD FERRULE COMPLIMENTS THE UNIFORM FLUX LOAD TO AFFECT A TOP QUALITY WELD.

SPECIAL FERRULES ARE ALSO AVAILABLE UPON REQUEST.

1) THE "F" FERRULE IS ALSO AVAILABLE IN THE LOW PROFILE VERSIONS.

2) THE "A" FERRULE PICTURED ABOVE IS THE COMBINATION INSIDE-OUTSIDE ANGLE FERRULE. THE INSIDE-ONLY AND OUTSIDE-ONLY FERRULES ARE ALSO STANDARD STOCK ITEMS.





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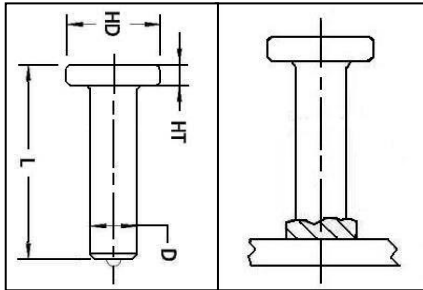
STANDARD FERRULES

TYPE	NOMINAL SIZE	TRU-WELD PART NUMBER	D	H	G	E	
F	3/16	FER03-F	.390	.390 or .250	.281	.156	
	1/4	FER04-F	.455	.390 or .250	.380	.156	
	5/16	FER05-F	.578	.390	.445	.156	
	3/8	FER06-F	.640	.390	.505	.156	
	7/16	FER07-F	.703	.422	.585	.188	
	1/2	FER08-F	.795	.438	.650	.188	
	5/8	FER10-F	1.030	.516	.785	.188	
	3/4	FER12-F	1.218	.656	1.030	.188	
	7/8	FER14-F	1.406	.732	1.210	.188	
FHD	1	FER16-F	1.610	.820	1.406	.188	
	1/4	FER04-FHD	.645	.390	.515	.150	
	3/8	FER06-FHD	.800	.400	.645	.150	
	1/2	FER08-FHD	.875	.455	.785	.185	
C	5/8	FER10-FHD	1.230	.520	1.035	.185	
	1/4	FER04-C	.875	.250	.785	.125	
	5/16	FER05-C	.875	.250	.785	.125	
	3/8	FER06-C	.875	.250	.785	.125	
P	1/2	FER08-C	1.203	.281	1.045	.156	
	1/4	FER04-P	.455	.250	.380	.125	
	5/16	FER05-P	.535	.250	.445	.125	
	3/8	FER06-P	.595	.265	.505	.125	
	7/16	FER07-P	.675	.329	.585	.156	
	1/2	FER08-P	.740	.362	.650	.156	
	5/8	FER10-P	.905	.433	.785	.156	
	3/4	FER12-P	1.150	.526	1.030	.187	
R	7/8	FER14-P	1.330	.593	1.203	.187	
	1	FER16-P	1.526	.661	1.406	.187	
	3/8	FER06-R	.595	.250	.505	.125	
	7/16	FER07-R	.675	.250	.585	.125	
	1/2	FER08-R	.740	.281	.650	.156	
TD	5/8	FER10-R	.875	.281	.785	.156	
	3/4	FER12-R	1.030	.375	.921	.187	
	1/2	FER08-TD	.800	.450	.645	.185	
	5/8	FER10-TD	1.015	.525	.775	.185	
A	3/4	FER12-TD	1.335	.600	1.210	.185	
	7/8	FER14-TD	1.528	.666	1.406	.200	
	1/4	FER04-A	.455	.500	.380	.156	
	3/8	FER06-A	.640	.480	.505	.156	
A	1/2	FER08-A	.795	.688	.650	.188	
	5/8	FER10-A	1.030	.875	.785	.188	
	3/4	FER12-A	1.218	.875	1.030	.188	



TRU-WELD Stud Welding

HEADED CONCRETE ANCHOR – FULL WELD BASE



TYPE **CA** STUD
TYPE F FERRULE SUPPLIED

Head Diameter (HD) – 1/2" for all 1/4" Headed Concrete Anchors.
Head Height (HT) – 3/16" for all 1/4" Headed Concrete Anchors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
1/4	1-1/8	CA04-018-11	2,000	27	54,000	47 lbs.	1,269 lbs.	22 lbs.
1/4	2-11/16	CA04-043-11	1,000	27	27,000	43 lbs.	1,161 lbs.	43 lbs.
1/4	3-1/8	CA04-050-11	1,000	27	27,000	49 lbs.	1,323 lbs.	49 lbs.
1/4	4-1/8	CA04-066-11	600	27	16,200	38 lbs.	1,026 lbs.	63 lbs.

Concrete Anchors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 1/4" will be approx. 1/8" shorter after welding.

TRU-WELD concrete anchors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. CA Studs are also available in weldable stainless steel. Type 302 is the most commonly used. Other grades of stainless steel (except Type 303) are available when required.

Mechanical Property Requirements		
	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLAT (DUAL LEG)
CN-050	B-1C	GC-025 (Standard Duty)	QN-025 (Standard Duty)
	B-1C	GC-037 (Heavy Duty)	QN-037 (Heavy Duty)

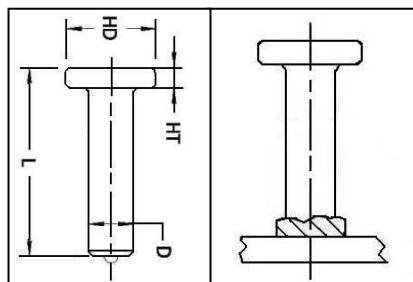
Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.



TRU-WELD Stud Welding

HEADED CONCRETE ANCHOR – FULL WELD BASE



TYPE **CA** STUD
TYPE F FERRULE SUPPLIED

Diameter (HD) – 3/4" for all 3/8" Headed Concrete Anchors.
Head Height (HT) – 9/32" for all 3/8" Headed Concrete Anchors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
3/8	1-3/8	CA06-022-11	1,000	27	27,000	70 lbs.	1,890 lbs.	70 lbs.
3/8	1-5/8	CA06-026-11	1,000	27	27,000	79 lbs.	2,133 lbs.	79 lbs.
3/8	2-1/8	CA06-034-11	700	27	18,900	65 lbs.	1,758 lbs.	93 lbs.
3/8	2-5/8	CA06-042-11	600	27	16,200	64 lbs.	1,728 lbs.	108 lbs.
3/8	3-1/8	CA06-050-11	500	27	13,500	62 lbs.	1,674 lbs.	124 lbs.
3/8	4-1/8	CA06-066-11	350	27	9,450	54 lbs.	1,458 lbs.	154 lbs.
3/8	5-1/8	CA06-082-11	300	27	8,100	55 lbs.	1,485 lbs.	183 lbs.
3/8	6-1/8	CA06-098-11	200	27	5,400	43 lbs.	1,161 lbs.	215 lbs.
3/8	8-1/8	CA06-130-11	125	27	3,375	35 lbs.	945 lbs.	280 lbs.

Concrete Anchors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 3/8" will be approx. 1/8" shorter after welding. TRU-WELD concrete anchors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. CA Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CH-037	B-1C	GC-037 (Standard Duty)	QN-037 (Standard Duty)
	B-1C	GC-050 (Heavy Duty)	QN-050 (Heavy Duty)

Mechanical Property Requirements		
	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

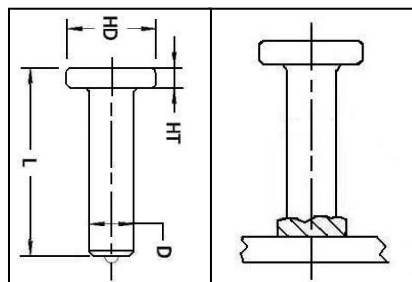
Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.



TRU-WELD Stud Welding

HEADED CONCRETE ANCHOR – FULL WELD BASE



TYPE **CA** STUD
TYPE F FERRULE SUPPLIED

Head Diameter (HD) – 1" for all 1/2" Headed Concrete Anchors.
Head Height (HT) – 5/16" for all 1/2" Headed Concrete Anchors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
1/2	1-1/8	CA08-018-11	600	27	16,200	68 lbs.	1,836 lbs.	112 lbs.
1/2	1-1/2	CA08-024-11	500	27	13,500	68 lbs.	1,836 lbs.	132 lbs.
1/2	1-5/8	CA08-026-11	450	27	12,150	63 lbs.	1,701 lbs.	140 lbs.
1/2	2-1/8	CA08-034-11	400	27	10,800	67 lbs.	1,809 lbs.	167 lbs.
1/2	2-5/8	CA08-042-11	350	27	9,450	68 lbs.	1,836 lbs.	194 lbs.
1/2	3-1/8	CA08-050-11	300	27	8,100	68 lbs.	1,836 lbs.	227 lbs.
1/2	4-1/8	CA08-066-11	200	27	5,400	56 lbs.	1,512 lbs.	280 lbs.
1/2	5-5/16	CA08-085-11	150	27	4,050	52 lbs.	1,404 lbs.	347 lbs.
1/2	6-1/8	CA08-098-11	125	27	3,375	50 lbs.	1,350 lbs.	400 lbs.
1/2	8-1/8	CA08-130-11	80	27	2,160	40 lbs.	1,080 lbs.	500 lbs.
1/2	10-1/8	CA08-162-11	150	9	1,350	91 lbs.	819 lbs.	606 lbs.
1/2	12-1/8	CA08-194-11	1,500	1	1,500	1,059 lbs.	1,059 lbs.	706 lbs.

Concrete Anchors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 1/2" will be approx. 1/8" shorter after welding. TRU-WELD concrete anchors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. CA Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CH-050	B-1C	GC-050 (Standard Duty)	QN-050 (Standard Duty)
	B-2C	GC-062 (Heavy Duty)	QN-062 (Heavy Duty)

Mechanical Property Requirements

	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

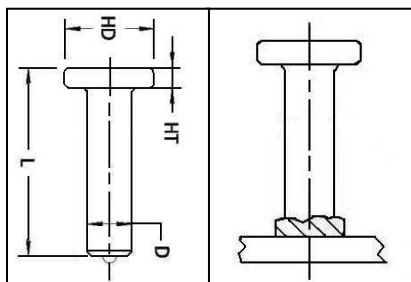
Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.



TRU-WELD Stud Welding

HEADED CONCRETE ANCHOR – FULL WELD BASE



TYPE **CA** STUD
TYPE F FERRULE SUPPLIED

Head Diameter (HD) – 1-1/4" for all 5/8" Headed Concrete Anchors.
Head Height (HT) – 5/16" for all 5/8" Headed Concrete Anchors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
5/8	1-7/16	CA10-023-11	400	27	10,800	81 lbs.	2,187 lbs.	203 lbs.
5/8	1-11/16	CA10-027-11	325	27	8,775	77 lbs.	2,079 lbs.	237 lbs.
5/8	2-1/8	CA10-034-11	250	27	6,750	68 lbs.	1,836 lbs.	264 lbs.
5/8	2-3/16	CA10-035-11	250	27	6,750	71 lbs.	1,917 lbs.	284 lbs.
5/8	2-11/16	CA10-043-11	250	27	6,750	77 lbs.	2,079 lbs.	308 lbs.
5/8	3-3/16	CA10-051-11	200	27	5,400	70 lbs.	1,890 lbs.	350 lbs.
5/8	3-11/16	CA10-059-11	150	27	4,050	60 lbs.	1,620 lbs.	400 lbs.
5/8	4-3/16	CA10-067-11	150	27	4,050	66 lbs.	1,782 lbs.	440 lbs.
5/8	4-11/16	CA10-075-11	125	27	3,375	60 lbs.	1,620 lbs.	480 lbs.

Concrete Anchors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 5/8" will be approx. 3/16" shorter after welding. TRU-WELD concrete anchors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. CA Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CH-075	B-2C	GC-062 (Standard Duty)	QN-062 (Standard Duty)
	B-2C	GC-075 (Heavy Duty)	QN-075 (Heavy Duty)

Mechanical Property Requirements

	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.

TFP Corporation/TRU-WELD
460 Lake Road
Medina, Ohio 44256

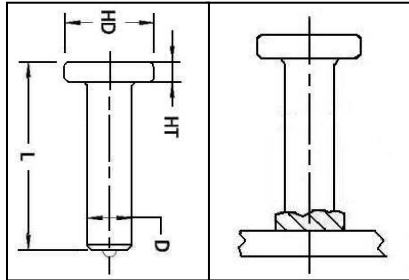
(330) 725-7741
(330) 725-0161 Fax
Sales@tfpcorp.com

<http://www.tfpcorp.com>
<http://www.truweldstudwelding.com>
<http://www.weldstud.com>



TRU-WELD Stud Welding

HEADED CONCRETE ANCHOR – FULL WELD BASE



TYPE **CA** STUD
TYPE F FERRULE SUPPLIED

Head Diameter (HD) – 1-1/4" for all 5/8" Headed Concrete Anchors.
Head Height (HT) – 5/16" for all 5/8" Headed Concrete Anchors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
5/8	5-3/16	CA10-083-11	100	27	2,700	53 lbs.	1,485 lbs.	530 lbs.
5/8	6-3/16	CA10-099-11	90	27	2,430	55 lbs.	1,485 lbs.	611 lbs.
5/8	6-9/16	CA10-105-11	80	27	2,160	52 lbs.	1,404 lbs.	650 lbs.
5/8	8-3/16	CA10-131-11	50	27	1350	39 lbs.	1080 lbs.	780 lbs.
5/8	9-3/16	CA10-147-11	125	9	1125	109 lbs.	981 lbs.	872 lbs.
5/8	10-3/16	CA10-16311	100	9	900	97 lbs.	882 lbs.	970 lbs.
5/8	12-3/16	CA10-19511	1500	1	1500	1694 lbs.	1694 lbs.	1129 lbs.

Concrete Anchors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 5/8" will be approx. 3/16" shorter after welding. TRU-WELD concrete anchors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. CA Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CH-075	B-2C	GC-062 (Standard Duty)	QN-062 (Standard Duty)
	B-2C	GC-075 (Heavy Duty)	QN-075 (Heavy Duty)

Mechanical Property Requirements		
	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.



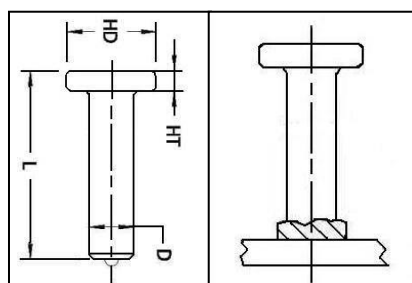
TRU-WELD Stud Welding

SHEAR CONNECTOR – FULL WELD BASE

(3/4" THRU DECK SHEAR CONNECTORS ON NEXT PAGE)

TYPE **SC** STUD

TYPE F FERRULE SUPPLIED



Head Diameter (HD) – 1-1/4" for all 3/4 headed Shear Connectors.

Head Height (HT) – 3/8" for all 3/4 headed Shear Connectors.

D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
3/4	2-20	SC12-036-11	200	48	9,600	71 lbs.	3,408 lbs.	355 lbs.
3/4	3-3/16	SC12-051-11	125	48	6,000	60 lbs.	2,880 lbs.	480 lbs.
3/4	3-11/16	SC12-059-11	100	48	4,800	54 lbs.	2,592 lbs.	540 lbs.
3/4	4-3/16	SC12-067-11	100	48	4,800	60 lbs.	2,880 lbs.	600 lbs.
3/4	4-11/16	SC12-075-11	75	48	3,600	50 lbs.	2,400 lbs.	667 lbs.
3/4	5-3/16	SC12-083-11	60	48	2,880	44 lbs.	2,112 lbs.	734 lbs.
3/4	5-11/16	SC12-091-11	60	48	2,880	48 lbs.	2,304 lbs.	800 lbs.
3/4	6-3/16	SC12-099-11	60	48	2,880	51 lbs.	2,448 lbs.	850 lbs.
3/4	6-11/16	SC12-107-11	70	27	1,890	64 lbs.	1,728 lbs.	914 lbs.
3/4	7-3/16	SC12-115-11	60	27	1,620	59 lbs.	1,593 lbs.	983 lbs.
3/4	8-3/16	SC12-131-11	50	27	1,350	54 lbs.	1,458 lbs.	1,080 lbs.
3/4	9-3/16	SC12-147-11	100	9	900	123 lbs.	1,107 lbs.	1,230 lbs.
3/4	10-3/16	SC12-163-11	100	9	900	137 lbs.	1,233 lbs.	1,370 lbs.
3/4	12-3/16	SC12-195-11	1,000	1	1,000	1,590 lbs.	1,590 lbs.	1,590 lbs.
3/4	16-3/16	SC12-259-11	700	1	700	1,457 lbs.	1,457 lbs.	2,081 lbs.

Shear Connectors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 3/4" will be approx. 3/16" shorter after weld.

TRU-WELD shear connectors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. SC Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

Mechanical Property Requirements

	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CH-075	B-2C	GC-075	QN-075

TFP Corporation/TRU-WELD
460 Lake Road
Medina, Ohio 44256

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Sales@tfpcorp.com

<http://www.tfpcorp.com>
<http://www.truweldstudwelding.com>
<http://www.weldstud.com>

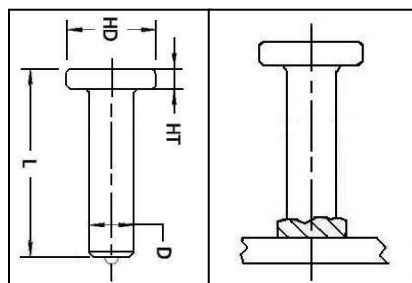


TRU-WELD Stud Welding

THRU-DECK SHEAR CONNECTOR

TYPE **DSC** STUD

TYPE **F** FERRULE SUPPLIED



Head Diameter (HD) – 1-1/4" for all 3/4" Thru-Deck Shear Connectors.
Head Height (HT) – 3/8" for all 3/4" Thru-Deck Shear Connectors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
3/4	3-3/8	DSC12-054-11	125	48	6,000	63 lbs.	3,024 lbs.	504 lbs.
3/4	3-7/8	DSC12-062-11	100	48	4,800	57 lbs.	2,736 lbs.	570 lbs.
3/4	4-3/8	DSC12-070-11	100	48	4,800	62 lbs.	2,976 lbs.	620 lbs.
3/4	4-7/8	DSC12-078-11	75	48	3,600	52 lbs.	2,496 lbs.	693 lbs.
3/4	5-3/8	DSC12-086-11	60	48	2,880	45 lbs.	2,160 lbs.	750 lbs.
3/4	5-7/8	DSC12-094-11	60	48	2,880	49 lbs.	2,352 lbs.	817 lbs.
3/4	6-3/8	DSC12-102-11	60	48	2,880	53 lbs.	2,544 lbs.	884 lbs.

Thru-Deck Shear Connectors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 3/4" will be approx. 3/8" shorter after weld.

TRU-WELD thru-deck shear connectors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. DSC Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

CHUCK PART #	THRU-DECK FOOT ASSEMBLY	THRU-DECK FERRULE GRIP
CH-075	B-0021-1A	B-0060-1
	B-0021-1P	

Mechanical Property Requirements

	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

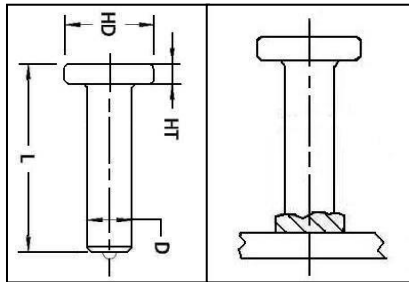
Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.



TRU-WELD Stud Welding

SHEAR CONNECTOR – FULL WELD BASE



TYPE **SC** STUD
TYPE F FERRULE SUPPLIED

Head Diameter (HD) – 1-3/8" for all 7/8" Shear Connectors.
Head Height (HT) – 3/8" for all 7/8" Shear Connectors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
7/8	3-3/16	SC14-051-11	100	27	2,700	66 lbs.	1,782 lbs.	631 lbs.
7/8	3-11/16	SC14-059-11	100	27	2,700	74 lbs.	1,998 lbs.	709 lbs.
7/8	4-3/16	SC14-067-11	75	27	2,025	60 lbs.	1,620 lbs.	796 lbs.
7/8	5-3/16	SC14-083-11	60	27	1,620	60 lbs.	1,620 lbs.	962 lbs.
7/8	6-3/16	SC14-099-11	50	27	1,350	58 lbs.	1,566 lbs.	1,137 lbs.
7/8	7-3/16	SC14-115-11	45	27	1,215	59 lbs.	1,593 lbs.	1,306 lbs.
7/8	8-3/16	SC14-131-11	40	27	1,080	59 lbs.	1,593 lbs.	1,496 lbs.
7/8	9-3/16	SC14-147-11	1,400	1	1,400	2,334 lbs.	2,334 lbs.	1,667 lbs.
7/8	10-3/16	SC14-163-11	1,000	1	1,000	1,800 lbs.	1,800 lbs.	1,800 lbs.
7/8	12-3/16	SC14-195-11	800	1	800	1,702 lbs.	1,702 lbs.	2,173 lbs.

Shear Connectors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 7/8" will be approx. 3/16" shorter after weld.

TRU-WELD shear connectors can be made in any length above the standard minimum.

Material: Low carbon steel, (ASTM A108 / A29, AASHTO M169) 1010-1020. SC Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

****Tru-Weld shear connectors are manufactured to conform to:** AWS D1.1, AWS D1.5, AWS D1.6, AASHTO, ISO-13918, CSA W59-2013. ******

See Also: ICC-ES Evaluation Report ESR-2577

Mechanical Property Requirements

	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CH-087	B-3C	GC-087	QN-087

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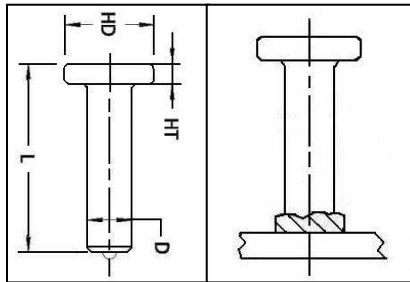
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TRU-WELD Stud Welding

SHEAR CONNECTOR – FULL WELD BASE



TYPE **SC** STUD
TYPE F FERRULE SUPPLIED

Head Diameter (HD) – 1-5/8" for all 1" Shear Connectors.
Head Height (HT) – 1/2" for all 1" Shear Connectors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
1"	3-1/4	SC16-052-11	75	27	2,025	70 lbs.	1,809 lbs.	894 lbs.
1"	4-1/4	SC16-068-11	50	27	1,350	57 lbs.	1,539 lbs.	1,140 lbs.
1"	5-1/4	SC16-084-11	50	27	1,350	67 lbs.	1,809 lbs.	1,340 lbs.
1"	6-1/4	SC16-100-11	40	27	1,080	63 lbs.	1,701 lbs.	1,575 lbs.
1"	7-1/4	SC16-116-11	40	27	1,080	72 lbs.	1,944 lbs.	1,800 lbs.
1"	8-1/4	SC16-132-11	85	9	765	171 lbs.	1,539 lbs.	2,012 lbs.
1"	9-1/4	SC16-148-11	50	9	450	112 lbs.	1,008 lbs.	2,240 lbs.

Shear Connectors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 1" will be approx. 1/4" shorter after weld.

TRU-WELD shear connectors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. SC Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CH-100	B-3C	GC-100	QN-100

Mechanical Property Requirements

	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

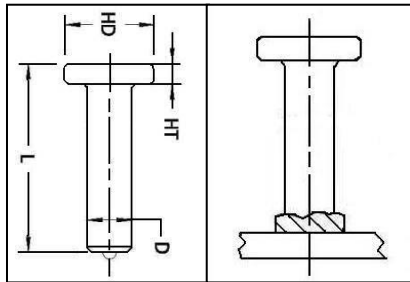
Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.



TRU-WELD Stud Welding

SHEAR CONNECTOR – FULL WELD BASE



TYPE **SC** STUD
TYPE F FERRULE SUPPLIED

Head Diameter (HD) – 1-5/8" for all 1" Shear Connectors.
Head Height (HT) – 1/2" for all 1" Shear Connectors.

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
1"	10-1/4	SC16-164-11	50	9	450	124 lbs.	1,116 lbs.	2,480 lbs.
1"	12-1/4	SC16-196-11	700	1	700	2,011 lbs.	2,011 lbs.	2,873 lbs.
1"	14-1/4	SC16-228-11	700	1	700	2,328 lbs.	2,328 lbs.	3,325 lbs.
1"	16-1/4	SC16-260-11	500	1	500	1,903 lbs.	1,903 lbs.	3,806 lbs.
1"	18-1/4	SC16-292-11	600	1	600	2,284 lbs.	2,284 lbs.	3,806 lbs.

Shear Connectors are used in all types of concrete connections. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 1" will be approx. 1/4" shorter after weld.

TRU-WELD shear connectors can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. SC Studs are also available in weldable stainless steel. Type 302 is the most commonly used.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CH-100	B-3C	GC-100	QN-100

Mechanical Property Requirements

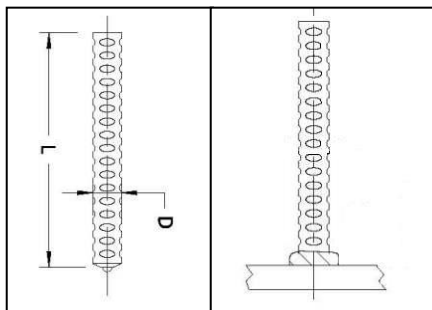
	Type A	Type B
Tensile Strength	61,000 psi min.	65,000 psi min.
Yield Strength	49,000 psi min.	51,000 psi min.
Elongation (% in 2 in.)	17% min.	20% min.
Elongation (% in 5x dia.)	14% min.	15% min.
Reduction of Area	50% min.	50% min.

Type A Studs are general purpose studs.

Type B Studs are headed, bent, or of other configuration that are used as an essential component in composite beam design and construction.



TRU-WELD Stud Welding



DEFORMED BAR ANCHORS

TYPE DBA STUD
NO THREAD – FULL WELD BASE
TYPE F FERRULE SUPPLIED

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
3/8	10-1/8	DBA06-162-18	150	18	2,700	46 lbs.	828 lbs.	288 lbs.
3/8	12-1/8	DBA06-194-18	150	18	2,700	55 lbs.	990 lbs.	345 lbs.
3/8	18-1/8	DBA06-290-18	150	12	1,800	80 lbs.	960 lbs.	515 lbs.
3/8	24-1/8	DBA06-386-18	150	8	1,200	108 lbs.	864 lbs.	685 lbs.
3/8	30-1/8	DBA06-482-18	150	7	1,050	130 lbs.	910 lbs.	897 lbs.
3/8	36-1/8	DBA06-578-18	150	6	900	156 lbs.	936 lbs.	1,047 lbs.
3/8	48-1/8	DBA06-770-18	150	6	900	208 lbs.	1,248 lbs.	1,394 lbs.

Deformed Bar Anchors are designed for weld and bearing plates in concrete connections.

Length: Length is listed before weld. Stud diameters 3/8" and below will be approx. 1/8" shorter after welding.

TRU-WELD Deformed Bar Anchors can be made in any length above the standard minimum.

Material: Low carbon steel ASTM A496 / A1064

Mechanical Property Requirements

	Type C
Tensile Strength	80,000 psi min. (552 MPa)
Yield Strength (0.5% offset)	70,000 psi min. (485 MPa)

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CN-037	B-1C	GC-037 (Standard Duty)	QN-037 (Standard Duty)
	B-1C	GC-050 (Heavy Duty)	QN-050 (Heavy Duty)

Type "C" Studs are cold-worked deformed steel bars manufactured in accordance with specification ASTM A496 having a nominal diameter equivalent to the diameter of a plain wire having the same weight per foot as the deformed wire. ASTM A496 specifies a maximum diameter of 0.628 in. (16mm). Any bar supplied above that diameter must have the same physical characteristics regarding deformations as required by ASTM A496.

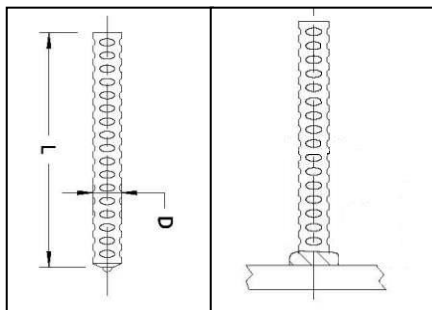
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TRU-WELD Stud Welding



DEFORMED BAR ANCHORS

TYPE DBA STUD
NO THREAD – FULL WELD BASE
TYPE F FERRULE SUPPLIED

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
1/2	8-1/8	DBA08-130-18	100	18	1,800	44 lbs.	792 lbs.	451 lbs.
1/2	10-1/8	DBA08-162-18	100	18	1,800	54 lbs.	972 lbs.	529 lbs.
1/2	12-1/8	DBA08-194-18	100	18	1,800	67 lbs.	1,206 lbs.	670 lbs.
1/2	18-1/8	DBA08-290-18	100	12	1,200	98 lbs.	1,176 lbs.	972 lbs.
1/2	24-1/8	DBA08-386-18	100	8	800	128 lbs.	1,024 lbs.	1,292 lbs.
1/2	30-1/8	DBA08-482-18	100	7	700	160 lbs.	1,120 lbs.	1,572 lbs.
1/2	36-1/8	DBA08-578-18	100	6	600	192 lbs.	1,152 lbs.	1,879 lbs.
1/2	42-1/8	DBA08-674-18	100	6	600	222 lbs.	1,332 lbs.	2,180 lbs.
1/2	48-1/8	DBA08-770-18	100	6	600	253 lbs.	1,518 lbs.	2,502 lbs.
1/2	60-1/8	DBA08-962-18	100	3	300	314 lbs.	942 lbs.	3,140 lbs.

Deformed Bar Anchors are designed for weld and bearing plates in concrete connections.

Length: Length is listed before weld. Stud diameters 1/2" will be approx. 1/8" shorter after welding.

TRU-WELD Deformed Bar Anchors can be made in any length above the standard minimum.

Material: Low carbon steel ASTM A496 / A1064

Mechanical Property Requirements

	Type C
Tensile Strength	80,000 psi min. (552 MPa)
Yield Strength (0.5% offset)	70,000 psi min. (485 MPa)

Type "C" Studs are cold-worked deformed steel bars manufactured in accordance with specification ASTM A496 having a nominal diameter equivalent to the diameter of a plain wire having the same weight per foot as the deformed wire. ASTM A496 specifies a maximum diameter of 0.628 in. (16mm). Any bar supplied above that diameter must have the same physical characteristics regarding deformations as required by ASTM A496.

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CN-050	B-1C	GC-050 (Standard Duty)	QN-050 (Standard Duty)
	B-2C	GC-062 (Heavy Duty)	QN-062 (Heavy Duty)

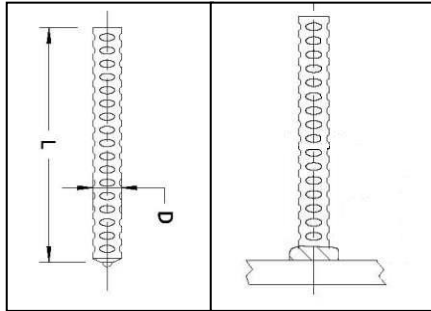
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TRU-WELD Stud Welding



DEFORMED BAR ANCHORS

TYPE DBA STUD
NO THREAD – FULL WELD BASE
TYPE F FERRULE SUPPLIED

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
5/8	12-3/16	DBA10-195-18	50	18	900	51 lbs.	918 lbs.	997 lbs.
5/8	18-3/16	DBA10-291-18	50	12	600	76 lbs.	912 lbs.	1,520 lbs.
5/8	24-3/16	DBA10-387-18	50	8	400	102 lbs.	816 lbs.	2,040 lbs.
5/8	30-3/16	DBA10-483-18	50	7	350	126 lbs.	882 lbs.	2,520 lbs.
5/8	36-3/16	DBA10-579-18	50	6	300	151 lbs.	906 lbs.	3,020 lbs.
5/8	42-3/16	DBA10-675-18	50	8	400	176 lbs.	1,408 lbs.	3,520 lbs.
5/8	48-3/16	DBA10-771-18	50	6	300	197 lbs.	1,182 lbs.	3,962 lbs.

Deformed Bar Anchors are designed for weld and bearing plates in concrete connections.

Length: Length is listed before weld. Stud diameters 5/8" will be approx. 3/16" shorter after welding.

TRU-WELD Deformed Bar Anchors can be made in any length above the standard minimum.

Material: Low carbon steel ASTM A496 / A1064

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CN-062	B-2C	GC-062 (Standard Duty)	QN-062 (Standard Duty)
	B-2C	GC-075 (Heavy Duty)	QN-075 (Heavy Duty)

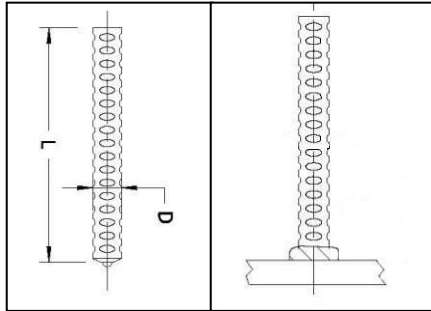
Mechanical Property Requirements

	Type C
Tensile Strength	80,000 psi min. (552 MPa)
Yield Strength (0.5% offset)	70,000 psi min. (485 MPa)

Type C Studs are cold-worked deformed steel bars manufactured in accordance with specification ASTM A496 having a nominal diameter equivalent to the diameter of a plain wire having the same weight per foot as the deformed wire. ASTM A496 specifies a maximum diameter of 0.628 in. (16mm). Any bar supplied above that diameter must have the same physical characteristics regarding deformations as required by ASTM A496.



TRU-WELD Stud Welding



DEFORMED BAR ANCHORS

TYPE DBA STUD
NO THREAD – FULL WELD BASE
TYPE F FERRULE SUPPLIED

WELD STUD SPECIFICATIONS			WELD STUD PACKAGING			WELD STUD WEIGHTS		
D Diameter	L Length	TRU-WELD Part Number	Pieces Per Box	Boxes Per Pallet	Pieces Per Pallet	Box Weight	Pallet Weight	1,000 Piece Weight
3/4	12-3/16	DBA12-195-18	40	18	720	60 lbs.	1,080 lbs.	1,525 lbs.
3/4	18-3/16	DBA12-291-18	40	12	480	87 lbs.	1,044 lbs.	2,175 lbs.
3/4	24-3/16	DBA12-387-18	40	8	320	115 lbs.	920 lbs.	2,875 lbs.
3/4	30-3/16	DBA12-483-18	40	6	240	145 lbs.	870 lbs.	3,625 lbs.
3/4	36-3/16	DBA12-579-18	40	6	240	175 lbs.	1,050 lbs.	4,375 lbs.
3/4	42-3/16	DBA12-675-18	40	6	240	205 lbs.	1,230 lbs.	5,125 lbs.
3/4	48-3/16	DBA12-771-18	40	6	240	228 lbs.	1,368 lbs.	5,690 lbs.

Deformed Bar Anchors are designed for weld and bearing plates in concrete connections.

Length: Length is listed before weld. Stud diameters 3/4" will be approx. 3/16" shorter after welding.

TRU-WELD Deformed Bar Anchors can be made in any length above the standard minimum.

Material: Low carbon steel ASTM A496 / A1064

Mechanical Property Requirements	
	Type C
Tensile Strength	80,000 psi min. (552 MPa)
Yield Strength (0.5% offset)	70,000 psi min. (485 MPa)

CHUCK PART #	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
CN-075	B-2C	GC-075 (Standard Duty)	QN-075 (Standard Duty)

Type "C" Studs are cold-worked deformed steel bars manufactured in accordance with specification ASTM A496 having a nominal diameter equivalent to the diameter of a plain wire having the same weight per foot as the deformed wire. ASTM A496 specifies a maximum diameter of 0.628 in. (16mm). Any bar supplied above that diameter must have the same physical characteristics regarding deformations as required by ASTM A496.

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Tru-Weld Stud Welding

Tru-Weld SWR A706 Weld Studs

patent pending

Tru-Weld's patent pending SWR (Stud Weldable Rebar) A706 anchors are fully stud weldable with standard stud welding equipment and accessories.

Benefits of Stud Welding:

- *Full penetration welds
- *Faster production than traditional welding
- *Bridge and building construction
- *Automatic machine controlled welds

SWR A706 Applications:

- *Precast concrete grade crossings
- *Concrete connections where ductility is key
- *Thread, bent and straight bar stud uses
- *Seismic management
- *Bridge and Building construction

Tru-Weld Part #	Size	Ferrule Part #	Chuck Part #	Foot Part #	Grip Part #
SWR08-194-11	1/2 X 12-1/8	FER10-P flat welding FER10-PV vertical welding	CSW-050	B-2C	GC-062
SWR08-290-11	1/2 X 18-1/8				
SWR08-386-11	1/2 X 24-1/8				
SWR08-482-11	1/2 X 30-1/8				
SWR08-578-11	1/2 X 36-1/8				
SWR08-770-11	1/2 X 48-1/8				
SWR10-291-11	5/8 X 18-3/16	FER12-P flat welding FER12-PV vertical welding	CSW-062	B-2C	GC-075
SWR10-387-11	5/8 X 24-3/16				
SWR10-483-11	5/8 X 30-3/16				
SWR10-579-11	5/8 X 36-3/16				
SWR10-771-11	5/8 X 48-3/16				
SWR12-291-11	3/4 X 18-3/16	FER14-P flat welding FER14-PV vertical welding	CSW-075	B-3C	GC-087
SWR12-387-11	3/4 X 24-3/16				
SWR12-483-11	3/4 X 30-3/16				
SWR12-579-11	3/4 X 36-3/16				
SWR12-771-11	3/4 X 48-3/16				



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Tru-Weld Stud Welding

Tru-Weld SWR A706 Weld Studs

patent pending



A706/A706M-16

Bar Designation	Nominal Weight, lb/ft [Nominal Mass, kg/m]	Diameter, in. [mm]	Cross-Sectional Area in. ² [mm ²]	Perimeter, in. [mm]
Nominal Dimensions ^A				
4 [13]	0.668 [0.994]	0.500 [12.7]	0.20 [129]	1.571 [39.9]
5 [16]	1.043 [1.552]	0.625 [15.9]	0.31 [199]	1.963 [49.9]
6 [19]	1.502 [2.235]	0.750 [19.1]	0.44 [284]	2.356 [59.8]

^A The nominal dimensions of a deformed bar are equivalent to those of a plain round bar having the same weight [mass] per foot [metre] as the deformed bar

Tensile Requirements	
	Grade 60 [420]
Tensile Strength, min, psi [MPa]	80,000 [550] ^A
Yield Strength, min, psi [MPa]	60,000 [420]
Yield Strength, max, psi [MPa]	78,000 [540]
Elongation in 8 in. [200 mm], min %	
Bar Designation Nos. 4, 5, 6 [13, 16, 19]	14

^A Tensile strength shall not be less than 1.25 times the actual yield strength.

The Tru-Weld SWR A706 meets all the requirements of:

- *ASTM A706 -Standard Specification for Deformed and Plain Low-Alloy Steel Bars for Concrete Reinforcement-Grade 60 deformed concrete reinforcement.
- *ACI 318- Earthquake-Resistant Structures
- *Seismic Design Requirements for Ductile Steel Reinforcing Elements
- *Stud-weldable in accordance with the requirements AWS D1.1/ D1.1 M Structural Welding Code-Steel Clause 7 Stud Welding and/or AWS D1.4/ D1.4 M



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Tru-Weld Stud Welding

Tru-Weld SWR A706 Weld Studs

patent pending

Physical and Embedment Properties of SWR A706 Weld Studs

Below are physical properties of SWR A706 Weld Studs per A706/A706M-16 Grade 60. Using formulas in ACI 318-14 (Table 4.2.2) development length for deformed bars in tension can be calculated. Below are embedment length requirements to develop the full bar strength capacity. Free edge distance and anchor spacing should be observed in regard to achieving full capacity. In actual practice, Tru-Weld applications should include a factor of safety. Embedment length can be reduced based upon factors given in ACI 318-14 Section 25.4. **The user of these Tru-Weld studs will make this determination.**

Dia.	A _s	ASTM	A _s F _y Yield Lbs. (Min)	A _s F _u Tensile Lbs. (Min.)
1/2	0.20	4 [13]	12,000	16,000
5/8	0.31	5 [16]	18,600	24,800
3/4	0.44	6 [19]	26,400	35,200
A _s Nominal Area				
F _y Yield--60,000 PSI Min				
F _u Tensile--80,000 PSI Min				

Per A706/A706M-16 Grade 60 6.2 The chemical composition as shown by heat analysis shall be limited by the following:

Element max, %

Carbon 0.33 %

Manganese 1.56 %

Phosphorus 0.043 %

Sulfur 0.053 %

Per ACI 318-14:25.4.2.1 Development length L_d for deformed bars and deformed wires in tension shall be the greater of (a) and (b):

- (a) Length calculated in accordance with 25.4.2.2 or 25.4.2.3 using the application modification factors of 25.4.2.4
- (b) 12 in. min. (per ACI)

Normal Weight Concrete Compressive Strength, f'c (psi)	Minimum Embedment Length for Full Anchor Capacity Development, After Welding (inches)		
	Bar Diameter, db		
	0.5	0.625	0.75
3000	21.91	27.39	32.86
4000	18.98	23.72	28.46
5000	16.97	21.21	25.46

Light Weight Concrete Compressive Strength, f'c (psi)	Minimum Embedment Length for Full Anchor Capacity Development, After Welding (inches)		
	Bar Diameter, db		
	0.5	0.625	0.75
3000	29.21	36.52	43.82
4000	25.30	31.63	37.95
5000	22.63	28.28	33.94



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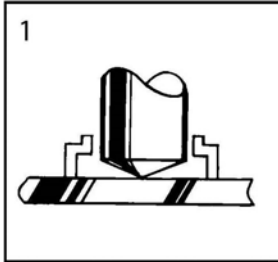
Tru-Weld Stud Welding

Set up for Welding SWR A706 Weld

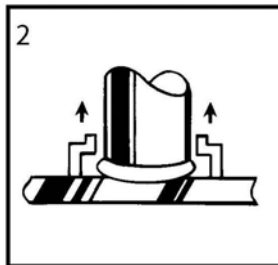
In house parameters provided acceptable results in welding application and testing. The parameters may need modification with respect to application or field conditions. Please refer to AWS requirements for further information.

Dia., in. [mm]	Area in ² [mm ²]	ASTM	Downhand Welding			
			Amp	Sec	Lift	Plunge
0.500 [12.7]	0.20 [129]	4 [13]	900	0.67	0.125	0.312
0.625 [15.9]	0.31 [199]	5 [16]	1200	0.71	0.1875	0.375
0.750 [19.1]	0.44 [284]	6 [19]	1700	0.98	0.1875	0.375

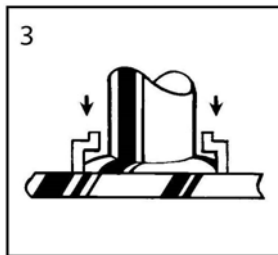
Stud Welding - Step by Step



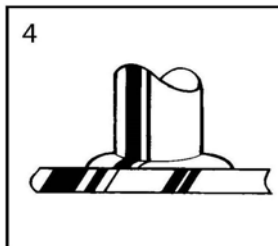
The weld gun is positioned over the base material and the main gun spring is partially compressed. Hold gun perpendicular to work surface and hold ferrule firmly against the surface.



The trigger is pressed and the stud lifts off the base, drawing an arc. The arc melts the end of the weld stud and the base material below. The arc shield (ferrule) concentrates the heat below the weld stud and contains the molten metal within the weld zone. Do not move weld gun during weld.



The main spring plunges the weld stud down into the molten pool of metal in the base material. The cycle is completed in less than a second and the resulting weld bond develops the full strength of the fastener in the weld zone. Allow metal to cool and withdraw gun from the stud, pulling the gun straight up off of the stud.



The weld gun is withdrawn from the weld stud leaving the ferrule. The ferrule is broken away and discarded. Visually inspect weld.

Note - when determining finished length required for the particular application, keep in mind the reduction in length (burn-off) from stud welding operations. TRU-WELD stud lengths are always given before weld.



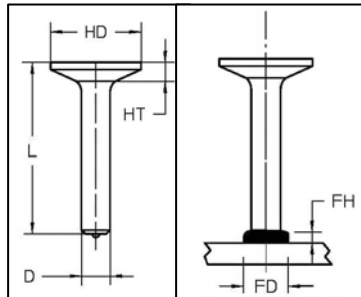
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TRU-WELD Stud Welding

PUNCHING SHEAR RESISTOR



TYPE **PSR** STUD
HEADED CONCRETE ANCHOR – FULL WELD BASE
TYPE F FERRULE SUPPLIED

WELD STUD SPECIFICATIONS

D Diameter	L Length	TRU-WELD Part Number	HD Head Diameter	HT Head Height	FD Fillet Diameter	FH Fillet Height
3/8	3-7/16	PSR06-055-11	1.190	.260	1/2	1/8
1/2	2-5/8	PSR08-042-11	1.580	.330	11/16	5/32
5/8	3-3/4	PSR08-060-11	1.980	.400	7/8	3/16
3/4	4-3/8	PSR08-070-11	2.370	.470	1-1/16	1/4

- 1) Tru-Weld studs are available in any length above the standard minimum.
- 2) Listed Ferrule above is for the standard flat down hand position.

Diameter	FOOT PART #	GRIP PART #	FERRULE FOOT PLATE (DUAL LEG)
3/8	B-1C	GC-037	QN-037
1/2	B-1C	GC-050	QN-050
5/8	B-2C	GC-062	QN-062
3/4	B-2C	GC-075	QN-075

Mechanical Property Requirements

	Type B
Tensile Strength	65,000 psi min.
Yield Strength	51,000 psi min.
Elongation (% in 2 in.)	20% min.
Elongation (% in 5x dia.)	15% min.
Reduction of Area	50% min.

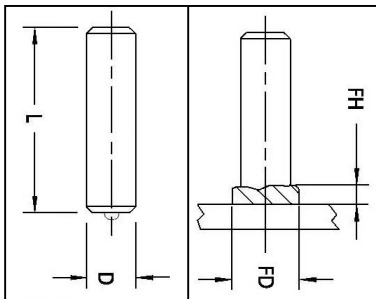


TRU-WELD Stud Welding

NO THREAD STUD – FULL WELD BASE

TYPE NT STUD

TYPE F FERRULE SUPPLIED



D Stud Diameter	L Length (BW)	TRU-WELD Part Number	FD Weld Fillet Diameter	FH Weld Fillet Height	Ferrule Part Number
1/4	7/8	NT04-014-11	23/64	7/64	FER04-F
5/16	7/8	NT05-014-11	7/16	7/64	FER05-F
3/8	7/8	NT06-014-11	1/2	1/8	FER06-F
7/16	1	NT07-016-11	19/32	9/64	FER07-F
1/2	1	NT08-016-11	11/16	5/32	FER08-F
5/8	1-5/16	NT10-021-11	7/8	3/16	FER10-F
3/4	1-5/16	NT12-021-11	1-1/16	1/4	FER12-F
7/8	1-9/16	NT14-025-11	1-1/8	5/16	FER14-F
1	1-7/8	NT16-030-11	1-3/8	3/8	FER16-F

NT Studs are used in all types of applications. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 1/2" and below will be approx. 1/8" shorter after welding. 5/8" - 7/8" will be approx. 3/16" shorter after welding. 1" and above will be 1/4" shorter after weld. TRU-WELD NT Studs can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. NT Studs are also available in weldable stainless steel.

Mechanical Property Requirements	
Tensile Strength	61,000 psi min.
Yield Strength	49,000 psi min.
Elongation (% in 2 in.)	17% min.
Elongation (% in 5x dia.)	14% min.
Reduction of Area	50% min.

DIAMETER	CHUCK PART #	Light Duty Standard		Light Duty Split		Standard Combination
		FOOT PART #	GRIP PART #	FOOT PART #	GRIP PART #	FOOT AND GRIP #
1/4	CN-025	B-1N	GN-025	B-1C	GC-025	QM-025
5/16	CN-031	B-1N	GN-031	B-1C	GC-031	QM-031
3/8	CN-037	B-1N	GN-050	B-1C	GC-050	QM-050
7/16	CN-043	B-1N	GN-043	B-1C	GC-043	QM-043
1/2	CN-050	B-2N	GN-062	B-2C	GC-062	QM-062
5/8	CN-062	B-2N	GN-075	B-2C	GC-075	QM-075
3/4	CN-075	B-2N	GN-075	B-2C	GC-075	QM-075
7/8	CN-087	B-3N	GN-087	B-3C	GC-087	QM-087
1	CN-100	B-3N	GN-100	B-3C	GC-100	QM-100

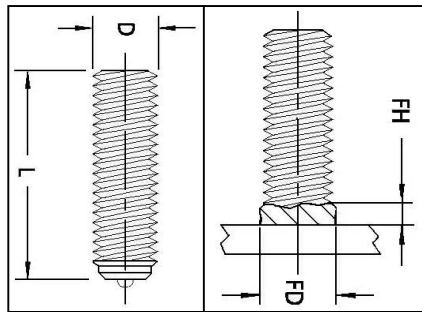
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TRU-WELD Stud Welding



FULL THREAD STUD – FULL WELD BASE

TYPE TT STUD

TYPE F FERRULE SUPPLIED

D Stud Diameter	L Length (BW)	TRU-WELD Part Number	FD Weld Fillet Diameter	FH Weld Fillet Height	Ferrule Part Number
1/4-20	3/4	TT04-012-11	23/64	7/64	FER04-F
5/16-18	3/4	TT05-012-11	7/16	7/64	FER05-F
3/8-16	3/4	TT06-012-11	1/2	1/8	FER06-F
7/16-14	7/8	TT07-014-11	19/32	9/64	FER07-F
1/2-13	7/8	TT08-014-11	11/16	5/32	FER08-F
5/8-11	1	TT10-016-11	7/8	3/16	FER10-F
3/4-10	1-3/16	TT12-019-11	1-1/16	1/4	FER12-F
7/8-9	1-11/16	TT14-027-11	1-1/8	5/16	FER14-F
1-8	1-11/16	TT16-027-11	1-3/8	3/8	FER16-F

Mechanical Property Requirements	
Tensile Strength	61,000 psi min.
Yield Strength	49,000 psi min.
Elongation (% in 2 in.)	17% min.
Elongation (% in 5x dia.)	14% min.
Reduction of Area	50% min.

Full Thread Studs are used in all types of applications. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 1/2" and below will be approx. 1/8" shorter after welding. 5/8" – 7/8" will be approx. 3/16" shorter after welding. 1" Diameter studs and above will be approx. 1/4" shorter after weld. TRU-WELD TT Studs can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. TT Studs are also available in weldable stainless steel. Type 302 is the most commonly used. Other grades of stainless steel (except Type 303) are available when required.

		Light Duty Standard		Light Duty Split		Standard Combination
DIAMETER	CHUCK PART #	FOOT PART #	GRIP PART #	FOOT PART #	GRIP PART #	FOOT AND GRIP #
1/4	CN-025	B-1N	GN-025	B-1C	GC-025	QN-025
5/16	CN-031	B-1N	GN-031	B-1C	GC-031	QN-031
3/8	CN-037	B-1N	GN-050	B-1C	GC-050	QN-050
7/16	CN-043	B-1N	GN-043	B-1C	GC-043	QN-044
1/2	CN-050	B-1N	GN-050	B-1C	GC-050	QN-050
5/8	CN-062	B-2N	GN-062	B-2C	GC-062	QN-062
3/4	CN-075	B-2N	GN-075	B-2C	GC-075	QN-075
7/8	CN-087	B-3N	GN-087	B-3C	GC-087	QN-087
1	CN-100	B-3N	GN-100	B-3C	GC-100	QN-100

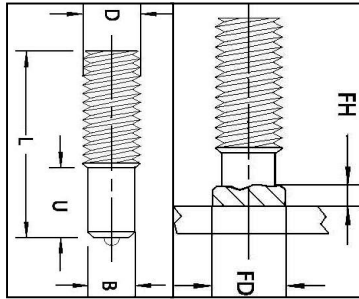
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TRU-WELD Stud Welding



PARTIAL THREAD STUD

TYPE TP STUD

TYPE P FERRULE SUPPLIED

D Stud Diameter	L Length (BW)	TRU-WELD Part Number	B Base Diameter	U Base Length	FD Weld Fillet Diameter	FH Weld Fillet Height	Ferrule Part Number
1/4-20	3/4	TP04-012-11	.215	3/8	5/16	3/32	FER04-P
5/16-18	3/4	TP05-012-11	.275	3/8	13/32	7/64	FER05-P
3/8-16	3/4	TP06-012-11	.330	13/32	7/16	7/64	FER06-P
7/16-14	7/8	TP07-014-11	.87	7/16	1/2	1/8	FER07-P
1/2-13	7/8	TP08-014-11	.448	1/2	19/32	5/32	FER08-P
5/8-11	1	TP10-016-11	.562	5/8	3/4	3/16	FER10-P
3/4-10	1-3/16	TP12-019-11	.680	13/16	7/8	1/4	FER12-P
7/8-9	1-11/16	TP14-027-11	.798	7/8	1	5/16	FER14-P
1-8	1-11/16	TP16-027-11	.915	15/16	1-1/8	5/16	FER16-P

TP STUDS are used in all types of applications.

Length: TRU-WELD TP Studs can be made in any length above the standard minimum.

Material: Low Carbon Steel, ASTM A29 / A108, 1010-1020. TP Studs are also available in weldable stainless steel.

Mechanical Property Requirements	
Tensile Strength	61,000 psi min.
Yield Strength	49,000 psi min.
Elongation (% in 2 in.)	17% min.
Elongation (% in 5x dia.)	14% min.
Reduction of Area	50% min.

DIAMETER	CHUCK PART #	Light Duty Standard		Light Duty Split		Standard Combination
		FOOT PART #	GRIP PART #	FOOT PART #	GRIP PART #	FOOT AND GRIP #
1/4	CN-025	B-1N	GN-025	B-1C	GC-025	QN-025
5/16	CN-031	B-1N	GN-031	B-1C	GC-031	QN-031
3/8	CN-037	B-1N	GN-050	B-1C	GC-050	QN-050
7/16	CN-043	B-1N	GN-043	B-1C	GC-043	QN-044
1/2	CN-050	B-1N	GN-050	B-1C	GC-050	QN-050
5/8	CN-062	B-2N	GN-062	B-2C	GC-062	QN-062
3/4	CN-075	B-2N	GN-075	B-2C	GC-075	QN-075
7/8	CN-087	B-3N	GN-087	B-3C	GC-087	QN-087
1	CN-100	B-3N	GN-100	B-3C	GC-100	QN-100

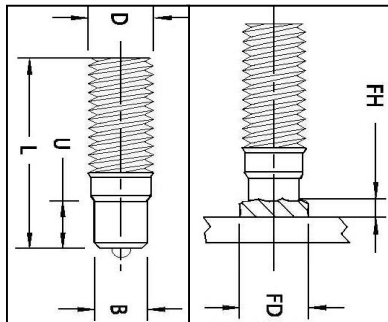
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TRU-WELD Stud Welding



THREADED STUD – REDUCED WELD BASE

TYPE TR STUD

TYPE R FERRULE SUPPLIED

D Stud Diameter	L Length (BW)	TRU-WELD Part Number	B Base Diameter	U Base Length	FD Weld Fillet Diameter	FH Weld Fillet Height	Ferrule Part Number
3/8-16	3/4	TR06-012-11	.310	3/8	7/16	7/64	FER06-R
7/16-14	7/8	TR07-014-11	.373	3/8	1/2	1/8	FER07-R
1/2-13	7/8	TR08-014-11	.435	7/16	19/32	9/64	FER08-R
5/8-11	1	TR10-016-11	.500	1/2	11/16	5/32	FER10-R
3/4-10	1-3/16	TR12-019-11	.625	5/8	7/8	3/16	FER12-R

TR Studs are used in all types of applications. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 1/2" and below will be approx. 1/8" shorter after welding. 5/8" – 3/4" will be approx. 3/16" shorter after welding.

TRU-WELD TR Studs can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. TR Studs are also available in weldable stainless steel. Type 302 is the most commonly used. Other grades of stainless steel (except Type 303) are available when required

Mechanical Property Requirements

Tensile Strength	61,000 psi min.
Yield Strength	49,000 psi min.
Elongation (% in 2 in.)	17% min.
Elongation (% in 5x dia.)	14% min.
Reduction of Area	50% min.

DIAMETER	CHUCK PART #	Light Duty Standard		Light Duty Split		Standard Combination
		FOOT PART #	GRIP PART #	FOOT PART #	GRIP PART #	FOOT AND GRIP #
3/8	CN-037	B-1N	GN-037	B-1C	GC-037	QN-037
7/16	CN-043	B-1N	GN-043	B-1C	GC-043	QN-044
1/2	CN-050	B-1N	GN-050	B-1C	GC-050	QN-050
5/8	CN-062	B-2N	GN-062	B-2C	GC-062	QN-062
3/4	CN-075	B-2N	GN-075	B-2C	GC-075	QN-075

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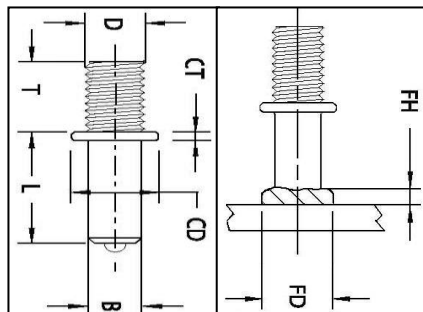
TRU-WELD Stud Welding

COLLAR STUD

TYPE CS STUD

THREADED TO COLLAR— PITCH DIAMETER WELD BASE

TYPE C FERRULE SUPPLIED



D Thread Diameter	T Thread Length	TRU-WELD Part Number	B Base Diameter	L Stud Length	FD Weld Fillet Diameter	FH Weld Fillet Height	Ferrule Part Number
1/4-20	1/4	CS03-008-11-04-004	.215	1/2	23/64	7/64	FER04-C
5/16-18	3/8	CS04-008-11-05-006	.275	1/2	7/16	7/64	FER05-C
3/8-16	3/8	CS05-008-11-06-006	.330	1/2	1/2	1/8	FER06-C
1/2-13	3/8	CS07-009-11-08-006	.448	9/16	11/16	5/32	FER08-C

Collar Studs are used in all types of applications. They can be welded to a flat surface, or on the inside or outside of an angle.

Length: Length is listed before weld. Stud diameters 1/2" and below will be approx. 1/8" shorter after welding.

TRU-WELD Collar Studs can be made in any length above the standard minimum.

Material: Low carbon steel, ASTM A29 / A108, 1010-1020. Collar Studs are also available in weldable stainless steel. Type 302 is the most commonly used. Other grades of stainless steel (except Type 303) are available when required.

Mechanical Property Requirements

Tensile Strength	61,000 psi min.
Yield Strength	49,000 psi min.
Elongation (% in 2 in.)	17% min.
Elongation (% in 5x dia.)	14% min.
Reduction of Area	50% min.

THREAD DIAMETER	CHUCK PART #	Light Duty Standard		Light Duty Split		Standard Combination
		FOOT PART #	GRIP PART #	FOOT PART #	GRIP PART #	FOOT AND GRIP #
1/4"	CN-025	B-2N	GN-062	B-2C	GC-062	QN-062
5/16"	CN-031	B-2N	GN-062	B-2C	GC-062	QN-062
3/8"	CN-037	B-2N	GN-062	B-2C	GC-062	QN-062
1/2"	CN-050	B-2N	GN-075	B-2C	GC-075	QN-075



TRU-WELD *Stud Welding*

CD STUD WELDING MATERIAL CAPABILITIES

BASE MATERIAL	STUD MATERIAL			
	MILD STEEL; 1010 - 1030	STAINLESS STEEL 302/304/305	ALUMINUM 1100/5086/6061	BRASS 70-30/65-35
MILD STEEL: 1006-1030	EXCELLENT	EXCELLENT	NA	EXCELLENT
MEDIUM CARBON STEEL: 1030-1050	GOOD	GOOD	NA	GOOD
GALVANIZED SHEET DUCT OR DECKING	EXCELLENT	EXCELLENT	NA	NA
STRUCTURAL STEEL	EXCELLENT	EXCELLENT	NA	EXCELLENT
STAINLESS STEEL: 405,410,430, AND 300 SERIES (EXCL. 303)	EXCELLENT	EXCELLENT	NA	EXCELLENT
LEAD-FREE BRASS, ELECTROLYTIC COPPER, LEAD-FREE ROLLED COPPER	EXCELLENT	EXCELLENT	NA	EXCELLENT
MOST ALUMINUM ALLOYS OF THE 1000,3000,5000, AND 6000 SERIES 1	NA	NA	EXCELLENT	NA
DIE-CAST ZINC ALLOYS	GOOD	GOOD	EXCELLENT	GOOD

1) OTHER MATERIALS, SUCH AS 7000 SERIES ALUMINUM, TITANIUM ALLOYS, INCONEL, ETC. CAN BE WELDED UNDER SPECIFIED CONDITIONS.

2) GOOD – GENERALLY FULL STRENGTH RESULTS, DEPENDING ON THE COMBINATION OF STUD SIZE AND BASE METAL.

STANDARD LOAD CAPACITIES

STUD MATERIAL	STUD SIZE	MAX. FASTENING TORQUE (INCH/LBS.)	ULTIMATE TENSILE LOAD (LBS.)	MAX. SHEAR LOAD (LBS.)
LOW-CARBON COPPER FLASHED STEEL	6-32	6.0	500	375
	8-32	12.0	765	575
	10-24	14.0	960	720
	1/4-20	43.0	1,750	1,300
	5/16-18	72.0	2,900	2,200
	3/8-16	106.0	4,300	3,250
STAINLESS STEEL: 304	6-32	10.0	790	590
	8-32	20.0	1,260	940
	10-24	23.0	1,530	1,150
	1/4-20	75.0	2,880	2,160
	5/16-18	126.0	3,750	5,350
	3/8-16	186.0	4,850	7,150
ALUMINUM ALLOY: 1100	6-32	2.5	200	125
	8-32	5.0	295	185
	10-24	6.5	380	235
	1/4-20	21.5	670	415
	5/16-18	36.0	1,125	695
	3/8-16	53.0	1,660	1,000
ALUMINUM ALLOY: 5086	6-32	3.5	375	235
	8-32	7.5	585	365
	10-24	10.0	735	460
	1/4-20	32.5	1,360	850
	5/16-18	54.5	2,300	1,400
	3/8-16	81.0	3,400	2,100
BRASS: 70-30, 65-35	6-32	8.0	600	390
	8-32	16.0	860	560
	10-24	18.5	1,040	680
	1/4-20	61.0	1,950	1,275
	5/16-18	102.0	3,280	2,140
	3/8-16	150.0	4,800	3,160

*MAXIMUM FASTENING TORQUE SHOULD DEVELOP FASTENER TENSION TO SLIGHTLY LESS THAN YIELD POINT.

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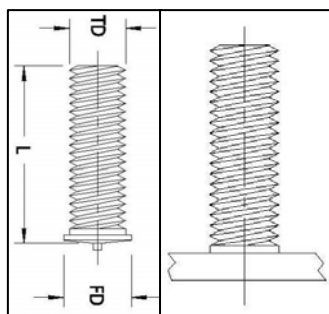
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TRU-WELD Stud Welding

TYPE CD STUD

FULLY THREADED CAPACITOR DISCHARGE STUD – FLANGED
NO FERRULE NEEDED



WELD STUD SPECIFICATIONS			
TD Diameter and Thread Pitch	L Min. Length before weld	TRU-WELD Part Number	FD Flange Diameter
#4-40	.250	CDEC-004-541	.187
#6-32	.250	CDGC-004-541	.218
#8-32	.250	CDIC-004-541	.250
#10-32	.250	CDKF-004-541	.250
#10-24	.250	CDKC-004-541	.250
1/4-20	.375	CD04-006-541	.312
5/16-18	.500	CD05-008-541	.375
3/8-16	.500	CD06-008-541	.437
CD STUDS ARE AVAILABLE IN VARIOUS LENGTHS, DIAMETERS, AND MATERIALS (TOO MANY TO LIST HERE)			

PART NUMBERING CODES (CD STUDS)

PREFIX (1ST FOUR DIGITS OR CHARACTERS)

CDEC = #4 CDKC = #10
CDGC = #6 CD04 = 1/4
CDIC = #8 CD05 = 5/16

SUFFIX (LAST THREE DIGITS)

FLANGE/NON-FLANGE (5 OR 6)
TIP/NO TIP (4 OR 0)
MATERIAL (1, 2, 3)
1 – MILD STEEL
2 – STAINLESS STEEL
3 – ALUMINUM

MATERIAL

MILD STEEL, STAINLESS STEEL, ALUMINUM, BRASS

PLATING

ALL MILD STEEL STUDS ARE COPPER PLATING (NICKEL PLATING AVAILABLE UPON REQUEST)

ANNEALING

ALL STUDS ARE ANNEALED WHERE REQUIRED

ESTIMATED WEIGHTS OF THREADED CD STUDS IN POUNDS PER 1000 PIECES						
LENGTH	#4-40	#6-32	#8-32	#10-24	1/4-20	5/16-18
1/4	.69	1.00	1.39	1.79	3.08	4.90
3/8	.94	1.38	1.93	2.50	4.37	6.98
1/2	1.18	1.76	2.49	3.21	5.66	9.06
5/8	1.43	2.13	3.04	3.93	6.95	11.13
3/4	1.67	2.51	3.60	4.64	8.24	13.21
7/8	1.92	2.89	4.15	5.35	9.52	15.29
1	2.16	3.26	4.71	6.07	10.81	17.36
1-1/4	2.65	4.02	5.82	7.50	13.39	21.52
1-1/2	3.15	4.77	6.93	8.92	15.96	25.67
1-3/4	3.64	5.52	8.04	10.35	18.54	29.83

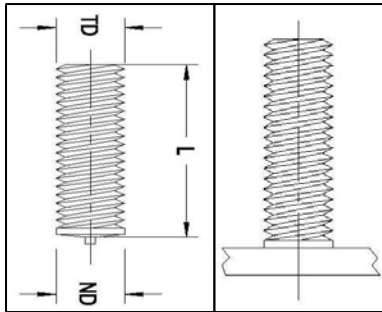
TFP Corporation/TRU-WELD
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<http://www.tfpcorp.com>
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<http://www.weldstud.com>



TRU-WELD Stud Welding



TYPE CD STUD

FULLY THREADED CAPACITOR DISCHARGE STUD – NON-FLANGED
NO FERRULE NEEDED

WELD STUD SPECIFICATIONS			
TD Diameter and Thread Pitch	L Min. Length before weld	TRU-WELD Part Number	ND Nominal Diameter
#4-40	.250	CDEC-004-641	.112
#6-32	.250	CDGC-004-641	.138
#8-32	.250	CDIC-004-641	.164
#10-32	.250	CDKF-004-641	.190
#10-24	.250	CDKC-004-641	.190
1/4-20	.375	CD04-006-641	.250
5/16-18	.500	CD05-008-641	.312
3/8-16	.500	CD06-008-641	.375
CD STUDS ARE AVAILABLE IN VARIOUS LENGTHS, DIAMETERS, AND MATERIALS (TOO MANY TO LIST HERE)			

PART NUMBERING CODES (CD STUDS)

PREFIX (1ST FOUR DIGITS OR CHARACTERS)

CDEC = #4 CDKC = #10
CDGC = #6 CD04 = 1/4
CDIC = #8 CD05 = 5/16

SUFFIX (LAST THREE DIGITS)

FLANGE/NON-FLANGE (5 OR 6)

TIP/NO TIP (4 OR 0)

MATERIAL (1, 2, 3)

1 – MILD STEEL
2 – STAINLESS STEEL
3 – ALUMINUM

MATERIAL

MILD STEEL, STAINLESS STEEL, ALUMINUM, BRASS

PLATING

ALL MILD STEEL STUDS ARE COPPER PLATING (NICKEL PLATING AVAILABLE UPON REQUEST)

ANNEALING

ALL STUDS ARE ANNEALED WHERE REQUIRED

ESTIMATED WEIGHTS OF THREADED CD STUDS IN POUNDS PER 1000 PIECES						
LENGTH	#4-40	#6-32	#8-32	#10-24	1/4-20	5/16-18
1/4	.69	1.00	1.39	1.79	3.08	4.90
3/8	.94	1.38	1.93	2.50	4.37	6.98
1/2	1.18	1.76	2.49	3.21	5.66	9.06
5/8	1.43	2.13	3.04	3.93	6.95	11.13
3/4	1.67	2.51	3.60	4.64	8.24	13.21
7/8	1.92	2.89	4.15	5.35	9.52	15.29
1	2.16	3.26	4.71	6.07	10.81	17.36
1-1/4	2.65	4.02	5.82	7.50	13.39	21.52
1-1/2	3.15	4.77	6.93	8.92	15.96	25.67
1-3/4	3.64	5.52	8.04	10.35	18.54	29.83

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TRU-WELD Stud Welding

Estimated Weights for Threaded Studs In Pounds Per 1000 Pieces

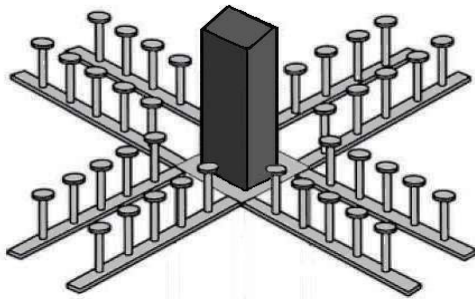
Length	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	7/8"
3/4	8.3	12.8	18.8	25.5	34.5			
1	11.0	17.0	25.0	34.0	46.0	70.0		
1-1/4	13.8	21.3	31.3	42.5	57.5	87.5	133.8	
1-1/2	16.5	25.5	37.5	51.0	69.0	105.0	160.5	243.8
1-3/4	19.3	29.8	43.8	59.5	80.5	122.5	187.3	284.4
2	22.0	34.0	50.0	68.0	92.0	140.0	214.0	325.0
2-1/4	24.8	38.3	56.3	76.5	103.5	157.5	240.8	365.6
2-1/2	27.5	42.5	62.5	85.0	115.0	175.0	267.5	406.3
2-3/4	30.3	46.8	68.8	93.5	126.5	192.5	294.3	446.9
3	33.0	51.0	75.0	102.0	138.0	210.0	321.0	487.5
3-1/4	35.8	55.3	81.3	110.5	149.5	227.5	347.8	528.1
3-1/2	38.5	59.5	87.5	119.0	161.0	245.0	374.5	568.8
3-3/4	41.3	63.8	93.8	127.5	172.5	262.5	401.3	609.4
4	44.0	68.0	100.0	136.0	184.0	280.0	428.0	650.0
4-1/4	46.8	72.3	106.3	144.5	195.5	297.5	454.8	690.6
4-1/2	49.5	76.5	112.5	153.0	207.0	315.0	481.5	731.3
4-3/4	52.3	80.8	118.8	161.5	218.5	332.5	508.3	771.9
5	55.0	85.0	125.0	170.0	230.0	350.0	535.0	812.5

Estimated Weights of No Thread Studs in Pounds Per 1000 Pieces

Length	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	7/8"
3/4	6.0	10.5	16.4	23.5	31.9	41.7			
1	8.0	14.0	21.8	31.3	42.5	55.6	86.6		
1-1/4	10.0	17.5	27.3	39.1	53.1	69.5	108.3	156.0	
1-1/2	12.0	21.0	32.7	47.0	63.8	83.4	129.9	187.2	254.0
1-3/4	14.0	24.5	38.2	54.8	74.4	97.3	151.6	218.4	297.5
2	16.0	28.0	43.6	62.6	85.0	111.2	173.2	249.6	340.0
2-1/4	18.0	31.5	49.1	70.4	95.6	125.1	194.9	280.8	382.5
2-1/2	20.0	35.0	54.5	78.3	106.3	139.0	216.5	312.0	425.0
2-3/4	22.0	38.5	60.0	86.1	116.9	152.9	238.2	343.2	467.5
3	24.0	42.0	65.4	93.9	127.5	166.8	259.8	374.4	510.0
3-1/4	26.0	45.5	70.9	101.7	138.1	180.7	281.5	405.6	552.5
3-1/2	28.0	49.0	76.3	117.4	148.8	194.7	303.1	436.8	595.0
3-3/4	30.0	52.5	81.8	125.2	159.4	208.5	324.8	468.0	637.5
4	32.0	56.0	87.2	128.6	170.0	222.4	346.4	499.2	680.0
4-1/4	34.0	59.5	92.7	133.0	180.6	236.3	368.1	530.4	722.5
4-1/2	36.0	63.0	98.1	140.9	191.3	250.2	389.7	561.6	765.0
4-3/4	38.0	66.5	103.6	148.7	201.9	264.1	411.4	592.8	807.5
5	40.0	70.0	109.0	156.5	212.5	278.0	433.0	624.0	850.0

TRU-WELD STUD WELDING

Punching Shear Resistor (PSR) Studs



Typical PSR Stud Layout

TRU-WELD offers the TRU-TRACE Advantage!

- TRU-WELD PSR Studs have heat codes stamped on the head that allow traceability to the specific Mill Certification of the stud.
- This expands TRU-WELD's Quality Control Program to trace all PSR Studs up to the point they are poured in concrete!

Punching Shear Resistor (PSR) Application;

Tru-Weld punching shear resistor (PSR) studs are large-headed shear connectors that are welded to flat steel bars (creating stud rails) and used for shear reinforcement in flat concrete slabs to replace stirrups and column capitals to resist the punching shear stress in the slabs.

Studs of a predetermined length and diameter, according to design specifications in compliance with IBC and UBC Structural Steel Welding Standards, are used to extend the column perimeter into the floor or foundation slab. This reduces the amount of reinforcing bar required in an area and column congestion resulting in easier and faster installation, as well as lower cost.

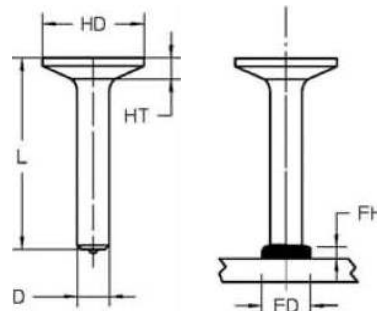
Using these PSR stud rails, you increase the punching shear capacity at the base of the concrete columns, resulting in a significant reduction in slab thickness. This creates a substantial savings in labor and material costs.

Contact a Tru-Weld Sales Rep for ordering details!

1-800-321-5588

PSR Stud Specifications

Stud Diameter	Head Diameter	Head Thickness
3/8" (9.5mm)	1.19" (30.1mm)	0.26" (5.3mm)
1/2" (12.7mm)	1.58" (40.2mm)	0.33" (7.1mm)
5/8" (15.9mm)	1.98" (50.2mm)	0.40" (8.9mm)
3/4" (19.1mm)	2.37" (60.2mm)	0.47" (10.7mm)



Material ;
ASTM A108 / A29
Grade 1010-1020

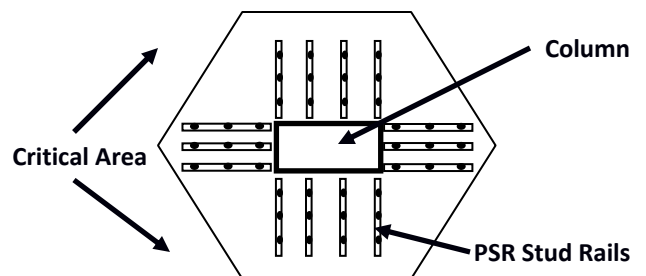
Properties;
Yield - 51,000 PSI
Tensile - 65,000 PSI
Elongation - 20% Min.
Reduction Of Area - 50% Min.

TRU-WELD Studs comply with the requirements of AWS D1.1- 2008 Structural Welding Code. (ICC-ES# - ESR-2822)

Benefits of Using PSR Stud Rails;

1. Eliminating the need for column capitals and stirrups
2. Reduction of setup and installation time.
3. Reduction of congestion around column/slab connections.
4. Distribution of force over a greater critical area.
5. Providing higher tensile strength and more ductile performance of the concrete slab.

PSR Stud Column Layout



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(330) 725-0161 Fax

MADE IN AMERICA



TRU-WELD STUD WELDING

Stainless Steel Weld Studs



TRU-WELD offers all of our high-quality weld studs in Type 302, 304L, 316L, and 430 Stainless Steel in any length above the standard minimum.

TRU-WELD STAINLESS STEEL WELD STUDS

- CONCRETE ANCHORS
- SHEAR CONNECTORS
- PSR STUDS
- FULL THREAD STUDS
- PARTIAL THREAD STUDS
- NO THREAD STUDS
- COLLAR STUDS
- INTERNAL THREAD STUDS
- REDUCED BASE STUDS
- KNOCK-OFF STUDS

302 Stainless - Material Characteristics

Type 302 stainless steel is a general purpose material with greater corrosion resistance to that of mild steel. Type 302 stainless steel produces very good, strong welds.

304L Stainless - Material Characteristics

High strength, excellent corrosion resistance and minimized carbon content make Types 304L stainless steel useful for applications where welding is required. For severely corrosive environments, Type 304L is preferred because of its greater immunity to intergranular corrosion. These grades are suitable for all applications specifying Type 302.

316L Stainless - Material Characteristics

Type 316 stainless steel is widely used in applications requiring corrosion resistance superior to Type 304, or good elevated temperature strength. Type 316L is used extensively for weldments where its immunity to carbide precipitation due to welding assures optimum corrosion resistance.

430 Stainless - Material Characteristics

Type 430 weldable stainless steel has high corrosion resistance, as well as elevated temperature strength which makes it less likely to crack at elevated temperatures. Type 430 Stainless Steel is a magnetic material.

Contact a TRU-WELD Sales Rep for ordering details!

1-800-321-5588



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TRU-WELD EQUIPMENT

STUD WELDING EQUIPMENT & ACCESSORIES CATALOG



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Smithville, OH 44677

Phone: (330) 725-7744

Fax: (330) 669-2473



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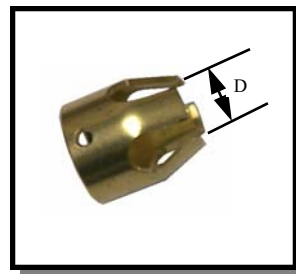
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Version 1.5
08/08/2016

FERRULE GRIPS

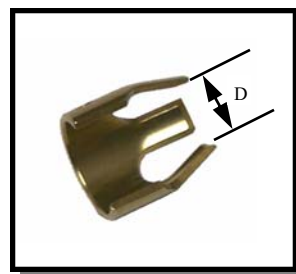
CLOSED FERRULE GRIP (1" LONG) BRASS

STUD SIZE	FOOT SIZE	GRIP DIA.(D)	PART NO.	PRICE
3/16	SMALL	.305	GN-019	
1/4	SMALL	.380	GN-025	
5/16	SMALL	.445	GN-031	
3/8	SMALL	.505	GN-037	
7/16	SMALL	.585	GN-043	
1/2	SMALL	.650	GN-050	
5/8	MEDIUM	.785	GN-062	
3/4	MEDIUM	1.030	GN-075	
7/8	LARGE	1.203	GN-087	
1"	LARGE	1.406	GN-100	



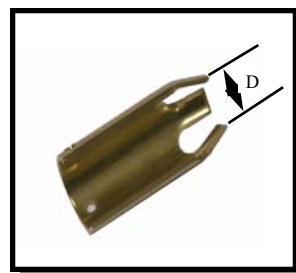
SPLIT FERRULE GRIP (1" LONG) BRASS

STUD SIZE	FOOT SIZE	GRIP DIA.(D)	PART NO.	PRICE
3/16	SMALL	.305	GC-019	
1/4	SMALL	.380	GC-025	
5/16	SMALL	.445	GC-031	
3/8	SMALL	.505	GC-037	
7/16	SMALL	.585	GC-043	
1/2	SMALL	.650	GC-050	
5/8	MEDIUM	.785	GC-062	
3/4	MEDIUM	1.030	GC-075	
7/8	LARGE	1.203	GC-087	
1"	LARGE	1.406	GC-100	



LONG SPLIT FERRULE GRIP (2" LONG) BRASS

STUD SIZE	FOOT SIZE	GRIP DIA.(D)	PART NO.	PRICE
1/4	SMALL	.380	GD-025	
5/16	SMALL	.445	GD-031	
3/8	SMALL	.505	GD-037	
7/16	SMALL	.585	GD-043	
1/2	SMALL	.650	GD-050	
5/8	MEDIUM	.785	GD-062	
3/4	MEDIUM	1.030	GD-075	

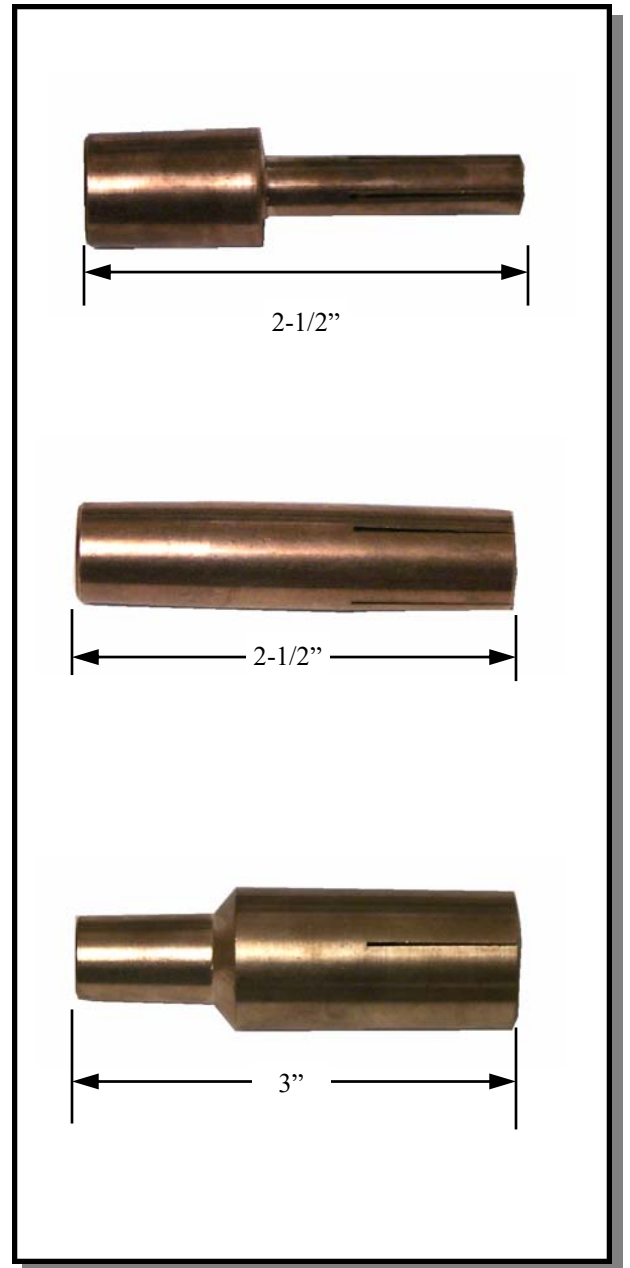


ADD \$1.00 FOR COPPER GRIPS

CHUCKS

ADJUSTABLE CHUCKS

<u>STUD DIA.</u>	<u>PART NO.</u>	<u>PRICE</u>
2MM (.079)	CN-002M	
#2	CN-008	
12 GA & #4	CN-010	
1/8 & #5	CN-012	
10 GA & #6	CN-013	
4MM (.155)	CN-004M	
#8	CN-015	
#10 & 5MM (.196)	CN-018	
6MM (.236)	CN-006M	
.215	CN-021	
.330	CN-033	
1/4	CN-025	
5/16	CN-031	
8MM	CN-008M	
3/8	CN-037	
10MM (.390)	CN-010M	
7/16	CN-043	
12MM (.472)	CN-012M	
1/2	CN-050	
14MM (.551)	CN-014M	
9/16	CN-056	
5/8	CN-062	
16MM	CN-016M	
.680	CN-068	
18MM (.708)	CN-018M	
3/4	CN-075	
7/8	CN-087	
20MM	CN-020M	
1"	CN-100	



LONG AND RECTANGULAR CHUCKS

3-7/8" LONG ADJUSTABLE CHUCKS

<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
#6	CM-013	
#8	CM-015	
#10 & 5MM	CM-018	
6 MM	CM-006M	
1/4	CM-025	
5/16	CM-031	
8MM	CM-008M	
.330	CM-033	
3/8	CM-037	
10MM	CM-010M	
7/16	CM-043	
12MM	CM-012M	
1/2	CM-050	
9/16	CM-056	
5/8	CM-062	
3/4	CM-075	



**SIZES CM-025 AND UNDER ARE
BERYLLIUM**

4-3/4" EXTRA LONG ADJUSTABLE CHUCKS

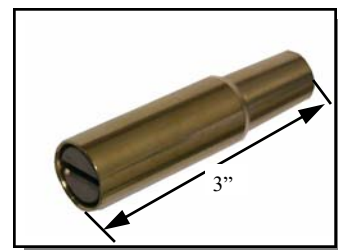
<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
#6	CL-013	
#8	CL-015	
#10	CL-018	
1/4	CL-025	
5/16	CL-031	
3/8	CL-037	
7/16	CL-043	
1/2	CL-050	
5/8	CL-062	
3/4	CL-075	



**SIZES CL-025 AND UNDER ARE
BERYLLIUM**

RECTANGULAR CHUCKS

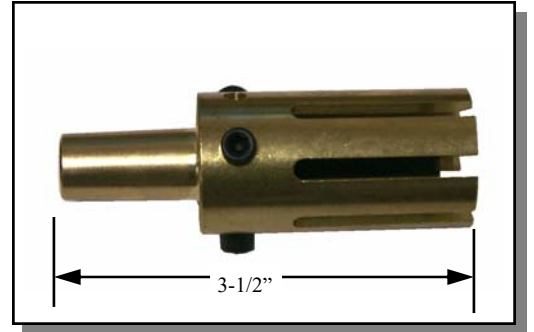
<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
1/8 X 1/4	CR-CA	
1/8 X 3/8	CR-CB	
1/8 X 5/8	CR-CC	
1/8 X 7/8	CR-CH	
1/8 X 1"	CR-CE	
1/4 X 3/4	CR-CF	



HEADED STUD CHUCKS

3/8 DIA. HEADED ANCHOR CHUCK (3/4" DIA. HEAD)

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
CH-037	COMPLETE ASSY.	
CH-037-1	SLEEVE ONLY	
CH-037-2	BASE ONLY	
CH-037-3	STOP SCREW	
SCREWS	10-32 X 3/8	

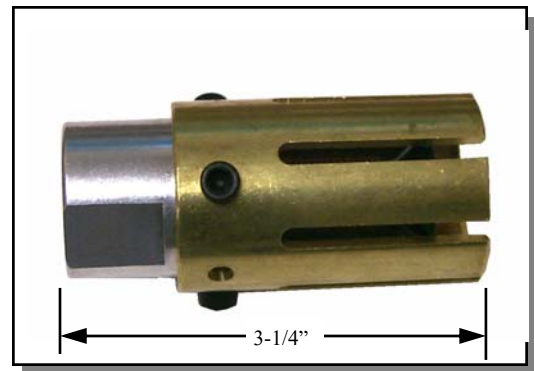


1/2 DIA. HEADED ANCHOR CHUCK (1" DIA. HEAD)

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
CH-050	COMPLETE ASSY.	
CH-050-1	SLEEVE ONLY	
CH-050-2	BASE ONLY	
CH-050-3	STOP SCREW	

5/8 & 3/4 DIA. HEADED ANCHOR CHUCK (1-1/4" DIA. HEAD)

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
CH-075	COMPLETE ASSY.	
CH-075-1	SLEEVE ONLY	
CH-075-2	BASE ONLY	
CH-075-3	STOP SCREW	



7/8 DIA. HEADED ANCHOR CHUCK (1-3/8" DIA. HEAD)

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
CH-087	COMPLETE ASSY.	
CH-087-1	SLEEVE ONLY	
CH-087-2	BASE ONLY	
CH-075-3	STOP SCREW	

1" DIA. HEADED ANCHOR CHUCK (1-5/8 DIA. HEAD)

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
CH-100	COMPLETE ASSY.	
CH-100-1	SLEEVE ONLY	
CH-100-2	BASE ONLY	
CH-075-3	STOP SCREW	
SCREWS	10-32 X 1/2	

SPECIAL CHUCKS / LEGS

Y ANCHOR CHUCKS



ANCHOR SIZE	PART NO.	PRICE
3/16	CY-018	
1/4	CY-025	
5/16	CY-031	

ARC STUD WELDING LEGS



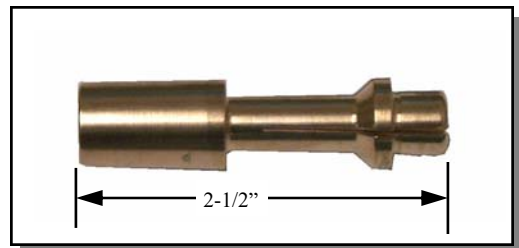
LENGTH	DIA.	PART NO.	PRICE
7"	5/16	L-03107	
9"	5/16	L-03109	
14"	5/16	L-03114	
18"	5/16	L-03118	
7"	3/8	L-03707	
9"	3/8	L-03709	
14"	3/8	L-03714	
18"	3/8	L-03718	
24"	3/8	L-03724	
27"	3/8	L-03727	
32"	3/8	L-03732	
36"	3/8	L-03736	
48"	3/8	L-03748	
5/16 LEG WASHER		L-031-1	
5/16 LEG SCREW		L-031-2	
3/8 LEG WASHER		L-037-1	
3/8 LEG SCREW		L-037-2	

BENT STUD CHUCK



STUD DIA.	BEND	PART NO.	PRICE
3/8	90 deg	CB-037-90	
3/8	45 deg	CB-037-45	
1/2	90 deg	CB-050-90	
1/2	45 deg	CB-050-45	
5/8	90 deg	CB-062-90	
5/8	45 deg	CB-062-45	
3/4	90 deg	CB-075-90	
3/4	45 deg	CB-075-45	

MALE CHUCKS



HOLE SIZE	PART NO.	PRICE
8/32	CX-008-32	
10-24	CX-010-24	
10-32	CX-010-32	
1/4-20	CX-025-20	
5/16-18	CX-031-18	
3/8-16	CX-037-16	
1/2-13	CX-050-13	
5/8-11	CX-062-11	
3/4-10	CX-075-10	
1/4	CX-025	
3/8	CX-037	
1/2	CX-050	
5/8	CX-062	

MISCELLANEOUS GUN PARTS

<u>DESCRIPTION</u>	<u>PART NO.</u>	<u>PRICE</u>
--------------------	-----------------	--------------



Connector Stud

033-506



Threaded Chuck Extension

033-504



Tapered Chuck Adapter

033-505

WELD THRU DECK ACCESSORIES

WELD THRU DECK FOOT ASSEMBLY



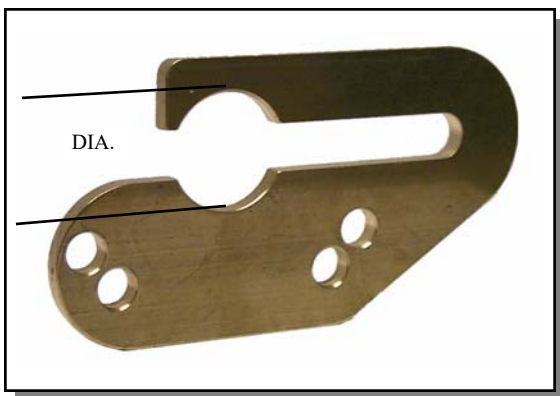
<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
B-0021	FOOT ASSY.	
B-0021-1	FOOT ONLY	
B-0021-2	EXTENSION BAR	
B-0021-3	1/4-20 X 1 SCREWS	

WELD THRU DECK FERRULE HOLDER



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
B-0060-1	3/4 WTD/7/8 FLAT	
B-0060-2	3/4 FLAT	
B-0060-3	5/8 FLAT	
B-0060-4	1" FLAT	
B-0060-5	1/2 FLAT	

REFRACTORY FERRULE FOOT PLATE



<u>PART NO.</u>	<u>NECK DIA.</u>	<u>PRICE</u>
QY-025-1	.810	
QY-025-2	.930	
QY-025-3	1.030	

HEAVY DUTY FERRULE GRIP



<u>PART NO.</u>	<u>STUD DIA.</u>	<u>PRICE</u>
GH-050	1/2	
GH-062	5/8	
GH-075	3/4	
GH-087	7/8	
GH-100	1	

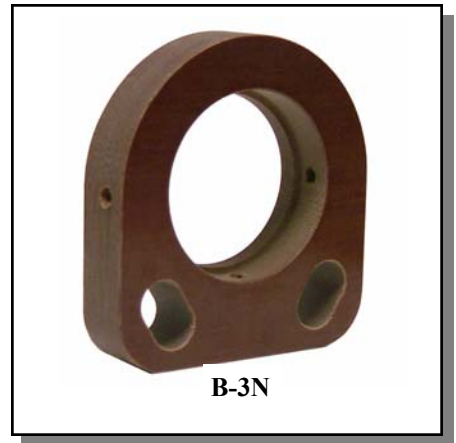
CLOSED FEET



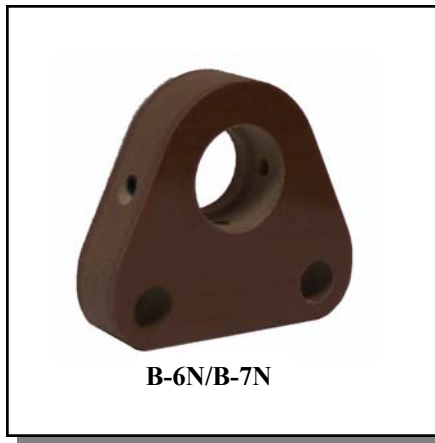
B-1N



B-2N



B-3N



B-6N/B-7N



B-4N/B-5N

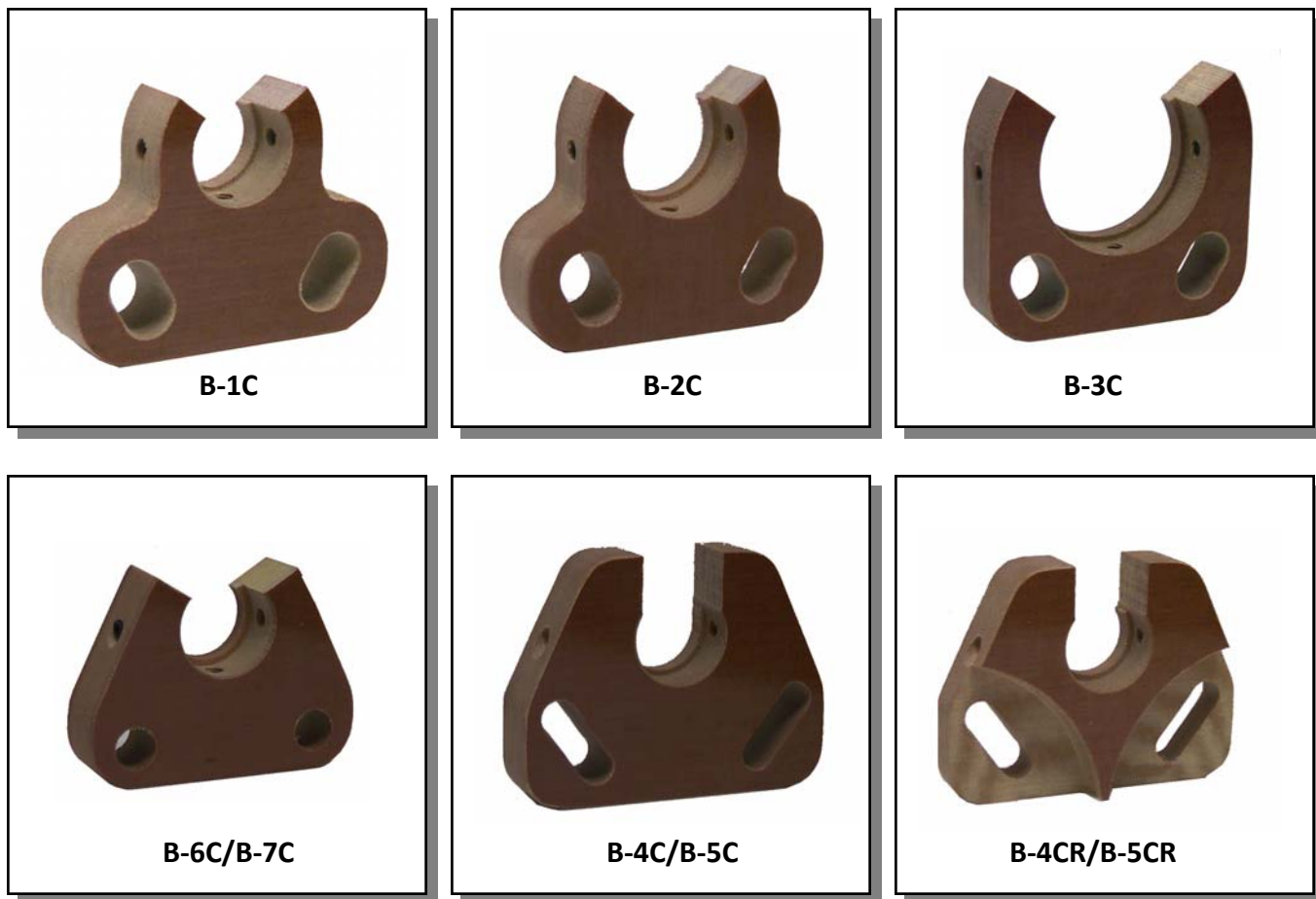


028-833

STANDARD CLOSED FEET

<u>GUN TYPE</u>	<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
PRO-WELD INT.	1/8-1/2	B-1N	
NELSON NS-20	1/8-1/2	B-1N	
NELSON NS-30	1/8-1/2	B-6N	
PRO-WELD INT.	5/8-3/4	B-2N	
NELSON NS-20	5/8-3/4	B-2N	
NELSON NS-30	5/8-3/4	B-7N	
PRO-WELD INT.	7/8-1"	B-3N	
NELSON NS-20	7/8-1"	B-3N	
BANTAM A-58	1/8-1/2	B-4N	
BANTAM A-58	5/8-3/4	B-5N	
PRO-WELD INT.	1/8-3/8	028-833	

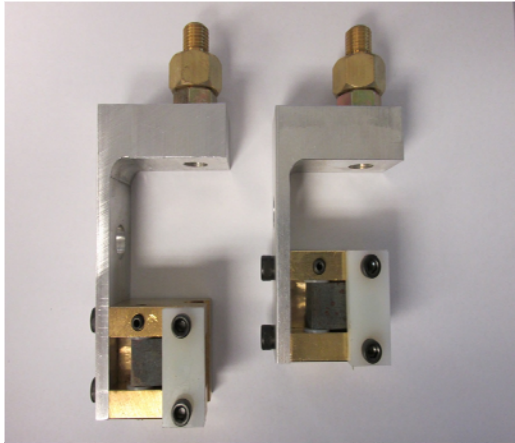
SPLIT FEET



STANDARD SPLIT FEET

GUN TYPE	STUD SIZE	PART NO.	PRICE
PRO-WELD INT.	1/8-1/2	B-1C	
NELSON NS-20	1/8-1/2	B-1C	
NELSON NS-30	1/8-1/2	B-6C	
PRO-WELD INT.	5/8-3/4	B-2C	
NELSON NS-20	5/8-3/4	B-2C	
NELSON NS-30	5/8-3/4	B-7C	
PRO-WELD INT.	7/8-1"	B-3C	
NELSON NS-20	7/8-1"	B-3C	
BANTAM A-58	1/8-1/2	B-4C	
BANTAM A-58	5/8-3/4	B-5C	
BANTAM C-2	1/8-1/2	B-4CR (RECESSED)	
BANTAM C-2	5/8-3/4	B-5CR (RECESSED)	

PSR Accessories



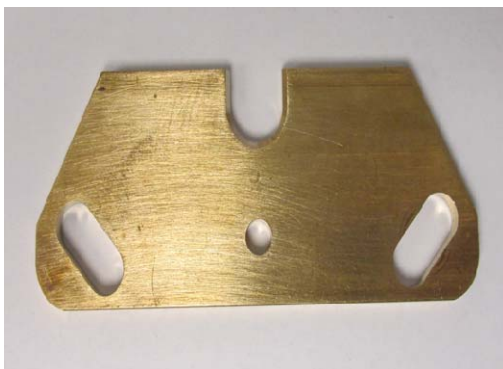
PSR Side Load Chucks

Size	Part Number	Part Description
3/8"	CSL-037L	3/8 Side Load Chuck Long
	CSL-037S	3/8 Side Load Chuck Short
1/2"	CSL-050L	1/2 Side Load Chuck Long
	CSL-050S	1/2 Side Load Chuck Short
5/8"	CSL-062L	5/8 Side Load Chuck Long
	CSL-062S	5/8 Side Load Chuck Short
3/4"	CSL-075L	3/4 Side Load Chuck Long
	CSL-075S	3/4 Side Load Chuck Short



Leg Wideners

Part Number	Part Description
CSLX	Mid-Leg Widener
CSLX	At Gun Leg Widener



Ferrule Foot Plate

Part Number	Part description
QNW-037	3/8F Ferrule Foot Plate
QNW-050	3/8FHD And 1/2F Ferrule Foot Plate
QNW-062	1/2FHD And 5/8F Ferrule Foot Plate
QNW-075	5/8FHD And 3/4F Ferrule Foot Plate

PSR Accessories



1/2" PSR Chuck

Part Number	Part Description
CH-500-PSR	1/2" PSR Chuck

SPECIAL FEET AND FERRULE PLATES

SPLIT BI-POD FEET

<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
1/8-1/2	BP-1C	
5/8-3/4	BP-2C	
7/8-1"	BP-3C	



CLOSED BI-POD FEET

<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
1/8-1/2	BP-1N	
5/8-3/4	BP-2N	
7/8-1"	BP-3N	



*****NOTE: PLEASE SPECIFY GUN TYPE*****

TWIN LEG FERRULE FOOT PLATE

<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
1/4	QN-025	
5/16	QN-031	
3/8	QN-037	
1/2	QN-050	
5/8	QN-062	
3/4	QN-075	
7/8	QN-087	
1"	QN-100	



SINGLE LEG FERRULE FOOT PLATE

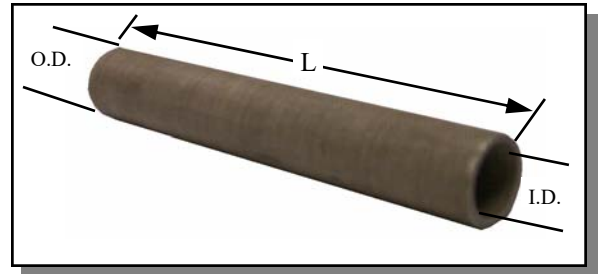
<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
1/4	QM-025	
3/8	QM-037	
1/2	QM-050	
5/8	QM-062	
3/4	QM-075	
7/8	QM-087	



SPECIAL ACCESSORIES

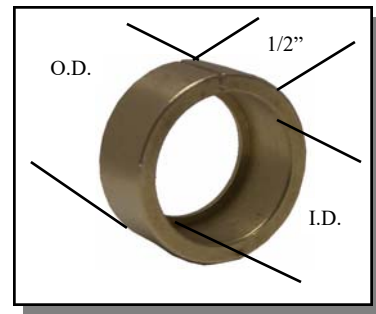
FERRULE TUBING

STUD SIZE	PART NO.	I.D.	O.D.	L	PRICE
#8	MP-015	.291	.360	36"	
#10	MP-018	.305	.375	36"	
1/4	MP-025	.380	.500	36"	
5/16	MP-031	.445	.562	36"	
3/8	MP-037	.505	.625	36"	
7/16	MP-043	.585	.687	36"	
1/2	MP-050	.650	.750	36"	
5/8	MP-062	.785	.906	36"	
3/4	MP-075	1.030	1.156	36"	



FERRULE TUBE BUSHING

STUD SIZE	PART NO.	I.D.	O.D.	PRICE
#8	MB-015	.360	.875	
#10	MB-018	.375	.875	
1/4	MB-025	.500	.875	
5/16	MB-031	.562	.875	
3/8	MB-037	.625	.875	
7/16	MB-043	.687	.875	
1/2	MB-050	.750	.875	
5/8	MB-062	.906	1.156	



GAS ADAPTOR FEET FOR ALUMINUM WELDING (SPECIFY GUN TYPE WHEN ORDERING)



PART NO. BG-1
USE WITH FERRULE



PART NO. BG-2
USE WITHOUT FERRULE

FOOT ONLY BG-2-1
SPARK SHIELD ONLY BG-2-2
VALVE ASSY. BG-2-3



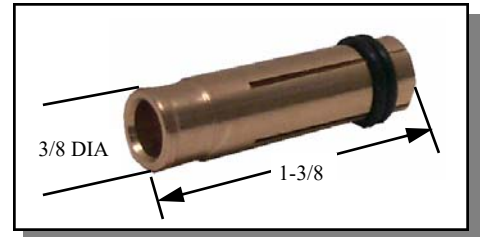
PART NO. BG-3
USE W/ARC-656 GAS UNIT

FOOT ONLY BG-3-1
SPARK SHIELD ONLY BG-3-2
HOSE CONNECTOR 119-0010

CAPACITOR DISCHARGE ACCESSORIES

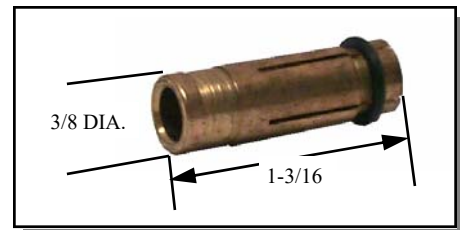
"B" COLLETS

<u>STUD DIA</u>	<u>PART NO.</u>	<u>PRICE</u>
3 MM	CDB-003M	
14 GA	CDB-008	
12 GA & #4	CDB-010	
1/8 GA & #5	CDB-012	
10 GA & #6	CDB-013	
4 MM	CDB-004M	
#8	CDB-015	
#10	CDB-018	
5 MM	CDB-005M	
6 MM	CDB-006M	
.215	CDB-021	
1/4	CDB-025	
5/16	CDB-031	



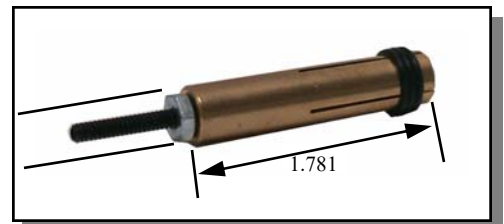
"B" COLLETS AGM STYLE

<u>STUD DIA.</u>	<u>PART NO.</u>	<u>PRICE</u>
14 GA	CDB-008A	
12 GA	CDB-010A	
#6	CDB-013A	
#8	CDB-015A	
#10	CDB-018A	
1/4	CDB-025A	



SOYER COLLETS

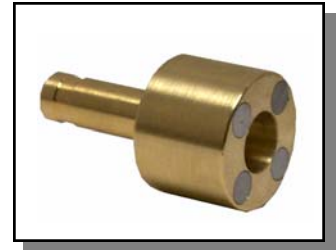
<u>STUD DIA.</u>	<u>PART NO.</u>	<u>PRICE</u>
#6	CDBS-013	
4 MM	CDBS-004M	
#8	CDBS-015	
#10	CDBS-018	
5 MM	CDBS-005M	
6 MM	CDBS-006M	
1/4	CDBS-025	
5/16	CDBS-031	



CAPACITOR DISCHARGE ACCESSORIES

ONE PIECE CONTACT/MAGNETIC CHUCK

<u>PART NO.</u>	<u>PRICE</u>
039-613	



MAGNETIC CHUCK

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
035-301	COMPLETE ASSY	
017-633	MAGNET ONLY	
029-615	CONDUCTOR PLATE	
039-609	INSUL. TUBE	
039-610	INSUL. DISC	
SCREW	10-32 X 7/8	



"B" COLLETS PROTECTOR

<u>STUD SIZE</u>	<u>PART NO.</u>	<u>PRICE</u>
14 GA X 12 GA	028-837	
10 GA	028-838	
BODY ONLY	028-836	
12 GA INSERT	028-834	
10 GA INSERT	028-835	



"B" STOP

<u>STUD</u>	<u>STOP</u>	<u>PART NO.</u>	<u>PRICE</u>
1/4	1-1/4	033-781	
3/8	1-1/8	033-782	
1/2	1"	033-783	
5/8	7/8	033-784	
3/4	3/4	033-785	
7/8	5/8	033-775	
1"	1/2	033-776	
1-1/8	3/8	033-777	
1-1/4	1/4	033-778	
1-3/8 (BUTTON STOP)	1/8	033-779	
UNIVERSAL		033-780	



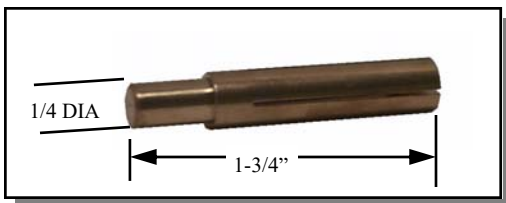
SHORT BUTTON STOP



UNIVERSAL "B" STOP

CAPACITOR DISCHARGE ACCESSORIES

COLLETS INSERTS FOR WELD STUDS



STUD DIA. X DEPTH	PART NO.	PRICE
#4 X 1/4	CI-010-025	
#4 X 3/8	CI-010-037	
#4 X 1/2	CI-010-050	
#4 X 1"	CI-010-100	
#6X 1/4	CI-013-025	
#6 X 3/8	CI-013-037	
#6 X 1/2	CI-013-050	
#6 X 5/8	CI-013-062	
#6 X 3/4	CI-013-075	
#6X 1"	CI-013-100	
10GA X 1/2	CI-014-050	
10GA X 3/4	CI-014-075	
10GA X 1	CI-014-100	
#8X 1/4	CI-015-025	
#8 X 3/8	CI-015-037	
#8 X 1/2	CI-015-050	
#8 X 5/8	CI-015-062	
#8 X 3/4	CI-015-075	
#8X 1"	CI-015-100	
#10 X 1/4	CI-018-025	
#10 X 3/8	CI-018-037	
#10 X 1/2	CI-018-050	
#10 X 5/8	CI-018-062	
#10 X 3/4	CI-018-075	
#10X 1"	CI-018-100	
1/4 X 1/4	CI-025-025	
1/4 X 3/8	CI-025-037	
1/4 X 1/2	CI-025-050	
1/4 X 5/8	CI-025-062	
1/4 X 3/4	CI-025-075	
1/4 X 1"	CI-025-100	
5/16 X 3/8	CI-031-037	
5/16 X 1/2	CI-031-050	
5/16 X 5/8	CI-031-062	
5/16 X 3/4	CI-031-075	
5/16 X 1"	CI-031-100	
3/8 X 1/2	CI-037-050	
3/8 X 3/4	CI-037-075	
3/8 X 1"	CI-037-100	

COLLETS INSERTS FOR WELD PINS



STUD DIA. X DEPTH	PART NO.	PRICE
12GA X 1/2	CIP-010-050	
12GA X 3/4	CIP-010-075	
12GA X 1"	CIP-010-100	
10GA X 1/2	CIP-014-050	
10GA X 3/4	CIP-014-075	

STANDARD SPARK SHIELD



STUD RANGE	PART NO.	PRICE
14 GA - #6	033-764	

VENTED SPARK SHIELD



STUD RANGE	PART NO.	PRICE
14 GA - 10 GA	033-769	

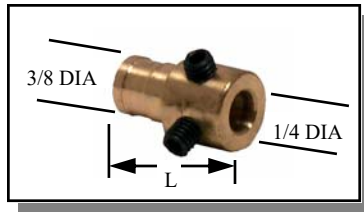
TEMPLATE TUBE ADAPTOR



TEMPLATE I.D.	PART NO.	PRICE
1" DIA.	039-839	
1-1/4" DIA.	039-840	

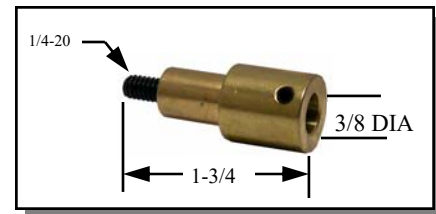
ADAPTORS

B-CI ADAPTOR



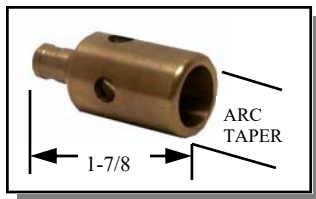
<u>PARTNO.</u>	<u>PRICE</u>
044-082	7/8 LONG
033-746	1-9/16 LONG

K-B ADAPTORS



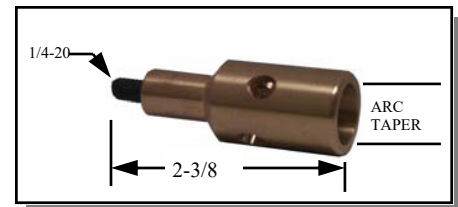
<u>PART NO.</u>	<u>PRICE</u>
039-464	

B-N ADAPTOR



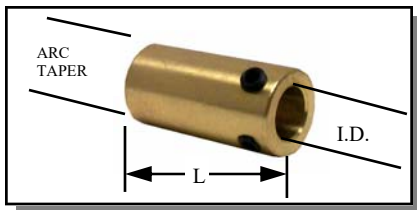
<u>PART NO.</u>	<u>PRICE</u>
039-468	

K-N ADAPTORS



<u>PART NO.</u>	<u>PRICE</u>
033-750	

ADAPTORS



<u>PART NO</u>	<u>.I.D.</u>	<u>PRICE</u>
044-083 N-B	3/8 ID	
044-084 N-C	1/4 ID	

THREADED TAPERED ADAPTORS



<u>PART NO.</u>	<u>PRICE</u>
MT-0003	

MISCELLANEOUS ADAPTORS

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
MT-0008	TEMPLATE TUBE 1/4-1/2 ARC STUDS	
MT-0012	TEMPLATE TUBE 5/8-3/4 ARC STUDS	
033-505L	L-TEC CHUCK ADAPTOR	
033-749	K-CI ADAPTORS	
751-458-049	NS-30 CHUCK ADAPTORS	

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
033-505	Chuck Adaptor	
033-506	Connector Stud	

WELD CABLE CONNECTORS

HEAVY DUTY HI TEMP CONNECTOR



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107-0006	4/O (M) HI TEMP	
107-0006-1	4/O (M) SLEEVE	
107-0006-2	4/O BRASS ONLY	

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107-0007	4/O (F) HI TEMP	
107-0007-1	4/O (F) SLEEVE	
107-0007-2	4/O BRASS ONLY	

107-0007-MF HI TEMP PIN (FITS (M) OR (F))
COPPER WRAP

LIGHT DUTY CONNECTOR



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107-0010	1/O (M) FIBER SHELL	
107-0011	1/O (F) FIBER SHELL	
107-0012	#4 (M) FIBER SHELL	

CONTROL CABLE CONNECTORS

CONTROL CABLE CONNECTOR



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107-0014	MALE 4 POLE CONNECTOR	
107-0015	FEMALE 4 POLE CONNECTOR	
107-0001	PANEL MOUNT CONNECTOR	

HUBBELL STYLE CONNECTOR



2-WIRE (M)

PANEL MOUNT

HUBBELL (M)

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107-0016	2-WIRE (M)	
107-0017	2-WIRE (F)	
107-0018	2-WIRE (PANEL MOUNT)	
107-0019	(M) RUBBER COVER	
107-0020	(F) RUBBER COVER	
107-0030	HUBBELL (M)	
107-0032	HUBBELL (F)	
107-0031	HUBBELL (PANEL MOUNT)	

PANEL MOUNT CAMLOK CONNECTORS



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107-0003	MALE PANEL MOUNT	
107-0002	FEMALE PANEL MOUNT	

WELD CABLE LUGS



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
123-0003	#4 W/#10 HOLE	
123-0001	#1 W/#10 HOLE	
123-0006	#1 W/1/4 HOLE	
123-0002	#1 W/3/8 HOLE	
123-0008	1/O W/3/8 HOLE	
123-0009	1/O W/1/2/ HOLE	
123-0013	4/O W/3/8 HOLE	
123-0010	4/O W/1/2/ HOLE	

ACCESSORIES



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
102-0041	ALLEN WRENCH SET	
102-0042	CHUCK EJECTOR KEY	



TRU-WELD

STUD WELDING

TW-i Series

MADE IN THE USA



- Intuitive touchscreen interface with preset values
- Set-point discharge: unit discharges to chosen stud setting
- Universal input voltage eliminates having to re-tap the machine
- Capable of welding CD studs from 14-gauge to 3/8" flanged
- Contact and trigger indicators for fast troubleshooting
- Resettable stud/weld counter

SPECIFICATIONS

*Specifications are subject to change without prior notice

	TW-i250	TW-i250CP	TW-i321	TW-i375
Weld Range	14Ga → 1/4" SS	14Ga → 1/4" SS (Including Cup Head Pins)	14Ga → 5/16" SS	14Ga → 3/8" SS
Duty Cycle (Studs per Minute)	18 (1/4" Settings)	18 (1/4" Settings)	14 (5/16" Settings)	10 (3/8" Settings)
Weight (Power Supply Only)	18 lbs. (8Kg)	18 lbs. (8Kg)	21 lbs. (9.5Kg)	23 lbs. (10.4Kg)
Dimensions (LxWxH)	14" x 10.5" x 11.5" (356mm X 267mm X 292mm)			
Primary Power	110VAC @ 50/60Hz 15A Circuit 220VAC @ 50/60Hz 7.5A Circuit			
Charge Voltage	35 → 200VDC			

Complete System Includes:

**(1) TW-i Power Supply, (1) TWE Hand Tool (1) Ground Cable Assembly,
(1) Phenolic CD Foot, (2) 7" CD legs, and (1) Collet Adapter**



TRU-WELD

STUD WELDING

ACE-P100

MADE IN THE USA



The ACE-P100 incorporates the latest technology into a compact, rugged, and portable capacitor discharge pin welder. With an updated user interface and new system design, this unit has the capacity to weld pins up to 10-gauge and CD studs up to #10.

SPECIFICATIONS

SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE

Weld Range	Pins → up to 10GA Studs → up to #10
Duty Cycle	15-30 pins per minute
Weight	10.2 lbs.
Dimensions (LxWxH)	12.5" x 10.1" x 6.0"
Primary Power	Universal Input: 85-250VAC @ 50/60Hz Fusing Requirement: 10A
Charge Voltage	35-100VDC

SYSTEM FEATURES

- Less than 1 second recharge time for pin welding
- Intuitive touchscreen interface with preset values for fast, accurate, and repeatable weld settings
- Set-Point discharge: Unit discharges directly to a new set-point without discharging completely
- Universal input voltage: No need to re-tap the machine for 110 or 220 input voltages
- Low input voltage capability enables operation with long extension cords
- Contact and trigger indicators for fast troubleshooting of hand tool and weld cable maintenance issues
- Thermal and voltage protection indicators to protect the unit from damage due to overheating or poor input power
- Mounted in a rugged outer case for greater durability and appearance
- Hand tool has an adjustable spring to apply the correct spring pressure for every welding application
- Hand tool can be configured for "B" collets, "CI" collets, "Euro" collets, and standard tapered chucks

Complete System Includes:

(1) ACE-P100 Power Supply, (1) Ground Cable Assembly, (1) TWEGP Stud Gun, (1) Phenolic CD Foot, (2) 7" Legs, and (1) Collet Adapter



TRU-WELD

STUD WELDING

TW4300

PRO-TECH'D

Technology Inside

MADE IN THE USA



- Welds up to 1/2" diameter studs
- Ferrule-shielded and gas-shielded drawn arc system
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control
- **NEW** SMAW capabilities

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	Up to 1/2" Diameter Studs
<u>Duty Cycle (Studs / Minute)</u> Up to 1/4" Diameter Studs → 3/8" Diameter Studs → 1/2" Diameter Studs →	Unlimited 5 to 6 2 to 3
Dimensions (LxWxH)	22.4" x 11" x 12.6"
Weight	106lbs.
Input Voltage	230/460 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 50A 460V / 25A

Complete System Includes:

(1) TW4300 Power Supply, (1) TWE19000 Light Duty Stud Gun with 25' of #1AWG combo cable and (1) 15' Ground Cable Assembly



TRU-WELD

STUD WELDING

TW4400

PRO-TECH'D

Technology Inside

MADE IN THE USA



- Welds up to 5/8" diameter threaded studs
- Capable of welding 1/2" diameter studs with up to 150' of cable
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control
- **NEW** SMAW capabilities

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	Up to 1/2" Diameter Studs
<u>Duty Cycle (Studs / Minute)</u>	
Up to 1/4" Diameter Studs →	Unlimited
3/8" Diameter Studs →	7 to 8
1/2" Diameter Studs →	4 to 5
5/8" Diameter Studs →	2 to 3
Dimensions (LxWxH)	22.4" x 11" x 12.6"
Weight	125lbs.
Input Voltage	230/460 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 50A 460V / 25A

Complete System Includes:

(1) TW4400 Power Supply, (1) TWE19000 Light Duty Stud Gun with 25' of #1AWG combo cable and (1) 15' Ground Cable Assembly



TRU-WELD

STUD WELDING

TW5600

PRO-TECH'D

Technology Inside

MADE IN THE USA



- Fully integrated 1600A single gun stud welding system
- Enhanced duty cycle for production environments
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	1/4" to 3/4" Diameter Studs
<u>Duty Cycle (Studs / Minute)</u> Up to 3/8" Diameter Studs → 1/2" Diameter Studs → 5/8" Diameter Studs → 3/4" Diameter Studs →	Unlimited 22 to 24 9 to 10 4 to 5
Dimensions (LxWxH)	30" x 25" x 22"
Weight	445lbs.
Input Voltage	230/460/575 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 120A 460V / 60A 575V / 50A

Complete System Includes:

- (1) TW5600 Power Supply, (1) TWE17000 Heavy Duty Stud Gun
(1) 50' Starter Combo Cable, and (1) 25' Ground Cable Assembly**



TRU-WELD

STUD WELDING

TW5700

PRO-TECH'D

Technology Inside

MADE IN THE USA



- Fully integrated 1800A single gun stud welding system
- Enhanced duty cycle for production environments
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	1/4" to 7/8" Diameter Studs
<u>Duty Cycle (Studs / Minute)</u>	
Up to 3/8" Diameter Studs →	Unlimited
1/2" Diameter Studs →	22 to 24
5/8" Diameter Studs →	9 to 10
3/4" Diameter Studs →	4 to 5
7/8" Diameter Studs →	3 to 4
Dimensions (LxWxH)	30" x 25" x 22"
Weight	445lbs.
Input Voltage	230/460/575 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 120A 460V / 60A 575V / 50A

Complete System Includes:

- (1) TW5700 Power Supply, (1) TWE17000 Heavy Duty Stud Gun
(1) 50' Starter Combo Cable, and (1) 25' Ground Cable Assembly**



TRU-WELD

STUD WELDING

TW6800

PRO-TECH'D

Technology Inside

MADE IN THE USA



*Also available as dual gun

- Fully integrated single gun stud welding system
- Enhanced duty cycle for production environments
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	1/4" to 1" Diameter Studs
<u>Duty Cycle (Studs / Minute)</u> Up to 5/8" Diameter Studs → 3/4" Diameter Studs → 7/8" Diameter Studs → 1" Diameter Studs →	Unlimited 18 to 24 12 to 14 6 to 8
Dimensions (LxWxH)	36" x 29" x 28"
Weight	665lbs.
Input Voltage	230/460/575 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 180A 460V / 90A 575V / 80A

Complete System Includes:

**(1) TW6800 Power Supply, (1) TWE17000 Heavy Duty Stud Gun
(1) 50' Starter Combo Cable, and (1) 25' Ground Cable Assembly**



TRU-WELD

STUD WELDING

TW6950

PRO-TECH'D

Technology Inside

MADE IN THE USA



*Also available as dual gun

- Fully integrated 50Hz single gun stud welding system
- Enhanced duty cycle for production environments
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	1/4" to 1" Diameter Studs
<u>Duty Cycle (Studs / Minute)</u>	
Up to 5/8" Diameter Studs →	Unlimited
3/4" Diameter Studs →	18 to 24
7/8" Diameter Studs →	12 to 14
1" Diameter Studs →	6 to 8
Dimensions (LxWxH)	36" x 29" x 28"
Weight	760lbs.
Input Voltage	380/400 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	380V / 100A 400V / 100A

Complete System Includes:

**(1) TW6950 Power Supply, (1) TWE17000 Heavy Duty Stud Gun
(1) 50' Starter Combo Cables, and (1) 25' Ground Cable Assemblies**



TRU-WELD

STUD WELDING

TW6802

PRO-TECH'D

Technology Inside

MADE IN THE USA



- Fully integrated dual gun stud welding system
- Enhanced duty cycle for production environments
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	1/4" to 1" Diameter Studs
<u>Duty Cycle (Studs / Minute)</u> Up to 5/8" Diameter Studs → 3/4" Diameter Studs → 7/8" Diameter Studs → 1" Diameter Studs →	Unlimited 18 to 24 12 to 14 6 to 8
Dimensions (LxWxH)	36" x 29" x 28"
Weight	695lbs.
Input Voltage	230/460/575 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 180A 460V / 90A 575V / 80A

Complete System Includes:

- (1) TW6802 Power Supply, (2) TWE17000 Heavy Duty Stud Gun**
(2) 50' Starter Combo Cables, and (2) 25' Ground Cable Assemblies



TRU-WELD

STUD WELDING

TW6900

PRO-TECH'D

Technology Inside

MADE IN THE USA



*Also available in dual gun and 50Hz

- Fully integrated 3000A single gun stud welding system
- Enhanced duty cycle for production environments
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	1/4" to 1-1/4" Diameter Studs
Duty Cycle (Studs / Minute)	
Up to 5/8" Diameter Studs →	Unlimited
3/4" Diameter Studs →	22 to 24
7/8" Diameter Studs →	16 to 18
1" Diameter Studs →	12 to 14
1-1/4" Diameter Studs →	4 to 5
Dimensions (LxWxH)	36" x 29" x 28"
Weight	760lbs.
Input Voltage	230/460/575 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 200A 460V / 100A 575V / 90A

Complete System Includes:

**(1) TW6900 Power Supply, (1) TWE17000 Heavy Duty Stud Gun
(1) 50' Starter Combo Cable, and (1) 25' Ground Cable Assembly**



TRU-WELD

STUD WELDING

TW6902

PRO-TECH'D

Technology Inside

MADE IN THE USA



*Also available in single gun and 50Hz

- Fully integrated 3000A dual gun stud welding system
- Enhanced duty cycle for production environments
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	1/4" to 1-1/4" Diameter Studs
Duty Cycle (Studs / Minute)	
Up to 5/8" Diameter Studs →	Unlimited
3/4" Diameter Studs →	22 to 24
7/8" Diameter Studs →	16 to 18
1" Diameter Studs →	12 to 14
1-1/4" Diameter Studs →	4 to 5
Dimensions (LxWxH)	36" x 29" x 28"
Weight	875lbs.
Input Voltage	230/460/575 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 200A 460V / 100A 575V / 90A

Complete System Includes:

- (1) TW6902 Power Supply, (2) TWE17000 Heavy Duty Stud Guns**
(2) 50' Starter Combo Cables, and (2) 25' Ground Cable Assemblies



TRU-WELD

STUD WELDING

TW6922

PRO-TECH'D

Technology Inside

MADE IN THE USA



*Also available in single gun and 50Hz

- Fully integrated 3000A dual gun 2-wire stud welding system
- Enhanced duty cycle for production environments
- **NEW** PRO-TECH'D technology protects the gun circuitry
- **NEW** Improved user interface for more intuitive setup
- **NEW** Factory presets and user customizable presets
- **NEW** Improved weld control

SPECIFICATIONS

*Specifications are subject to change without prior notice

Weld Range	1/4" to 1-1/4" Diameter Studs
Duty Cycle (Studs / Minute)	
Up to 5/8" Diameter Studs →	Unlimited
3/4" Diameter Studs →	22 to 24
7/8" Diameter Studs →	16 to 18
1" Diameter Studs →	12 to 14
1-1/4" Diameter Studs →	4 to 5
Dimensions (LxWxH)	36" x 29" x 28"
Weight	875lbs.
Input Voltage	230/460/575 VAC 3-Phase 60Hz
Fusing Requirements (Slow Acting)	230V / 200A 460V / 100A 575V / 90A

Complete System Includes:

- (1) TW6902 Power Supply, (2) TWE17000N Heavy Duty Stud Guns
(2) 50' Starter Combo Cables, and (2) 25' Ground Cable Assemblies**



TRU-WELD

STUD WELDING

SJ-205-T4
MADE IN THE USA

Mobile Stud Welding System

The SJ-205-T4 is a complete mobile stud welding package that is fully compliant with the Tier IV emissions regulations. The system incorporates a heavy duty dual gun stud welder coupled with a Cummins diesel generator system which enables jobs to be done more effectively and efficiently.

SYSTEM FEATURES

- Dual 7000 pound axles
- Lightweight aluminum enclosure
- Easy access doors for generator and welder controls
- Battery trickle charger
- Engine block heater
- Fully insulated enclosure
- Electronic governor
- Surge brakes
- Four lifting points
- Built in 120 VAC outlets
- Lockable storage box
- Keyed access doors

SPECIFICATIONS

* Skid Mount Option Available

Generator Voltage	480 VAC, 3 Phase
Generator Power	256 KVA
Circuit Breakers	150 & 200A
Weight	9800 LBS
Dimensions (LxWxH)	217x78x100"

* Specifications Are Subject To Change Without Prior Notice

SYSTEM INCLUDES

**(1) Mobile Generator, (1) Dual Gun Power Supply, (2) HD Stud Guns,
(2) 50' Ground Assemblies, (4) 75' Combo Weld Cables**



TRU-WELD EQUIPMENT

6400 N. Honeytown Road
Smithville, OH 30043

(330) 725-7744 Phone
(330) 669-2473 Fax

TWE 17000 Heavy Duty Stud Gun

Made In the USA

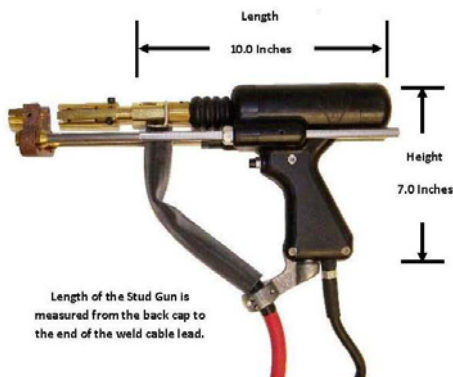


DESCRIPTION

The TWE17000 has been designed to fit comfortably for all hands, including when wearing a work glove. The neck of the handle has been tapered so that when grasped, the trigger can be accessed easily, without any unnecessary strain. The handle length allows for better balance of the stud gun and it keeps the welding cable and connector away from your hand, minimizing operator fatigue.

FEATURES

The TWE17000 heavy duty stud gun has a welding range from 1/8" through 1-1/4" diameter studs.



The TWE17000 is approximately 10.0" long from the weld cable to the back cap, and approximately 7" long from the top of the stud gun to the bottom of the handle. The overall weight of the stud gun is approximately 5.2 pounds (excludes 8.5 feet of 4/0 weld cable and 8 feet of control cable (This also excludes all connectors, legs, and foot piece.)).

The TWE17000 can be ordered to operate with any type of stud welding equipment. Simply specify the make and model of your equipment and we will provide you with a stud gun connection that is compatible with your unit, regardless of the manufacturer.

Order your TWE17000 Heavy Duty Stud Gun from your local TRU-WELD Equipment Distributor.



TRU-WELD EQUIPMENT

6400 N. Honeytown Road
Smithville, OH 44677

(330) 725-7744 Phone
(330) 669-2473 Fax

TWE 18500 Medium Duty Stud Gun



Made In the USA

DESCRIPTION

The TWE85000 has been designed to fit comfortably for all hands, including when wearing a work glove. The neck of the handle has been tapered so that when grasped, the trigger can be accessed easily, without any unnecessary strain. The handle length allows for better balance of the stud gun and it keeps the welding cable and connector away from your hand, minimizing operator fatigue.

FEATURES

The TWE18500 is approximately 8.5" long from the weld cable to the back cap, and approximately 7" long from the top of the stud gun to the bottom of the handle. The overall weight of the stud gun is approximately 4.8 pounds (excludes 8.5 feet of 2/0 weld cable and 9 feet of control cable. This also excludes all connectors, legs, and foot piece.)

The TWE18500 can be ordered to operate with any type of stud welding equipment. Simply specify the make and model of your equipment and we will provide you with a stud gun connection that is compatible with you unit, regardless of the manufacturer.

Order your TWE18500 Medium Duty Stud Gun from your local TRU-WELD Equipment Distributor.



TRU-WELD EQUIPMENT

6400 N. Honeytown Road
Smithville, OH 44677

(330) 725-7744 Phone
(330) 669-2473 Fax

TWE 19000 Light Duty Stud Gun



Made In the USA

DESCRIPTION

The TWE19000 has been designed to fit comfortably for all hands, including when wearing a work glove. The neck of the handle has been tapered so that when grasped, the trigger can be accessed easily, without any unnecessary strain. The handle length allows for better balance of the stud gun and it keeps the welding cable and connector away from your hand, minimizing operator fatigue.

FEATURES

The TWE19000 is approximately 8.0" long from the weld cable to the back cap, and approximately 7" long from the top of the stud gun to the bottom of the handle. The overall weight of the stud gun is approximately 4.2 pounds (excludes 8.5 feet of 2/0 weld cable and 9 feet of control cable. This also excludes all connectors, legs, and foot piece.)

The TWE19000 can be ordered to operate with any type of stud welding equipment. Simply specify the make and model of your equipment and we will provide you with a stud gun connection that is compatible with you unit, regardless of the manufacturer.

Order your TWE19000 Light Duty Stud Gun from your local TRU-WELD Equipment Distributor.



A Division of Tru-Fit Products Corporation
460 Lake Road
Medina, OH 44256
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