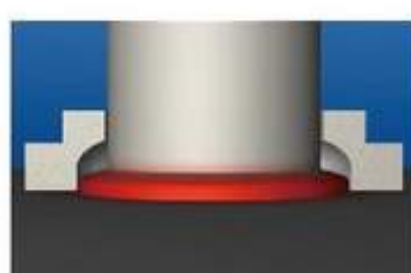




ZHUANCHENG STUD WELDING



电容放电点焊螺柱
CAPACITOR DISCHARGE
STUD WELDING



长周期拉弧螺柱
ARC-DRAWN ARC
STUD WELDING



短周期弧焊螺柱
SHORT CYCLE DRAWN
ARC STUD WELDING

螺柱焊钉选型目录

WELDING STUDS CATALOG

2025



专成螺柱焊
ZHUANCHENG
STUD WELDING

THIS CATALOG SHOWCASES OUR LATEST ASSORTMENT OF PREMIUM-GRADE STUDS AND FERRULES AVAILABLE IN THE EMEA REGION, METICULOUSLY DESIGNED TO CATER TO THE REQUIREMENTS OF ANY FASTENING APPLICATION. WITH A VAST ARRAY OF SIZES AND MATERIALS TO SELECT FROM, YOU CAN BE CONFIDENT IN DISCOVERING THE IDEAL SOLUTION TO MEET YOUR SPECIFIC STUD WELDING NEEDS.

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SERVICE AND TECHNICAL SUPPORT CONTACT
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公司简介 COMPANY PROFILE

专成螺柱焊接是一家专业从事于研究、制造螺柱焊钉，螺柱焊机设备的销售、租赁和售后服务为一体的企业。公司在螺柱焊接螺柱领域23年的生产服务经验，持续扩展的高性能生产设备的大量投资，专成旨在不断提高焊接螺柱产品的质量以及在售前和售后对客户的服务。

我们将会为客户通过提供焊接工艺来支持我们的客户对螺钉合理的选型，我们还将提供螺柱焊培训支持、焊接故障排除；以及螺柱焊机的维修。我们相信，质量、交货、价格、支持和服务对于赢得每个客户的业务至关重要。我们努力提供您应得的响应迅速且准确的个性化服务。

如果您想购买焊接螺柱和螺柱焊接设备，我们拥有专业的螺柱焊钉生产经验和螺柱焊设备技术支持，可以为您的应用推荐更合适的产品。

ZhuanCheng Stud Welding Company is engaged in the research, manufacture, Sales and After-sales support of welding stud and equipment products. Thanks to our 23 years experience in the welding studs field, a high-tech production process in continuous expansion and massive investments, ZhuanCheng aims to achieve continuous improvement in the quality of the studs products and in the service to our customers, before and after the sale. Our products include a full line of welding studs, standard and custom accessories and a comprehensive line of stud welding equipment for rent and purchase.

We support our customers' by providing and answering stud welding and studs technical questions, providing welding process support and training; We also can supplying equipment parts and performing equipment repairs. We believe that quality, delivery, price, support and service are paramount to earning every customer's business. We strive to provide the responsive and accurate personalized service you deserve.

If you are looking to purchase stud welding equipment and studs, we have the application expertise and equipment knowledge to recommend and explain the equipment options for your applications. We believe this leads to the customer making an informed decision that is the best for their business at that point in time.

We appreciate the opportunity to work for you and appreciate every order we receive. Feel free to contact us at any time on any day.

发展为客户信赖和喜爱的
螺柱焊品牌供应商

Develop into a trusted and beloved
customer base Supplier of stud welding brand

”

企业文化

CORPORATE CULTURE

目标 TARGET

打造成为国内螺柱焊接
设备领域实力派供应商

Build into a domestic stud welding industry
Powerful suppliers in the field of equipment

理念 IDEA

做实、做大、做强

Be solid, bigger, and stronger

使命 MISSION

提供有竞争力螺柱焊解决方
案和服务，为客户创造价值

Provide competitive stud welding solutions
Creating value for customers through cases and services

愿景 VISION

发展成为客户信赖和喜
爱的螺柱焊品牌供应商

Develop into a trusted and happy customer base
Love's stud welding brand supplier

精神 SPIRIT

专心、专注、专业

Focused, dedicated, and professional

质量系统

QUALITY SYSTEM

Quality system

Quality means putting the customer first, and having the customers changing needs and expectations as your primary goal.



Certifications

Our quality system is certified

- ISO 9001:2015
- ISO 14001:2015
- ISO 45001:2018
- IATF-16949:2016



Highest productivity and manufacturing quality

In an increasingly competitive, unpredictable market, success is only possible if the customer knows that your quality is high, and will remain the same over time. To reach this goal, every productive process is controlled in real time through monitoring systems which detect process failures. In case of production problems (e.g. tool breakage or ejection failures), they stop the machine early.

Our goal is achieving the highest productivity and manufacturing quality of our products.

We have machines for



Tensile and shear testing



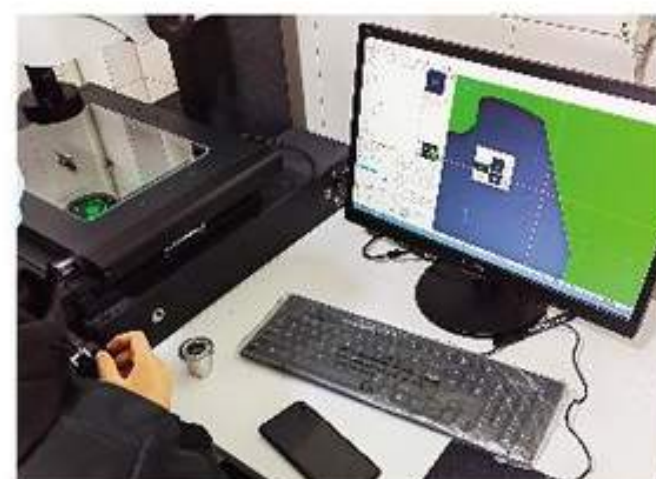
Dimensional checking



Hardness testing



Mechanical testing



适用场景

STUD WELDING APPLICABLE SCENE



船舶建造

SHIP CONSTRUCTION



汽车

CAR INDUSTRY



机车

RAIL INDUSTRY



石化行业

PETRIFACTION INDUSTYR



核电

NUCLAER POWER



新能源

NEW ENERGY



港口机械

HARBOUR MACHINERY



厨房电器

KITCHEN APPLIANCE



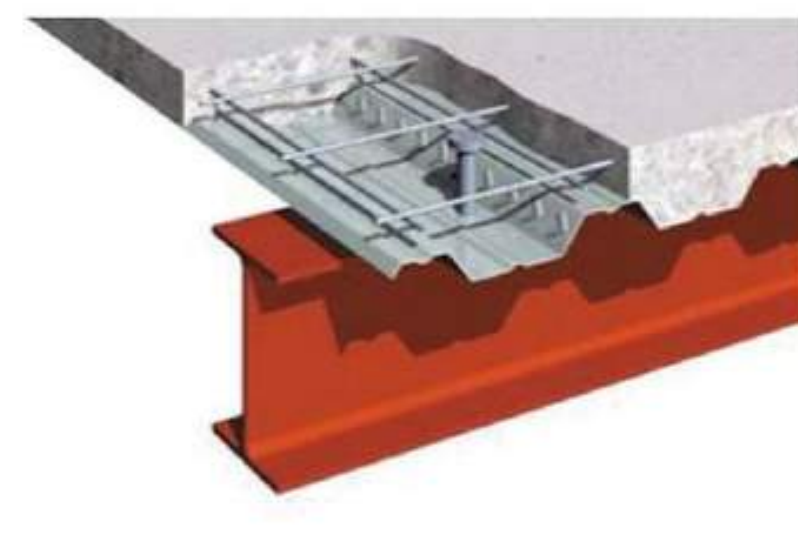
电梯

ELEVATOR INDUSTRY



工程机械

CONSTRUCTION MACHINERY



建筑行业

BUILDING CONSTRUCTION



变压器

TRANSFORMER ASSEMBLY



电力柜体

ELECTRICITY CABINET



锅炉工业

BOILER INDUSTRY



风电建设

WIND POWER

企业荣誉

CONTENT HERE

公司取得国内发明专利4项，实用新型专利25项，软件著作权6项。

公司获得“江苏省科技型中小企业”，“江苏省民营科技型企业”，“江苏省高新技术企业”等荣誉称号。

公司产品通过IATF-16949：2016，ISO9001：2015，ISO14001：2008，ISO45001：2018等认证。



发明专利 4项



软件著作权 6项



实用新型专利 25项



我们的优势

OUR ADVANTAGES



源头厂家

SOURCE MANUFACTURER



质量保证

QUALITY ASSURANCE



支持定制

SUPPORT CUSTOMIZATION





01 技术团队

TECHNICAL TEAM

我们拥有一批多年从事螺柱焊钉，螺柱焊机设计制造的工程技术人员和经验丰富的一线技术人员。随着市场经济不断深入和加工技术不断进步，我厂的技术革新和设备改造日新月异，生产规模逐渐扩大，已形成集产品研发、生产、销售、服务为一体的综合型科技企业。

We have a group of engineering and technical personnel who have been engaged in the design and manufacturing of stud welding nails and stud welding machines for many years, as well as experienced front-line technical personnel. With the continuous deepening of the market economy and the advancement of processing technology, our factory's technological innovation and equipment transformation are advancing rapidly, forming a comprehensive technology enterprise integrating product research and development, production, sales, and service.

02 质量保证

QUALITY ASSURANCE

公司生产设备精良，技术力量雄厚，进行严格的质量控制。严格按照标准和用户需求组织生产。以完善的设备、过硬的产品质量，产品畅销海内外各地，深得用户信赖和好评，选择我们的产品就等于选择了可靠保证！

The company has excellent production equipment, strong technical strength, and strict quality control. Strictly organize production according to standards and user needs. Our factory has perfect equipment and excellent product quality. Our products are sold well all over the country and have won the trust and praise of users. Choosing our products is equivalent to choosing a reliable guarantee for the project!





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CERAMIC FERRULES

螺柱焊概述 STUD WELDING GENERAL

螺柱焊是将金属螺柱或类似零件连接到工件的一种工艺。焊接可以通过以下三种不同的焊接工艺来完成，包括电容器放电、拉弧和短周期气体。

以上三种螺柱焊接方法主要称为ARC和CAPACITOR DISCHARGE（简称“CD”）。这三种方法之间的区别涉及用于提供焊接电流/能量的电源和螺柱设计。螺柱电弧焊所需的设备由直流电源、焊枪或焊头以及焊索组成。技术上称为螺柱电弧焊的工艺通常称为“螺柱焊”。

电弧螺柱焊接方法、工艺、设备、焊接螺柱、配件和相关产品均会在本目录中进行详细介绍。

Stud Welding is a general term for joining a metal stud or similar part to a work piece. Welding can be done by following three different welding processes including Capacitor Discharge, Draw Arc and Short Cycle With Gas.

Above Three stud welding methods are majorly called ARC and Capacitor Discharge (usually “CD” for brevity). The difference between these three methods involves the Power Source used to provide the welding current / energy and the stud design. The equipment required to STUD ARC WELD is composed of a direct current power supply, a weld gun or weld head and the weld cables.

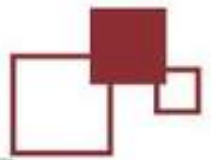
The process technically known as STUD ARC WELDING is generally known as “STUD WELDING.” STUD ARC WELDING methods, processes, equipment, weld studs, accessories and related products are covered in this product literature.

焊接过程 WELDING PROCESS

- | | |
|-----------|--|
| · 电容式放电焊接 | Capacitor Discharge Welding (CD Welding) |
| · 拉弧焊接 | Drawn Arc Stud Welding |
| · 短周期螺柱焊 | Short Cycle Stud Welding—(Gas Arc) |

螺柱焊优势 STUD WELDING ADVANTAGES

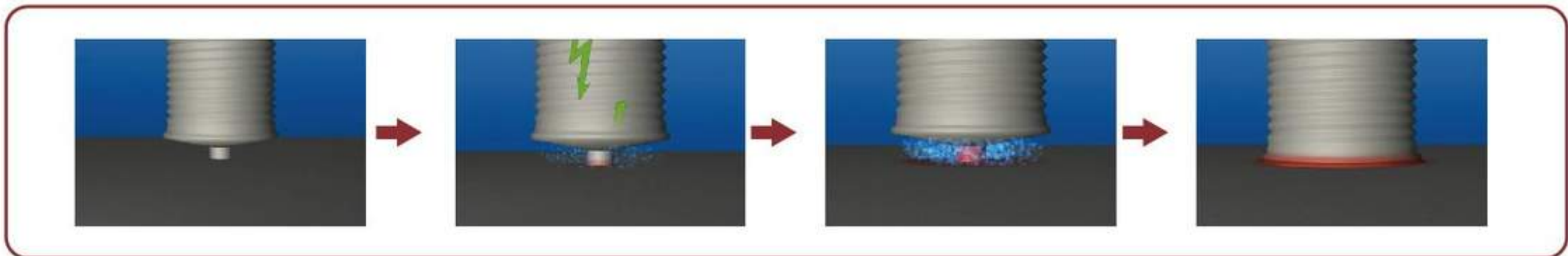
- 节省成本：减少人工作业时间、材料损耗。
 - 焊缝强度：焊缝通常比螺柱和母材强度更坚固。
 - 工艺过程：简单的操作过程以及瞬间的工作循环时间。
 - 母材：对母材的发热和变形影响达到最小。
 - 板厚：适用于非常薄的金属（CD和短周期方法）。
 - 反面痕迹：金属板面被焊接后无反面痕迹。
- Cost savings: reduced labor time, materials and secondary operations.
·Weld strength: weld is typically stronger than the stud and base material.
·Process: single sided and split second cycle time.
·Deformation: Minimal heating and warpage .
·Metal Thickness: Suitable for very thin metals(CD and Short Cycle methods).
·Base metal: No reverse side marking (CD Method).



保护方式 SHIELDING MODE

- 气体保护 GAS
- 磁环保护 Ferrule
- 气体+磁环保护 Gas + Ferrule

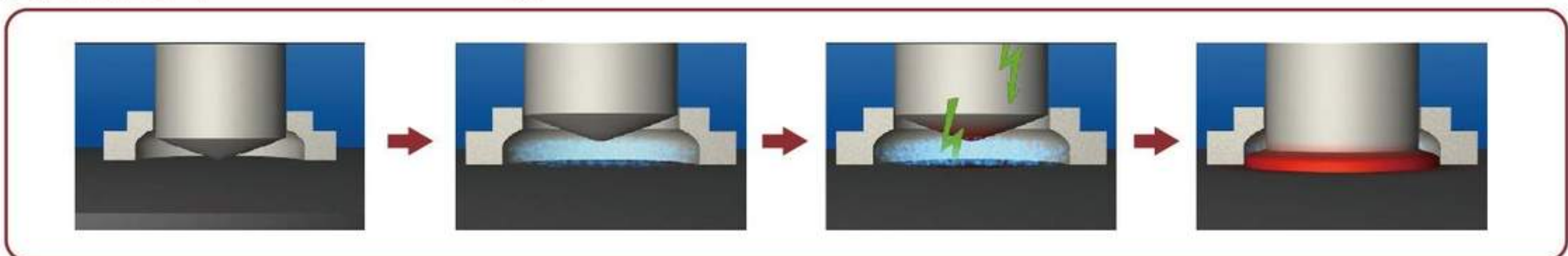
电容式焊接过程/ Capacitor discharge stud welding process



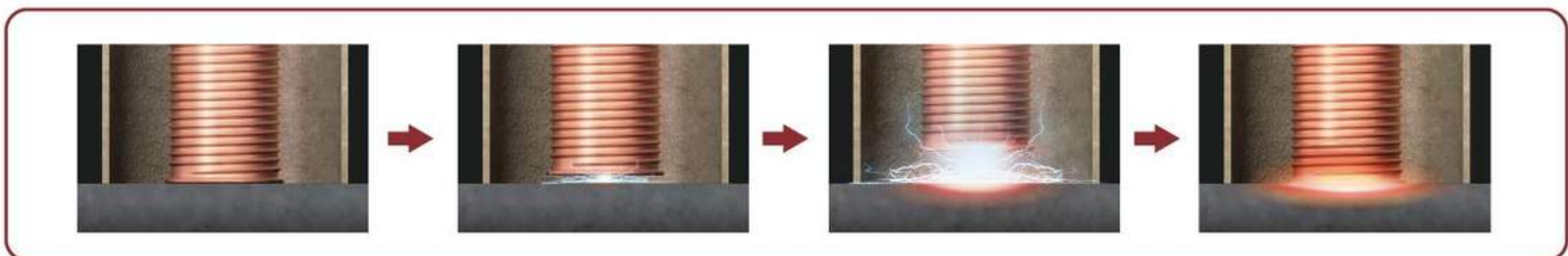
气体保护焊接过程/ Gas stud welding process



磁环保护焊接过程/ Ferrule stud welding process



短周期焊接过程/ Short cycle stud welding process



螺柱焊钉概述 OVERVIEW OF STUD WELDING NAILS

焊接螺钉（又称弧焊螺钉，碰焊螺柱，植焊螺钉等），由于其特殊的高效焊接工艺。目前已被广泛应用在汽车，电气，家电，石化，医疗、机车，造船，核电，锅炉，新能源等行业。“常州专成”是国内较早开发，生产焊钉的专业厂家之一，也是目前国内少数几家既从事螺柱焊机的研制和开发，又拥有螺柱焊钉的生产，销售的实体企业。

“专成牌”螺柱外形尺寸严格按照ISO13918，ISO14555和GB902.4标准执行，文中所涉及的螺柱长度都是定义为焊后长度。由于焊钉的外形尺寸大小将直接影响焊接强度（如虚焊，偏弧等缺陷）。因此，焊接螺钉尺寸的一致性和生产过程的稳定性对焊接强度的质量起着关键作用。

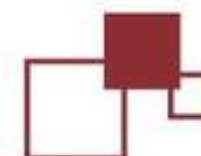
本文所述的各种规格焊接螺柱都是按照国际标准ENISO13918（2018）和ENISO14555（2017）来执行生产制造和验证。本文中所使用的名词术语、代（符）号以及商品名称都是遵循ISO标准。

Welding studs (also known as arc welding screws, welding bolts, implant welding studs, etc.), due to their special and efficient welding process. it has been widely used in industries such as automotive, electrical, home appliances, petrochemicals, medical, locomotive, shipbuilding, nuclear power, boilers, and new energy. Changzhou Zhuancheng is one of the earliest professional manufacturers in China to develop and produce stud welding machines. It is also one of the few physical enterprises in China that not only engages in the research and development of stud welding machines, but also produces and sells stud welding machines.

The external dimensions of the "specialized brand" bolts are strictly in accordance with ISO13918, ISO 14555, and GB902.4 standards. The length of the studs mentioned in the article is defined as the length after welding. Due to the direct impact of the external dimensions of the welding nail on the welding strength (such as defects such as virtual welding and arc deviation). Therefore, the consistency of welding studs size and the stability of the production process play a key role in the quality of welding strength.

The various specifications of welded studs described in this article are manufactured and validated in accordance with international standards EN ISO 13918 (2018) and EN ISO14555 (2017). The terminology, symbols, and product names used in this article comply with ISO standards. When listing products in this article, try to use pictures and tables to express product content as much as possible, in order to facilitate customers to identify and order the products they need.

Welding technique	Type of stud	Symbol for stud	Symbol for ceramic ferrule	Welding Process
Stud welding with tip ignition - CD	Threaded stud	PT	-	Capacitor Discharge with 220/110 Volt AC, Single Phase
	Unthreaded stud	UT	-	Capacitor Discharge with 220/110 Volt AC, Single Phase
	Stud with internal thread	IT	-	Capacitor Discharge with 220/110 Volt AC, Single Phase
Drawn arc stud welding with ceramic ferrule or shielding gas - ARC	Threaded stud with reduced shaft	RD	RF	Arc welding with 380 Volt AC, Three Phase
	Virtually fully-threaded stud	MD	UF	Arc welding with 380 Volt AC, Three Phase
	Partially threaded stud	PD	PF	Arc welding with 380 Volt AC, Three Phase
	Unthreaded stud	UD	UF	Arc welding with 380 Volt AC, Three Phase
	Stud with internal thread	ID	UF	Arc welding with 380 Volt AC, Three Phase
	Shear connector	SD	UF/DF	Arc welding with 380 Volt AC, Three Phase
Short cycle drawn arc stud welding - SC	Threaded stud with flange	PS	-	Arc welding with 380 Volt AC, Three Phase
	Unthreaded stud with flange	US	-	Arc welding with 380 Volt AC, Three Phase
	Stud with internal thread an flange	IS	-	Arc welding with 380 Volt AC, Three Phase



材料

MATERIAL SPECIFICATIONS

“专成牌”焊接螺柱材质主要围绕低碳钢，不锈钢（304、316、321、2205）和铝合金（ALMG3）三种材料生产焊接螺柱，以满足全球客户的要求。下文列出了几种常见焊接材料的属性（规格和规范要求）。列出了每种焊接螺柱所用材料的物理要求和化学特性，这些属性和特性适用于任何尺寸或形状的螺柱，公司还可以为客户提供合格证书、原材料报告及物理特性报告等。

Changzhou Zhuancheng produces weld studs composition of 3 major different materials to meet global customer requirements. The following common material properties are listed, as specified by the referenced specification sheets and construction codes. The stated physical requirements and chemical properties listed apply regardless of stud size or shape. Certificates of conformance, chemical analysis and physical properties are available upon request.

低碳钢 MILD STEEL STUDS

低碳钢螺柱严格遵循ISO13918和ASTM标准进行管理和生产；低碳钢螺柱的化学成分如下表所示。

All the studs manufactured of stainless steel conform to ISO 13918 and ASTM specifications. Studs can be manufactured from other weldable stainless steel alloys according to customers' special requirements. Stainless Steel chemical composition as below chart show.

Element	Minimum wt%	Maximum wt%
C	0.08	0.23
Mn	0.30	0.90
P	-	0.04
S	-	0.05

铝螺柱 ALUMINUM STUDS

公司主要以ALMG3系列中的5356，5754，5019和6061等材料进行铝螺钉的生产，其化学成分元素参见下表所示。

Changzhou Zhuancheng manufactured aluminum studs are made from Aluminum alloysALMg3 series as 6061,5356,5754 and 5019 etc. The chemical composition and physical properties of these alloys are shown below.

Element	Gas Arc, Stored Arc		Drawn				Capacitor Discharge	
	Alloy 1100 ASTM B211		Alloy 5356		Alloy 5086 ASTM B211		5754	
	Minimum wt%	Maxinmun wt%	Minimum wt%	Maxinmun wt%	Minimum wt%	Maxinmun wt%	Minimum wt%	Maxinmun wt%
Al	99	-	93.05	95.34	93.15	96.25	94.35	95.35
Cr	-	-	0.05	0.20	0.05	0.25	-	0.3
Cu	0.05	0.20	-	0.10	-	0.10	-	0.1
Mn	-	0.05	0.05	0.20	0.20	0.70	-	0.5
Si	N/A	N/A	-	0.25	-	0.40	-	0.4
Fe	N/A	N/A	-	0.40	-	0.50	-	0.4
Si+Fe	-	0.95	N/A	N/A	N/A	N/A	N/A	N/A
Zn	-	0.10	-	0.10	-	0.25	-	0.2
Mg	-	-	4.50	5.50	3.50	4.50	2.6	3.6
Ti	-	-	0.06	0.20	-	0.15	-	0.15

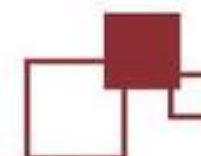
不锈钢螺柱 STAINLESS STEEL STUDS

不锈钢螺柱的生产将严格遵循ISO13918和ASTM标准来执行生产，除了一些常规的不锈钢材质外，我司还会根据一些客户的特殊要求去定制一些其它合金的不锈钢螺柱来满足特殊客户的需求，不锈钢螺柱的化学成分参照下表所示。

All the studs manufactured of stainless steel conform to ISO 13918 and ASTM specifications. Studs can be manufactured from other weldable stainless steel alloys according to customers' special requirements. Stainless Steel chemical composition as below chart show.

Element	302HQ		304HC		31603(316L)	
	Minimum wt%	Maxinmun wt%	Minimum wt%	Maxinmun wt%	Minimum wt%	Maxinmun wt%
C	-	0.08	-	0.03	-	0.03
Cr	17.00	19.00	18.00	20.00	16.00	18.00
Ni	8.00	10.00	8.00	12.00	10.00	14.00
Mn	-	2.00	-	2.00	-	2.00
Cu	3.00	4.00	2.00	4.00	-	-

Stud types		Abbreviations for studs	Material	Mechanical Properties Tensile Strength Rm Yield Strength, 0.2% (MPa), Re0.2 Elongation (ε)
Capacitor discharge Studs	Threaded stud	PT	Steel 4.8	Rm ≥ 450 N/mm ² , Re ≥ 350 N/mm ² , ε > 17%
	Unthreaded stud	UT	A2-50, A2-70 A4-50, A4-70	500 N/mm ² < Rm ≤ 780 N/mm ² , Re ≥ 245 N/mm ² , ε > 20%
	Stud with internal thread	IT	EN AW-ALMg3 EN AW-5754	Rm ≥ 230 N/mm ²
Drawn arc Studs	Partially threaded stud	PD MD	Mild steel 4.8	Rm ≥ 450 N/mm ² , Re ≥ 350 N/mm ² , ε > 17%
	Threaded stud with reduced shaft	RD	A2-50, A2-70 A4-50, A4-70	500 N/mm ² < Rm ≤ 780 N/mm ² , Re ≥ 245 N/mm ² , ε > 20%
	Unthreaded stud (Pin)	UD		
	Stud with internal thread	ID	EN AW-ALMg3 EN AW-5754	Rm ≥ 230 N/mm ²
	Shear connectors	SD	ML15	Rm ≥ 450 N/mm ² , Re ≥ 350 N/mm ² , ε > 15%,
Short Cycle Studs	Threaded stud with flange	PS	Steel 4.8	Rm ≥ 450 N/mm ² , Re ≥ 350 N/mm ² , ε > 17%,
	Pin with flange	US		
	Internal thread With flange	IS	A2-50, A2-70 A4-50, A4-70	Rm ≥ 500 N/mm ² , Re ≥ 245 N/mm ² , ε > 20%



螺纹要求

THREADS REQUIREMENTS

公司目前具备美制和公制的所有规格的螺纹生产能力，对于客户的特殊螺纹要求，确定订单后会单独进行安排生产，不同螺柱的螺纹要求参见下表。螺柱在生产和运输过程中，螺纹会产生较小的损伤如磕碰凹陷、缺口和撞痕等缺陷，可能会影响螺纹规的检验，这些情况目前无法100%避免。这些存在于螺柱外观表面的缺陷和损伤，在不影响零件本身功能的情况下，参照ISO6157标准在一定范围界限内都可接受。

UNC and Metric threads can all be manufactured by Zhuancheng Company. Other threads are available upon request. During thread production, small overlaps and/or profile deviations can occur - during the further production processes (coating, transport), minor damages such as dents, nicks and impact marks that impede the free movement in threaded gauges and in mating threads are unavoidable. These production-related surface defects / damages are permissible within certain limits according to ISO6157.

Thread Type	External Thread	Internal Thread
Metric Threads	Class 6g	Class 6H
Imperial threads-Coarse	UNC-2A	UNC-2B
Imperial threads-Fine	UNC-2A	UNC-2B

螺柱长度

STUD LENGTH

本文中所有描述的螺柱长度都是焊接后的长度，焊接螺柱在被焊接完后，螺柱的长度会由于焊接工艺的不同，导致螺柱长度会有所缩短（即焊后长度）。不同规格的螺柱，在不同的焊接工艺下，焊接后的缩短尺寸参照下表（仅供参考）。

The length dimensions (L) depicted throughout this catalog are the overall length of the stud Before Weld. The After Weld stud length will be shorter based on the stud diameter as below chart show.

Length Reduction After Weld		
Stud Diameter	Weld Process	Length Reduction
M3 through M6 6-32 through 1/4-20,	Stored Arc	0.8-1mm
M6 and 6mm diameter studs	Electric Arc	2mm
M8, 8mm, M10, 10mm, and M12 diameter studs	Electric Arc	3mm
12mm, M16, and 16mm diameter studs	Electric Arc	4mm
M20, 19mm, and 20mm diameter studs	Electric Arc	5mm
M24, 22mm, and 24mm diameter studs	Electric Arc	6mm
3/16" through 1/2" diameter studs	Electric Arc	1/8"(3mm)
5/8" through 7/8" diameter studs	Electric Arc	3/16"(5mm)
1" diameter or larger studs	Electric Arc	1/4"(6mm)

引弧剂 FLUX

引弧剂的质量是保证稳定的焊接质量及一致性的重要影响因素。当螺柱的直径38MM或者更大，建议使用带引弧剂的螺柱，当螺柱的直径 $\leq 6\text{MM}$ 以下，考虑到成本的影响因素，不建议客户使用带引弧剂的螺柱。

Flux quality is an essential factor for obtaining stable and consistent weld results. Generally, our company advise the Studs diameter exceed 38mm or more larger, it's need include a solid aluminum flux. Diameter less than 6mm Smaller diameter studs can be supplied with or without a solid aluminum flux per customer request or according to our company design and suggestions.

表面处理 SURFACE PLANTING

螺柱表面处理的目的是为了提高螺柱的耐腐蚀性。我司生产的电容式焊接螺钉（PT、UT、IT）通常采用表面0或者镀锌工艺。镀层厚度通常在3到5UM之间。电容式点焊螺柱表面采用镀铜工艺，既保证焊接质量的同时又达到了防锈功能。短周期弧焊螺柱，目前常采用镀铜和镀锌两种工艺（强度等级有4.8、6.8和8.8）。不锈钢和铝螺柱，我们保持材料的原始色泽，生产完后进行清洗处理。

Plating is useful to enhance the stud's corrosion resistance capability. Thread Studs and studs with internal thread (PT, UT, IT) made of mid steel are normally be copped with galvanized or copper coating. Layer thickness is between 3 and 5 um normally. The following types of surface protection are available.



· 镀铜 Copper Plating



· 镀锌 Zinc Plating



· 镀镍 Nickel Plating

打造成为国内螺柱焊 领域实力派供应商

包装 PACKAGING



针对螺柱的包装，我们会提供一种灵活的包装方式去满足代理商和客户不同要求。螺柱将使用内外2层包装防护的方式来包装，先用环保型可降解的透明袋子进行封装，然后被装入纸箱中进行打包，最后将统一堆放至满足出口要求的熏蒸托盘上进行发货。

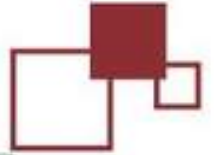
Offering a flexible packaging service for all in-stock studs aim to convenient to agent and customers' special requirements. Generally, the studs will be packed with a recyclable see-through plastic bag firstly, then it will put into the carton box packaging finally. Once received orders, operators will put the studs packaged with carton into fumigation wood pallet.

发货 DELIVERIES

本目录中常规的标准螺柱，我们在收到订单后，在3天内会根据客户要求，让客户收到货物并使用。对于非常规或者非标的螺柱，我们需要一个交货期来应付原材料的短缺或者生产设备的订单冲突等情况。如果发生这种情况，我们会进行生产工艺和设备产能分析，然后再反馈和书面承诺客户交货期。

Delivery on stock items will be made within 24 hours following the date of order receipt. Non-stock items or special items may require a lead time due to material availability and machining occupy. In this case we will be acknowledged in writing with a delivery promise after reviewing machining capacity and process analysis.





如何订购 HOW ORDERING ZHUANCHENG STUDS

当需要订购时，请指定详细信息，例如螺柱的类型、材料、直径、表面要求和长度（焊接后）。如果有可能的话，请告知我们螺柱的应用领域，以便我们可以推荐更合适的螺柱使用。每个型号的螺柱都被单独进行了编号，其每个数字都代表其独特的意义，如下表所示。

When need ordering, please specify detail info for example Type, Material, Diameter, Surface requirements and length (Beford welding).. if possible, please share us application area then we can suggest reasonable studs. Each studs is coded separately and each digit represents its own unique significance as below table show.

Item 1	Item 2	Item 3	Item 4	Item 5	Item 6	Item 7	Item 8	Item 9	Item 10
Stud type		Matreial	Surface	Thread form	Thread Type	Thread Size		Thread Length	
01	PT	1: Mid steel 2:Stainless steel 3:Aluminum	1:Copper 2:Nickel 3: Zinc 4: original	1: Thread 2:Internal thread 3: Unthread	0:cyclindrical 1:Metric 2:Unic	M3,M4,M5...M12,M16... Unc1/4,Unc3/8,Unc3/16...		Length	
02	IT								
03	UT								
04	Pin								
05	PD								
06	RD								
07	MD								
08	ID								
09	UD								
10	PS								
11	IS								
12	US								
13	Non-standard								

Note: If your desired stud is missing in the existing versions, please contact us; we look forward to developing your stud together with you.

示例 Examples:

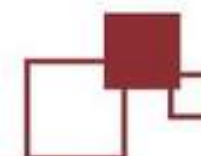
如果要订购M6 × 25的表面镀铜的碳钢电容式螺柱，那么根据螺柱编号定义规则，其订购编号为0111-1106-25。

If ordering capacitor discharge Threaded stud M6 x 25, material steel 4.8 copper coated, Order No. 0111-1106-25.

0111-1106-25

螺柱长度 Thread Length
 螺纹尺寸 Thread Size
 螺纹类型 Thread Type
 螺纹形状 Thread form
 表面处理 Surface
 产品材质 Matreial
 螺柱类型 Stud type

专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



PT

外螺纹点焊螺柱 Threaded studs type PT

Material: Mild steel 4.8

Surface: Copper plated



d ₁	l ₁ +0.6	d ₂ ±0.2	d ₄ ±0.08	l ₃ ±0.05	h ₅ max	h ₁	α±2°
M3	see table	4.5	0.6	0.55	0.6	0.7-1.4	174°
M4		5.5	0.65				
M5		6.5	0.75	0.8	1.0		
M6		7.5					
M8		9.0		0.85	1.5	0.8-1.4	
M10		10.7	1.2-1.8				

l_1 (mm)	Dimater													
	M3		M4		M5		M6		M8		M10		M12	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0111-1103-06	0.28	0111-1104-06	0.50	—	—	—	—	—	—	—	—	—	—
8	0111-1103-08	0.40	0111-1104-08	0.65	0111-1105-08	6.10	0111-1106-08	1.45	—	—	—	—	—	—
10	0111-1103-10	0.50	0111-1104-10	0.85	0111-1105-10	1.25	0111-1106-10	1.80	0111-1108-10	3.29	—	—	—	—
12	0111-1103-12	0.60	0111-1104-12	0.95	0111-1105-12	1.55	0111-1106-12	2.40	0111-1108-12	3.95	—	—	—	—
16	0111-1103-16	0.70	0111-1104-16	1.15	0111-1105-16	1.88	0111-1106-16	2.75	0111-1108-16	5.20	0111-1110-16	10.6	—	—
20	0111-1103-20	0.90	0111-1104-20	1.55	0111-1105-20	2.40	0111-1106-20	3.30	0111-1108-20	6.50	0111-1110-20	10.6	0111-1112-20	15.68
25	0111-1103-25	1.06	0111-1104-25	2.00	0111-1105-25	3.00	0111-1106-25	3.50	0111-1108-25	7.85	0111-1110-25	13	0111-1112-25	19.25
30	0111-1103-30	1.12	0111-1104-30	2.40	0111-1105-30	3.65	0111-1106-30	4.35	0111-1108-30	9.40	0111-1110-30	15.4	0111-1112-30	22.82
35	0111-1103-35	1.30	0111-1104-35	2.80	0111-1105-35	4.26	0111-1106-35	5.23	0111-1108-35	10.80	0111-1110-35	17.8	0111-1112-35	26.38
40	0111-1103-40	1.48	0111-1104-40	3.20	0111-1105-40	4.87	0111-1106-40	6.95	0111-1108-40	12.30	0111-1110-40	20	0111-1112-40	29.95
45	0111-1103-45	1.67	0111-1104-45	3.60	0111-1105-45	5.50	0111-1106-45	7.82	0111-1108-45	13.83	0111-1110-45	22.6	0111-1112-45	33.52
50	0111-1103-50	1.85	0111-1104-50	4.00	0111-1105-50	6.10	0111-1106-50	8.90	0111-1108-50	15.30	0111-1110-50	25	0111-1112-50	37.08
55	0111-1103-55	2.05	0111-1104-55	4.40	0111-1105-55	6.73	0111-1106-55	9.40	0111-1108-55	16.83	0111-1110-55	27.55	0111-1112-55	40.64
60	0111-1103-60	2.25	0111-1104-60	4.80	0111-1105-60	7.350	0111-1106-60	10.65	0111-1108-60	18.36	0111-1110-60	29.96	0111-1112-60	44.21

Note:

1. All the wt digit in above table unit is Kg.

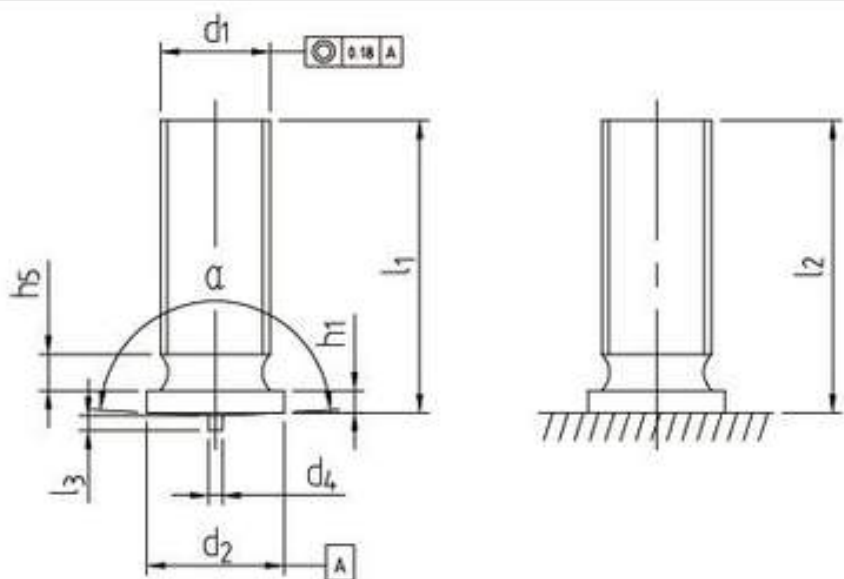
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

PT

外螺纹点焊螺柱 Threaded studs type PT

Material: Stainless steel (A2-50,A4-50)

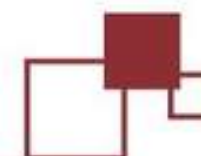


d_1	$l_1+0.6$	$d_2\pm0.2$	$d_4\pm0.08$	$l_3\pm0.05$	$h_5\max$	h_1	$a\pm2^\circ$	
M3	see table	4.5	0.6	0.55	0.6	0.7-1.4	174°	
M4		5.5	0.65					
M5		6.5	0.75	0.8	1.0			
M6		7.5						
M8		9.0		0.85	1.5	0.8-1.4		
M10		10.7	1.2-1.8					

l_1 (mm)	d_1													
	M3		M4		M5		M6		M8		M10		M12	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0124-1103-06	0.31	0124-1104-06	0.50	—	—	—	—	—	—	—	—	—	—
8	0124-1103-08	0.38	0124-1104-08	0.65	0124-1105-08	0.90	0124-1106-08	1.50	—	—	—	—	—	—
10	0124-1103-10	0.48	0124-1104-10	0.81	0124-1105-10	1.28	0124-1106-10	1.87	0124-1108-10	3.77	—	—	—	—
12	0124-1103-12	0.56	0124-1104-12	0.95	0124-1105-12	1.42	0124-1106-12	2.25	0124-1108-12	4.39	—	—	—	—
16	0124-1103-16	0.67	0124-1104-16	1.15	0124-1105-16	1.80	0124-1106-16	2.65	0124-1108-16	5.65	0124-1110-16	8.98	—	—
20	0124-1103-20	0.90	0124-1104-20	1.57	0124-1105-20	2.40	0124-1106-20	3.56	0124-1108-20	6.90	0124-1110-20	10.98	0124-1112-20	16.20
25	0124-1103-25	1.1	0124-1104-25	1.85	0124-1105-25	3.05	0124-1106-25	4.40	0124-1108-25	8.48	0124-1110-25	13.50	0124-1112-25	19.87
30	0124-1103-30	1.21	0124-1104-30	2.20	0124-1105-30	3.63	0124-1106-30	5.25	0124-1108-30	10.05	0124-1110-30	15.97	0124-1112-30	23.56
35	0124-1103-35	1.38	0124-1104-35	2.50	0124-1105-35	4.25	0124-1106-35	6.10	0124-1108-35	11.61	0124-1110-35	18.46	0124-1112-35	27.24
40	0124-1103-40	1.54	0124-1104-40	2.80	0124-1105-40	4.85	0124-1106-40	6.96	0124-1108-40	13.18	0124-1110-40	20.96	0124-1112-40	30.92
45	0124-1103-45	1.71	0124-1104-45	3.10	0124-1105-45	5.45	0124-1106-45	7.80	0124-1108-45	14.75	0124-1110-45	23.45	0124-1112-45	34.60
50	0124-1103-50	1.88	0124-1104-50	3.40	0124-1105-50	6.05	0124-1106-50	8.60	0124-1108-50	16.32	0124-1110-50	25.94	0124-1112-50	38.28
55	—	—	—	—	—	—	0124-1106-55	9.40	0124-1108-55	17.89	0124-1110-55	28.44	0124-1112-55	41.96
60	—	—	—	—	—	—	0124-1106-60	10.56	0124-1108-60	19.46	0124-1110-60	30.93	0124-1112-60	45.64

Note:

- All the wt digit in above table unit is Kg.
- Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



PT

外螺纹点焊螺柱 Threaded studs type PT

Material: Aluminum (AlMg3)

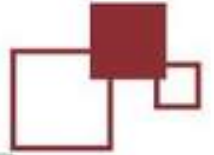


d_1	$l_1+0.6$	$d_2\pm0.2$	$d_4\pm0.08$	$l_3\pm0.05$	$h_5\max$	h_1	$\alpha\pm2^\circ$	
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d_1										
l_1 (mm)	M3		M4		M5		M6		M8	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0134-1103-06	0.10	0134-1104-06	0.11	—	—	—	—	—	—
8	0134-1103-08	0.13	0134-1104-08	0.18	0134-1105-08	0.34	0134-1106-08	0.46	—	—
10	0134-1103-10	0.14	0134-1104-10	0.27	0134-1105-10	0.40	0134-1106-10	0.55	0134-1108-10	1.13
12	0134-1103-12	0.15	0134-1104-12	0.32	0134-1105-12	0.50	0134-1106-12	0.70	0134-1108-12	1.33
16	0134-1103-16	0.21	0134-1104-16	0.41	0134-1105-16	0.70	0134-1106-16	0.95	0134-1108-16	1.6
20	0134-1103-20	0.29	0134-1104-20	0.50	0134-1105-20	0.88	0134-1106-20	1.19	0134-1108-20	2.15
25	0134-1103-25	0.39	0134-1104-25	0.65	0134-1105-25	1.00	0134-1106-25	1.40	0134-1108-25	2.65
30	0134-1103-30	0.47	0134-1104-30	0.77	0134-1105-30	1.24	0134-1106-30	1.70	0134-1108-30	3.25
35	0134-1103-35	0.56	0134-1104-35	0.92	0134-1105-35	1.42	0134-1106-35	1.98	0134-1108-35	3.65
40	0134-1103-40	0.65	0134-1104-40	1.07	0134-1105-40	1.65	0134-1106-40	2.35	0134-1108-40	4.1
45	0134-1103-45	0.73	0134-1104-45	1.22	0134-1105-45	1.85	0134-1106-45	2.60	0134-1108-45	4.7
50	—	—	—	—	—	—	0134-1106-50	2.85	0134-1108-50	5.2
55	—	—	—	—	—	—	—	—	—	—
60	—	—	—	—	—	—	—	—	—	—

Note:
1. All the wt digit in above table unit is Kg.
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



IT

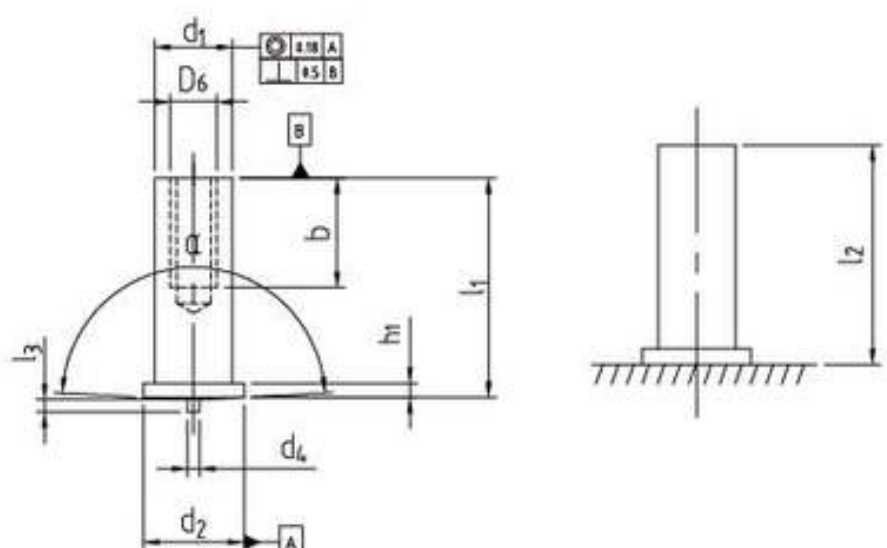
内螺纹点焊螺柱

Studs with internal thread type IT

Material: Mild steel 4.8

Surface: Copper plated



$d_1 \pm 0.1$	D_6	$l_1 \pm 0.6$	$b_{\min} + 2P$	$d_2 \pm 0.2$	$d_4 \pm 0.08$	$l_3 \pm 0.05$	h_1	$a \pm 2^\circ$						
5	M3	see table	5	6.5	0.75	0.8	0.7-1.4	174°						
6	M3		6	7.5										
6	M4													
7.1	M5			9		0.85	0.8-1.4							
8	M6		9											

d_1								
l_1 (mm)	M3/Ø5		M4/Ø6		M5/Ø7		M6/Ø8	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0211-2103-06	0.78	—	—	—	—	—	—
8	0211-2103-08	0.89	0211-2104-08	—	—	—	—	—
10	0211-2103-10	1.13	0211-2104-10	2.07	0211-2105-10	3.30	0211-2106-10	3.86
12	0211-2103-12	1.37	0211-2104-12	2.50	0211-2105-12	3.90	0211-2106-12	4.35
15	0211-2103-15	1.75	0211-2104-15	3.10	0211-2105-15	5.00	0211-2106-15	5.67
20	0211-2103-20	2.35	0211-2104-20	4.28	0211-2105-20	6.50	0211-2106-20	7.15
25	0211-2103-25	2.98	0211-2104-25	5.40	0211-2105-25	8.00	0211-2106-25	8.65
30	0211-2103-30	3.50	0211-2104-30	6.40	0211-2105-30	9.80	0211-2106-30	10.35

Note:
1. All the wt digit in above table unit is Kg.
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

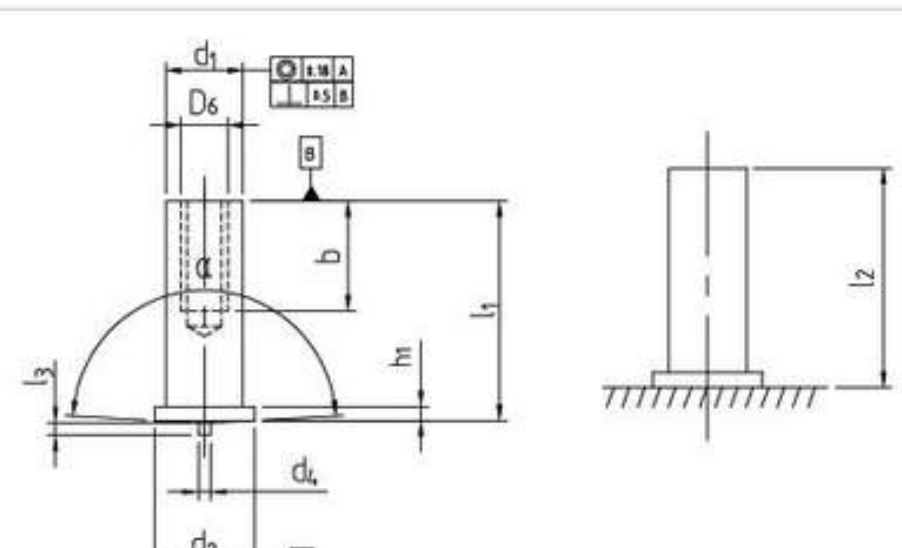
IT

内螺纹点焊螺柱

Studs with internal thread type IT

Material: Stainless steel (A2-50,A4-50)



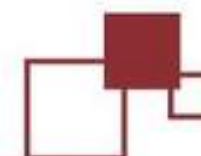
$d_1 \pm 0.1$	D_6	$l_1 \pm 0.6$	$b_{\min} + 2P$	$d_2 \pm 0.2$	$d_4 \pm 0.08$	$l_3 \pm 0.05$	h_1	$a \pm 2^\circ$				
5	M3	See table	5	6.5	0.75	0.8	0.7-1.4	174°				
6	M3		6	7.5						0.85	0.8-1.4	
6	M4			9								
7.1	M5											
8	M6		9									

d_1								
l_1 (mm)	M3/Ø5		M4/Ø6		M5/Ø7		M6/Ø8	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0224-2103-06	1.30	—	—	—	—	—	—
8	0224-2103-08	1.65	0224-2104-08	2.35	—	—	—	—
10	0224-1103-10	1.95	0224-2104-10	2.80	0224-2105-10	3.98	0224-2106-10	4.25
12	0224-1103-12	2.25	0224-2104-12	3.24	0224-2105-12	4.55	0224-2106-12	5.31
15	0224-1103-15	2.8	0224-2104-15	4.00	0224-2105-15	5.80	0224-2106-15	6.73
20	0224-1103-20	3.43	0224-2104-20	4.95	0224-2105-20	7.00	0224-2106-20	7.82
25	0224-1103-25	4.2	0224-2104-25	6.10	0224-2105-25	8.50	0224-2106-25	9.37
30	0224-1103-30	4.9	0224-2104-30	7.10	0224-2105-30	10.10	0224-2106-30	10.87

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



IT

内螺纹铝螺柱

Studs with internal thread type IT

Material: Aluminum (AlMg3)



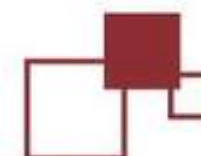
$d_1 \pm 0.1$	D_6	$l_1 \pm 0.6$	$b_{\min} + 2P$	$d_2 \pm 0.2$	$d_4 \pm 0.08$	$l_3 \pm 0.05$	h_1	$a \pm 2^\circ$
5	M3	See table	5	6.5	0.75	0.8	0.7-1.4	174°
6	M3		6	7.5				
6	M4			9		0.8-1.4		
7.1	M5							
8	M6		9					

Technical drawing of a stud with internal thread. The drawing shows a side view and a cross-sectional view. The side view includes dimensions: d_1 (outer diameter), D_6 (thread diameter), l_1 (total length), b (thread length), h_1 (height of the base), d_2 (inner diameter), d_4 (inner diameter of the base), and l_3 (length of the base). The cross-sectional view shows the internal thread and the base. The drawing is labeled with 'A' and 'B' at the ends of the stud.

d_1								
l_1 (mm)	M3/Ø5		M4/Ø6		M5/Ø7		M6/Ø8	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0234-2103-06	0.5	—	—	—	—	—	—
8	0234-2103-08	0.59	0234-2104-08	0.93	—	—	—	—
10	0234-1103-10	0.7	0234-2104-10	1.00	0234-2105-10	1.42	0234-2106-10	1.55
12	0234-1103-12	0.8	0234-2104-12	1.15	0234-2105-12	1.64	0234-2106-12	1.78
15	0234-1103-15	1	0234-2104-15	1.25	0234-2105-15	2.05	0234-2106-15	2.17
20	0234-1103-20	1.25	0234-2104-20	1.65	0234-2105-20	2.50	0234-2106-20	2.68
25	0234-1103-25	1.5	0234-2104-25	1.75	0234-2105-25	3.10	0234-2106-25	3.26
30	0234-1103-30	1.75	0234-2104-30	1.95	0234-2105-30	3.60	0234-2106-30	3.75

Note:
1. All the wt digit in above table unit is Kg.
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



UT

无螺纹点焊螺柱

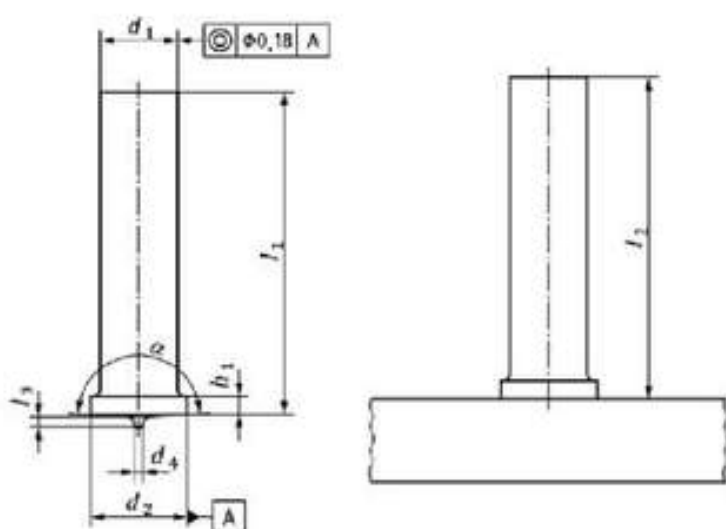
Unthreaded studs (pins) type UT

Material: Mild steel 4.8

Surface: Copper plated



$d_1 \pm 0.1$	$l_1 + 0.6$	$d_2 \pm 0.2$	$d_4 \pm 0.08$	$l_4 \pm 0.05$	h_1	$a \pm 2^\circ$
3	See table	4.50	0.60	0.55	0.70-1.40	174°
4		5.50	0.65			
5		6.50	0.75	0.80		
6		7.50				
7.1		9		0.85	0.8-1.40	



d_1								
l_1 (mm)	M3		M4		M5		M6	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0311-3303-06	0.42	0311-3304-06	0.70	—	—	—	—
8	0311-3303-08	0.52	0311-3304-08	0.85	0311-3305-08	1.41	0311-3306-08	2.15
10	0311-3303-10	0.62	0311-3304-10	1.05	0311-3305-10	1.78	0311-3306-10	2.58
12	0311-3303-12	0.72	0311-3304-12	1.28	0311-3305-12	2.08	0311-3306-12	3.01
16	0311-3303-16	0.91	0311-3304-16	1.68	0311-3305-16	2.67	0311-3306-16	3.87
20	0311-3303-20	1.14	0311-3304-20	2.06	0311-3305-20	3.26	0311-3306-20	4.73
25	0311-3303-25	1.4	0311-3304-25	2.58	0311-3305-25	4.00	0311-3306-25	5.80
30	0311-3303-30	1.67	0311-3304-30	3.00	0311-3305-30	4.74	0311-3306-30	6.87
35	0311-3303-35	1.92	0311-3304-35	3.47	0311-3305-35	5.48	0311-3306-35	7.95
40	0311-3303-40	2.18	0311-3304-40	3.94	0311-3305-40	6.22	0311-3306-40	9.02
45	0311-3303-45	2.44	0311-3304-45	4.41	0311-3305-45	6.96	0311-3306-45	10.09
50	0311-3303-50	2.70	0311-3304-50	4.87	0311-3305-50	7.70	0311-3306-50	11.17

Note:

- All the wt digit in above table unit is Kg.
- Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

UT

无螺纹点焊螺柱

Unthreaded studs (pins) type UT

Material: Stainless steel (A2-50,A4-50)



$d_1 \pm 0.1$	$l_1 \pm 0.6$	$d_2 \pm 0.2$	$d_4 \pm 0.08$	$l_4 \pm 0.05$	h_1	$a \pm 2^\circ$
3	See table	4.50	0.60	0.55	0.70-1.40	174°
4		5.50	0.65			
5		6.50	0.75	0.80		
6		7.50				
7.1		9		0.85	0.8-1.40	

The technical drawing illustrates the dimensions of a stud bolt. The side view shows the overall length l_1 , the diameter d_1 at the top, the diameter d_2 at the base, and the diameter d_4 at the threaded section. The length of the threaded section is l_4 . The height of the base is h_1 . The angle a is indicated between the base and the side. The cross-sectional view shows the internal thread and the base.

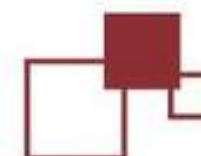
d_1								
l_1 (mm)	M3		M4		M5		M6	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0324-3303-06	0.43	0324-3304-06	0.78	—	—	—	—
8	0324-3303-08	0.54	0324-3304-08	0.97	0324-3305-08	1.53	0324-3306-08	2.22
10	0324-3303-10	0.64	0324-3304-10	1.17	0324-3305-10	1.84	0324-3306-10	2.66
12	0324-3303-12	0.75	0324-3304-12	1.36	0324-3305-12	2.14	0324-3306-12	3.10
16	0324-3303-16	0.96	0324-3304-16	1.74	0324-3305-16	2.75	0324-3306-16	4.00
20	0324-3303-20	1.18	0324-3304-20	2.13	0324-3305-20	3.36	0324-3306-20	4.88
25	0324-3303-25	1.45	0324-3304-25	2.62	0324-3305-25	4.13	0324-3306-25	5.99
30	0324-3303-30	1.71	0324-3304-30	3.10	0324-3305-30	4.89	0324-3306-30	7.10
35	0324-3303-35	1.98	0324-3304-35	3.58	0324-3305-35	5.66	0324-3306-35	8.20
40	0324-3303-40	2.25	0324-3304-40	4.07	0324-3305-40	6.42	0324-3306-40	9.31
45	0324-3303-45	2.52	0324-3304-45	4.55	0324-3305-45	7.19	0324-3306-45	10.42
50	0324-3303-50	2.79	0324-3304-50	5.04	0324-3305-50	7.95	0324-3306-50	11.53

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).





UT

无螺纹点焊螺柱

Unthreaded studs (pins) type UT

Material: Aluminum (AlMg3)



$d_1 \pm 0.1$	$l_1 \pm 0.6$	$d_2 \pm 0.2$	$d_4 \pm 0.08$	$l_4 \pm 0.05$	h_1	$\alpha \pm 2^\circ$
3	See table	4.50	0.60	0.55	0.70-1.40	174°
4		5.50	0.65			
5		6.50	0.75	0.80		
6		7.50				
7.1		9		0.85	0.8-1.40	

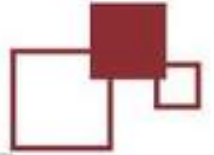
d_1								
l_1 (mm)	M3		M4		M5		M6	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	0334-3303-06	0.15	0334-3304-06	0.27	—	—	—	—
8	0334-3303-08	0.19	0334-3304-08	0.33	0334-3305-08	0.53	0334-3306-08	0.77
10	0334-3303-10	0.22	0334-3304-10	0.40	0334-3305-10	0.64	0334-3306-10	0.92
12	0334-3303-12	0.25	0334-3304-12	0.47	0334-3305-12	0.74	0334-3306-12	1.07
16	0334-3303-16	0.33	0334-3304-16	0.60	0334-3305-16	0.95	0334-3306-16	1.38
20	0334-3303-20	0.41	0334-3304-20	0.74	0334-3305-20	1.16	0334-3306-20	1.68
25	0334-3303-25	0.5	0334-3304-25	0.90	0334-3305-25	1.43	0334-3306-25	2.07
30	0334-3303-30	0.59	0334-3304-30	1.07	0334-3305-30	1.69	0334-3306-30	2.45
35	0334-3303-35	0.68	0334-3304-35	1.24	0334-3305-35	1.95	0334-3306-35	2.83
40	0334-3303-40	0.78	0334-3304-40	1.41	0334-3305-40	2.22	0334-3306-40	3.22
45	0334-3303-45	0.87	0334-3304-45	1.57	0334-3305-45	2.48	0334-3306-45	3.60
50	0334-3303-50	0.96	0334-3304-50	1.74	0334-3305-50	2.75	0334-3306-50	3.98

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



CD

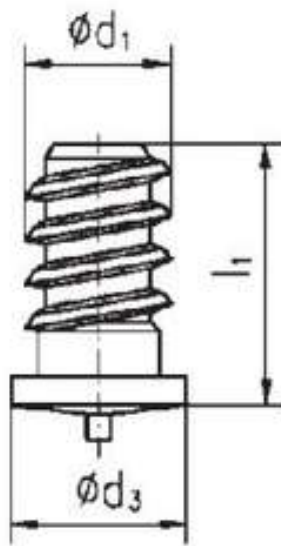
木螺纹点焊螺柱 CD Fir Tree Studs

This standard fir tree stud is mainly used to fasten plastic clips and nuts. Due to the trigger point on the flange, the studs welding need used with Capacitor discharge welding machines.

Material: Mild steel 4.8, 6.8 or 8.8

Surface: Copper planted



d_1	$l_1+0.6$	$d_3\pm0.2$	
5.0	See table	6.5	

l_1 (mm)	d_1	
	$\varnothing 5$	
	Order No.	Wt 1000/PCS
9	0111-3305-09	1.10
14.2	0111-3305-14.2	1.60
18	0111-3305-18	1.85
20	0111-3305-20	2.15
25	0111-3305-25	2.80

Note:

1. All the wt digit in above table unit is Kg.
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

CD

带纵向槽点焊螺柱

CD Paint clearing threaded Studs

This standard fir tree stud is mainly used to fasten plastic clips and nuts. Due to the trigger point on the flange, the studs welding need used with Capacitor discharge welding machines.

Material: Mild steel 4.8, 6.8 or 8.8

Surface: Copper planted/Nicke planted



d_1	$l_1+0.6$	$d_2+0.2$	$d_4+0.08$	$l_3+0.05$	h_1	$a\pm 1^\circ$	
M5	See table	6.50	0.75	0.80	0.70-1.40	3°	
M6		7.50	0.75	0.80			

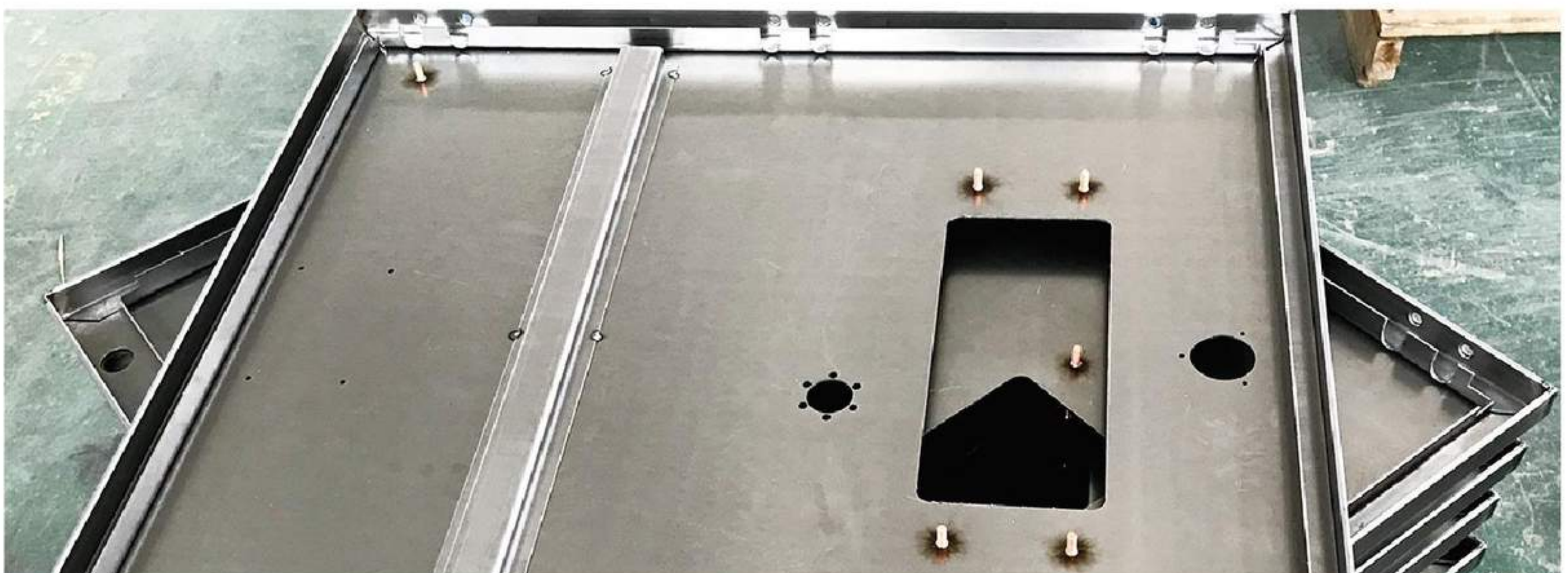
l_1 (mm)	d_1			
	M5		M6	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
10	0111-1105-10	1.38	0111-1106-10	1.98
12	0111-1105-12	1.61	0111-1106-12	2.31
16	0111-1105-16	2.07	0111-1106-16	2.97
20	0111-1105-20	2.53	0111-1106-20	3.63
25	0111-1105-25	3.11	0111-1106-25	4.45
30	0111-1105-30	3.68	0111-1106-30	5.28

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

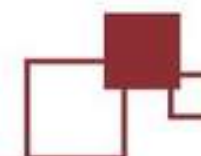
案例展示
Case Presentation





专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS

PD
Without Flux



PD

外螺纹拉弧螺柱

Partially Threaded Studs Type PD

Material: 4.8 Steel

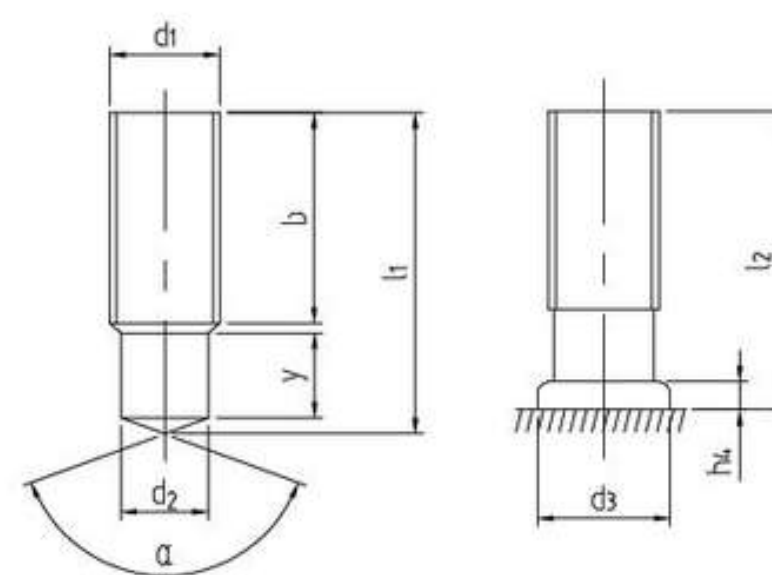
Specification: Without flux

Coating: Copper planted/Nicke planted

Recommend Welding Process: Shield gas welding



d_1	l_2	$d_2 \pm 0.1$	d_3	h_4	$\alpha \pm 7^\circ$
M6	See table	5.35	8.5	3.5	140°
M8		7.19	10	3.5	
M10		9.03	12.5	4	
M12		10.86	15.5	4.5	
M16		14.6	19.5	6	
M20		18.38	24.5	7	
M24		22.05	30	10	



d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0511-1106-10	2.06	0511-1106-10	3.80	—	—	—	—	—	—
12	0511-1106-12	2.39	0511-1108-12	4.41	—	—	—	—	—	—
16	0511-1106-16	3.05	0511-1108-16	5.63	0511-1110-16	8.95	—	—	—	—
20	0511-1106-20	3.71	0511-1108-20	6.84	0511-1110-20	10.87	0511-1112-20	16.02	0511-1116-20	29.02
25	0511-1106-25	4.54	0511-1108-25	8.36	0511-1110-25	13.53	0511-1112-25	19.61	0511-1116-25	34.69
30	0511-1106-30	5.36	0511-1108-30	9.88	0511-1110-30	15.71	0511-1112-30	23.17	0511-1116-30	41.64
35	0511-1106-35	6.18	0511-1108-35	11.40	0511-1110-35	18.27	0511-1112-35	26.74	0511-1116-35	47.94
40	0511-1106-40	7.01	0511-1108-40	12.92	0511-1110-40	20.68	0511-1112-40	30.31	0511-1116-40	54.25
45	0511-1106-45	7.83	0511-1108-45	14.44	0511-1110-45	22.95	0511-1112-45	33.88	0511-1116-45	60.56
50	0511-1106-50	8.66	0511-1108-50	15.96	0511-1110-50	25.52	0511-1112-50	37.43	0511-1116-50	66.87
55	0511-1106-55	9.48	0511-1108-55	17.48	0511-1110-55	27.79	0511-1112-55	40.99	0511-1116-55	73.18
60	0511-1106-60	10.31	0511-1108-60	19.01	0511-1110-60	30.35	0511-1112-60	44.56	0511-1116-60	79.49
65	0511-1106-65	11.13	0511-1108-65	20.52	0511-1110-65	32.76	0511-1112-65	48.13	0511-1116-65	85.8
70	0511-1106-70	11.96	0511-1108-70	22.04	0511-1110-70	35.04	0511-1112-70	51.69	0511-1116-70	92.1

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

PD

外螺纹拉弧螺柱

Partially Threaded Studs Type PD

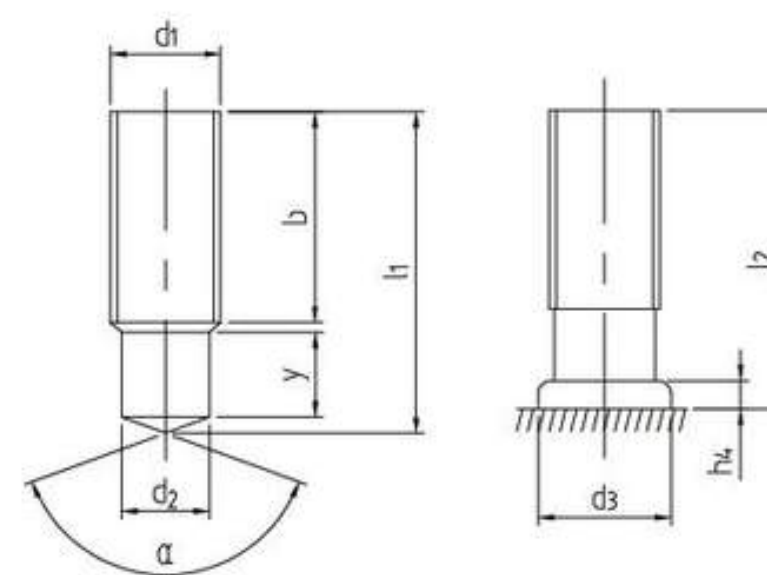
Material: Stainless steel (A2-50,A4-50)

Specification: Without flux

Recommend Welding Process: Shield gas welding



d_1	l_2	$d_2 \pm 0.1$	d_3	h_4	$\alpha \pm 7^\circ$
M6	See table	5.35	8.5	3.5	140°
M8		7.19	10	3.5	
M10		9.03	12.5	4	
M12		10.86	15.5	4.5	
M16		14.6	19.5	6	
M20		18.38	24.5	7	
M24		22.05	30	10	



d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0521-1106-10	2.13	0521-1106-10	3.92	—	—	—	—	—	—
12	0521-1106-12	2.47	0521-1108-12	4.55	—	—	—	—	—	—
16	0521-1106-16	3.15	0521-1108-16	5.81	0521-1110-16	9.23	—	—	—	—
20	0521-1106-20	3.83	0521-1108-20	6.97	0521-1110-20	11.23	0521-1112-20	16.56	0521-1116-20	29.31
25	0521-1106-25	4.68	0521-1108-25	8.63	0521-1110-25	13.72	0521-1112-25	20.24	0521-1116-25	35.82
30	0521-1106-30	5.53	0521-1108-30	10.20	0521-1110-30	16.21	0521-1112-30	23.92	0521-1116-30	42.33
35	0521-1106-35	6.38	0521-1108-35	11.77	0521-1110-35	18.71	0521-1112-35	27.61	0521-1116-35	48.85
40	0521-1106-40	7.23	0521-1108-40	13.34	0521-1110-40	21.20	0521-1112-40	31.29	0521-1116-40	55.36
45	0521-1106-45	8.09	0521-1108-45	14.91	0521-1110-45	23.69	0521-1112-45	34.97	0521-1116-45	61.87
50	0521-1106-50	8.94	0521-1108-50	16.48	0521-1110-50	26.19	0521-1112-50	38.65	0521-1116-50	68.39
55	0521-1106-55	9.79	0521-1108-55	18.05	0521-1110-55	28.69	0521-1112-55	42.33	0521-1116-55	74.89
60	0521-1106-60	10.64	0521-1108-60	19.62	0521-1110-60	31.18	0521-1112-60	46.01	0521-1116-60	81.41
65	0521-1106-65	11.49	0521-1108-65	21.19	0521-1110-65	33.68	0521-1112-65	49.69	0521-1116-65	87.93
70	0521-1106-70	12.34	0521-1108-70	22.76	0521-1110-70	36.17	0521-1112-70	53.37	0521-1116-70	94.44

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS

PD
With Flux

PD

外螺纹拉弧螺柱

Partially Threaded Studs Type PD

Material: 4.8 Steel

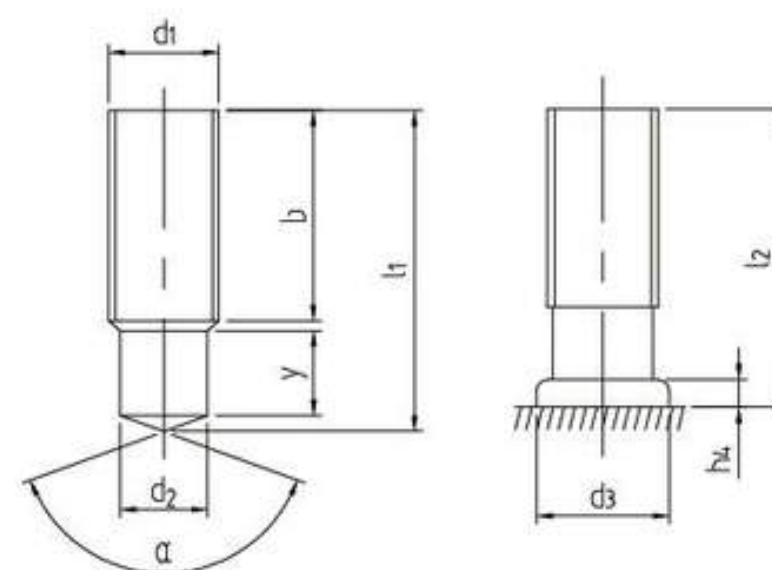
Specification: With flux

Coating: Copper planted/Nicke planted

Recommend Welding Process: Cermaic ferrule welding



d_1	l_2	$d_2 \pm 0.1$	d_3	h_4	$\alpha \pm 7^\circ$
M6	See table	5.35	8.5	3.5	140°
M8		7.19	10	3.5	
M10		9.03	12.5	4	
M12		10.86	15.5	4.5	
M16		14.6	19.5	6	
M20		18.38	24.5	7	
M24		22.05	30	10	

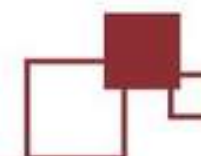


d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0511-1106-10	2.06	0511-1106-10	3.80	—	—	—	—	—	—
12	0511-1106-12	2.39	0511-1108-12	4.41	—	—	—	—	—	—
16	0511-1106-16	3.05	0511-1108-16	5.63	0511-1110-16	8.95	—	—	—	—
20	0511-1106-20	3.71	0511-1108-20	6.84	0511-1110-20	10.87	0511-1112-20	16.02	0511-1116-20	29.02
25	0511-1106-25	4.54	0511-1108-25	8.36	0511-1110-25	13.53	0511-1112-25	19.61	0511-1116-25	34.69
30	0511-1106-30	5.36	0511-1108-30	9.88	0511-1110-30	15.71	0511-1112-30	23.17	0511-1116-30	41.64
35	0511-1106-35	6.18	0511-1108-35	11.40	0511-1110-35	18.27	0511-1112-35	26.74	0511-1116-35	47.94
40	0511-1106-40	7.01	0511-1108-40	12.92	0511-1110-40	20.68	0511-1112-40	30.31	0511-1116-40	54.25
45	0511-1106-45	7.83	0511-1108-45	14.44	0511-1110-45	22.95	0511-1112-45	33.88	0511-1116-45	60.56
50	0511-1106-50	8.66	0511-1108-50	15.96	0511-1110-50	25.52	0511-1112-50	37.43	0511-1116-50	66.87
55	0511-1106-55	9.48	0511-1108-55	17.48	0511-1110-55	27.79	0511-1112-55	40.99	0511-1116-55	73.18
60	0511-1106-60	10.31	0511-1108-60	19.01	0511-1110-60	30.35	0511-1112-60	44.56	0511-1116-60	79.49
65	0511-1106-65	11.13	0511-1108-65	20.52	0511-1110-65	32.76	0511-1112-65	48.13	0511-1116-65	85.8
70	0511-1106-70	11.96	0511-1108-70	22.04	0511-1110-70	35.04	0511-1112-70	51.69	0511-1116-70	92.1

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



PD

外螺纹拉弧螺柱

Partially Threaded Studs Type PD

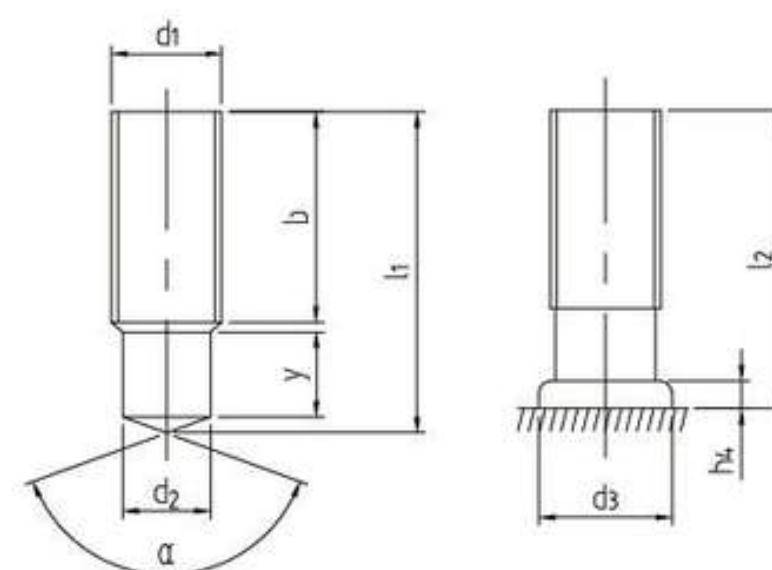
Material: Stainless steel (A2-50,A4-50)

Specification: With flux

Recommend Welding Process: Cermaic ferrule welding



d_1	l_2	$d_2 \pm 0.1$	d_3	h_4	$\alpha \pm 7^\circ$
M6	See table	5.35	8.5	3.5	140°
M8		7.19	10	3.5	
M10		9.03	12.5	4	
M12		10.86	15.5	4.5	
M16		14.6	19.5	6	
M20		18.38	24.5	7	
M24		22.05	30	10	



d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0521-1106-10	2.13	0521-1106-10	3.92	—	—	—	—	—	—
12	0521-1106-12	2.47	0521-1108-12	4.55	—	—	—	—	—	—
16	0521-1106-16	3.15	0521-1108-16	5.81	0521-1110-16	9.23	—	—	—	—
20	0521-1106-20	3.83	0521-1108-20	6.97	0521-1110-20	11.23	0521-1112-20	16.56	0521-1116-20	29.31
25	0521-1106-25	4.68	0521-1108-25	8.63	0521-1110-25	13.72	0521-1112-25	20.24	0521-1116-25	35.82
30	0521-1106-30	5.53	0521-1108-30	10.20	0521-1110-30	16.21	0521-1112-30	23.92	0521-1116-30	42.33
35	0521-1106-35	6.38	0521-1108-35	11.77	0521-1110-35	18.71	0521-1112-35	27.61	0521-1116-35	48.85
40	0521-1106-40	7.23	0521-1108-40	13.34	0521-1110-40	21.20	0521-1112-40	31.29	0521-1116-40	55.36
45	0521-1106-45	8.09	0521-1108-45	14.91	0521-1110-45	23.69	0521-1112-45	34.97	0521-1116-45	61.87
50	0521-1106-50	8.94	0521-1108-50	16.48	0521-1110-50	26.19	0521-1112-50	38.65	0521-1116-50	68.39
55	0521-1106-55	9.79	0521-1108-55	18.05	0521-1110-55	28.69	0521-1112-55	42.33	0521-1116-55	74.89
60	0521-1106-60	10.64	0521-1108-60	19.62	0521-1110-60	31.18	0521-1112-60	46.01	0521-1116-60	81.41
65	0521-1106-65	11.49	0521-1108-65	21.19	0521-1110-65	33.68	0521-1112-65	49.69	0521-1116-65	87.93
70	0521-1106-70	12.34	0521-1108-70	22.76	0521-1110-70	36.17	0521-1112-70	53.37	0521-1116-70	94.44

Note:

1. All the wt digit in above table unit is Kg.

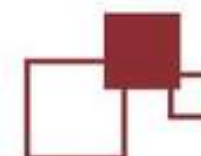
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS

RD
Without Flux





RD

缩颈外螺纹拉弧螺柱

Threaded Studs With Reduced Shaft Type PD

Material: 4.8 Steel

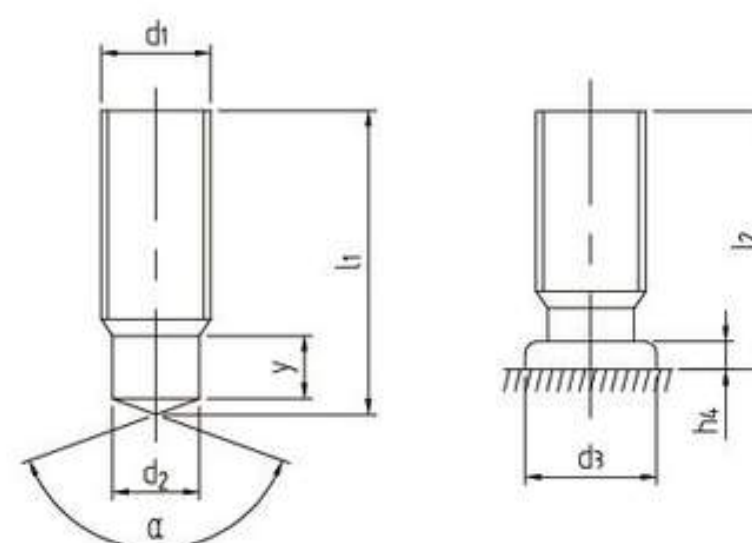
Specification: Without flux

Coating: Copper planted/Nicke planted

Recommend Welding Process: Shield gas welding



d_1	l_2	$d_2 \pm 0.1$	d_3	$y+2p$	h_4	$a \pm 7^\circ$
M6	See table	4.7	7	4	2.5	140°
M8		6.2	9	4	2.5	
M10		7.9	11.5	5	3	
M12		9.5	13.5	6	4	
M16		13.2	18	7.5	5	



d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0611-1106-10	1.96	0611-1106-10	3.70	—	—	—	—	—	—
12	0611-1106-12	2.28	0611-1108-12	4.30	—	—	—	—	—	—
16	0611-1106-16	2.95	0611-1108-16	5.52	0611-1110-16	8.85	—	—	—	—
20	0611-1106-20	3.60	0611-1108-20	6.74	0611-1110-20	10.76	0611-1112-20	15.92	0611-1116-20	28.9
25	0611-1106-25	4.45	0611-1108-25	8.25	0611-1110-25	13.42	0611-1112-25	19.50	0611-1116-25	34.53
30	0611-1106-30	5.25	0611-1108-30	9.76	0611-1110-30	15.60	0611-1112-30	23.02	0611-1116-30	41.52
35	0611-1106-35	6.08	0611-1108-35	11.30	0611-1110-35	18.16	0611-1112-35	26.63	0611-1116-35	47.82
40	0611-1106-40	6.90	0611-1108-40	12.80	0611-1110-40	20.56	0611-1112-40	30.20	0611-1116-40	54.12
45	0611-1106-45	7.71	0611-1108-45	14.34	0611-1110-45	22.85	0611-1112-45	33.76	0611-1116-45	60.42
50	0611-1106-50	8.56	0611-1108-50	15.85	0611-1110-50	25.41	0611-1112-50	37.33	0611-1116-50	66.77
55	0611-1106-55	9.38	0611-1108-55	17.36	0611-1110-55	27.67	0611-1112-55	40.85	0611-1116-55	73.02
60	0611-1106-60	10.20	0611-1108-60	18.90	0611-1110-60	30.23	0611-1112-60	44.43	0611-1116-60	79.32
65	0611-1106-65	11.02	0611-1108-65	20.40	0611-1110-65	32.62	0611-1112-65	48.01	0611-1116-65	85.65
70	0611-1106-70	11.85	0611-1108-70	21.94	0611-1110-70	34.90	0611-1112-70	51.57	0611-1116-70	92

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

RD

缩颈外螺纹拉弧螺柱

Threaded Studs With Reduced Shaft Type PD

Material: Stainless steel, A2-50, A4-50

Specification: Without flux

Recommend Welding Process: Shield gas welding



d_1	l_2	$d_2 \pm 0.1$	d_3	$y+2p$	h_4	$\alpha \pm 7^\circ$
M6	See table	4.7	7	4	2.5	140°
M8		6.2	9	4	2.5	
M10		7.9	11.5	5	3	
M12		9.5	13.5	6	4	
M16		13.2	18	7.5	5	

d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0621-1106-10	2.01	0621-1106-10	3.80	—	—	—	—	—	—
12	0621-1106-12	2.35	0621-1108-12	4.42	—	—	—	—	—	—
16	0621-1106-16	3.02	0621-1108-16	5.68	0621-1110-16	9.14	—	—	—	—
20	0621-1106-20	3.70	0621-1108-20	6.83	0621-1110-20	11.12	0621-1112-20	16.40	0621-1116-20	29.15
25	0621-1106-25	4.53	0621-1108-25	8.50	0621-1110-25	13.58	0621-1112-25	20.10	0621-1116-25	35.64
30	0621-1106-30	5.40	0621-1108-30	10.08	0621-1110-30	16.08	0621-1112-30	23.80	0621-1116-30	42.05
35	0621-1106-35	6.25	0621-1108-35	11.60	0621-1110-35	18.60	0621-1112-35	27.50	0621-1116-35	48.72
40	0621-1106-40	7.12	0621-1108-40	13.20	0621-1110-40	21.05	0621-1112-40	31.10	0621-1116-40	55.2
45	0621-1106-45	7.95	0621-1108-45	14.75	0621-1110-45	23.55	0621-1112-45	34.82	0621-1116-45	61.7
50	0621-1106-50	8.80	0621-1108-50	16.33	0621-1110-50	26.02	0621-1112-50	38.50	0621-1116-50	68.23
55	0621-1106-55	9.68	0621-1108-55	17.85	0621-1110-55	28.55	0621-1112-55	42.20	0621-1116-55	74.7
60	0621-1106-60	10.50	0621-1108-60	19.45	0621-1110-60	31.03	0621-1112-60	45.85	0621-1116-60	81.2
65	0621-1106-65	11.35	0621-1108-65	21.02	0621-1110-65	33.52	0621-1112-65	49.55	0621-1116-65	87.75
70	0621-1106-70	12.22	0621-1108-70	22.55	0621-1110-70	36.03	0621-1112-70	53.25	0621-1116-70	94.2

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS

RD
With Flux

RD

缩颈外螺纹拉弧螺柱

Threaded Studs With Reduced Shaft Type PD

Material: 4.8 Steel

Specification: With flux

Coating: Copper planted/Nicke planted

Recommend Welding Process: Cermaic ferrule welding



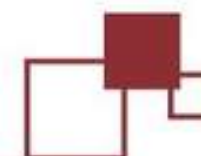
d_1	l_2	$d_2 \pm 0.1$	d_3	$y+2p$	h_4	$a \pm 7^\circ$	
M6	See table	4.7	7	4	2.5	140°	
M8		6.2	9	4	2.5		
M10		7.9	11.5	5	3		
M12		9.5	13.5	6	4		
M16		13.2	18	7.5	5		

d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0611-1106-10	1.96	0611-1106-10	3.70	—	—	—	—	—	—
12	0611-1106-12	2.28	0611-1108-12	4.30	—	—	—	—	—	—
16	0611-1106-16	2.95	0611-1108-16	5.52	0611-1110-16	8.85	—	—	—	—
20	0611-1106-20	3.60	0611-1108-20	6.74	0611-1110-20	10.76	0611-1112-20	15.92	0611-1116-20	28.9
25	0611-1106-25	4.45	0611-1108-25	8.25	0611-1110-25	13.42	0611-1112-25	19.50	0611-1116-25	34.53
30	0611-1106-30	5.25	0611-1108-30	9.76	0611-1110-30	15.60	0611-1112-30	23.02	0611-1116-30	41.52
35	0611-1106-35	6.08	0611-1108-35	11.30	0611-1110-35	18.16	0611-1112-35	26.63	0611-1116-35	47.82
40	0611-1106-40	6.90	0611-1108-40	12.80	0611-1110-40	20.56	0611-1112-40	30.20	0611-1116-40	54.12
45	0611-1106-45	7.71	0611-1108-45	14.34	0611-1110-45	22.85	0611-1112-45	33.76	0611-1116-45	60.42
50	0611-1106-50	8.56	0611-1108-50	15.85	0611-1110-50	25.41	0611-1112-50	37.33	0611-1116-50	66.77
55	0611-1106-55	9.38	0611-1108-55	17.36	0611-1110-55	27.67	0611-1112-55	40.85	0611-1116-55	73.02
60	0611-1106-60	10.20	0611-1108-60	18.90	0611-1110-60	30.23	0611-1112-60	44.43	0611-1116-60	79.32
65	0611-1106-65	11.02	0611-1108-65	20.40	0611-1110-65	32.62	0611-1112-65	48.01	0611-1116-65	85.65
70	0611-1106-70	11.85	0611-1108-70	21.94	0611-1110-70	34.90	0611-1112-70	51.57	0611-1116-70	92

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



RD

缩颈外螺纹拉弧螺柱

Threaded Studs With Reduced Shaft Type PD

Material: Stainless steel (A2-50,A4-50)

Specification: With flux

Recommend Welding Process: Cermaic ferrule welding



d_1	l_2	$d_2 \pm 0.1$	d_3	$y+2p$	h_4	$\alpha \pm 7^\circ$
M6	See table	4.7	7	4	2.5	140°
M8		6.2	9	4	2.5	
M10		7.9	11.5	5	3	
M12		9.5	13.5	6	4	
M16		13.2	18	7.5	5	

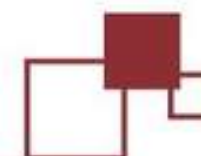
d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0621-1106-10	2.01	0621-1106-10	3.80	—	—	—	—	—	—
12	0621-1106-12	2.35	0621-1108-12	4.42	—	—	—	—	—	—
16	0621-1106-16	3.02	0621-1108-16	5.68	0621-1110-16	9.14	—	—	—	—
20	0621-1106-20	3.70	0621-1108-20	6.83	0621-1110-20	11.12	0621-1112-20	16.40	0621-1116-20	29.15
25	0621-1106-25	4.53	0621-1108-25	8.50	0621-1110-25	13.58	0621-1112-25	20.10	0621-1116-25	35.64
30	0621-1106-30	5.40	0621-1108-30	10.08	0621-1110-30	16.08	0621-1112-30	23.80	0621-1116-30	42.05
35	0621-1106-35	6.25	0621-1108-35	11.60	0621-1110-35	18.60	0621-1112-35	27.50	0621-1116-35	48.72
40	0621-1106-40	7.12	0621-1108-40	13.20	0621-1110-40	21.05	0621-1112-40	31.10	0621-1116-40	55.2
45	0621-1106-45	7.95	0621-1108-45	14.75	0621-1110-45	23.55	0621-1112-45	34.82	0621-1116-45	61.7
50	0621-1106-50	8.80	0621-1108-50	16.33	0621-1110-50	26.02	0621-1112-50	38.50	0621-1116-50	68.23
55	0621-1106-55	9.68	0621-1108-55	17.85	0621-1110-55	28.55	0621-1112-55	42.20	0621-1116-55	74.7
60	0621-1106-60	10.50	0621-1108-60	19.45	0621-1110-60	31.03	0621-1112-60	45.85	0621-1116-60	81.2
65	0621-1106-65	11.35	0621-1108-65	21.02	0621-1110-65	33.52	0621-1112-65	49.55	0621-1116-65	87.75
70	0621-1106-70	12.22	0621-1108-70	22.55	0621-1110-70	36.03	0621-1112-70	53.25	0621-1116-70	94.2

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



MD

全螺纹拉弧螺柱

Virtually fully-threaded studs Similar Type MD

全螺纹 (MD) 焊接螺柱类似于PD系列螺柱, 这种类型的螺柱在焊接后, 焊疤根部以上拥有螺纹, 适用于某些螺母装配到底的焊接紧固工艺。

MD type threaded studs Similar PD type, this Type studs are recommended for fastening applications where threads are needed for the full fastener length. MD threaded studs have a short length of pitch diameter weld base. This length is melted off during the stud welding process so that usable thread extends down to the top of the weld flash on installed studs.

Material: Mid steel 4.8

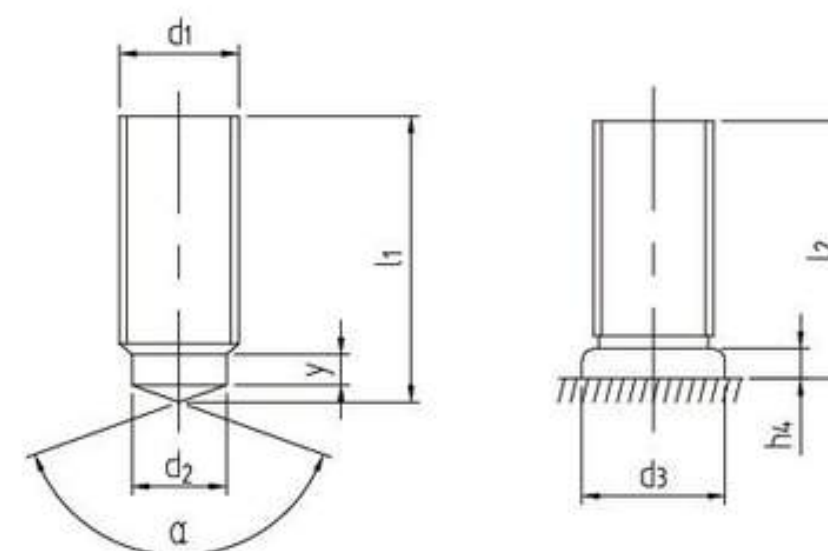
Specification: Without flux

Coating: Copper planted/Nicke planted

Recommend Welding Process: Shield gas welding



d_1	l_2	$d_2 \pm 0.1$	d_3	$y + 2p$	h_4	$\alpha \pm 7^\circ$
M6	See table	5.35	9	5.5	3.5	140°
M8		7.19	9.9	6	3	
M10		9.03	12.5	6.5	3.4	
M12		10.86	14.5	7.5	4.2	
M16		14.6	17.8	11	5.8	



l_2 (mm)	d_1									
	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0511-1106-10	2.06	0511-1106-10	3.80	—	—	—	—	—	—
12	0511-1106-12	2.39	0511-1108-12	4.41	—	—	—	—	—	—
16	0511-1106-16	3.05	0511-1108-16	5.63	0511-1110-16	8.95	—	—	—	—
20	0511-1106-20	3.71	0511-1108-20	6.84	0511-1110-20	10.87	0511-1112-20	16.02	0511-1116-20	29.02
25	0511-1106-25	4.54	0511-1108-25	8.36	0511-1110-25	13.53	0511-1112-25	19.61	0511-1116-25	34.69
30	0511-1106-30	5.36	0511-1108-30	9.88	0511-1110-30	15.71	0511-1112-30	23.17	0511-1116-30	41.64
35	0511-1106-35	6.18	0511-1108-35	11.40	0511-1110-35	18.27	0511-1112-35	26.74	0511-1116-35	47.94
40	0511-1106-40	7.01	0511-1108-40	12.92	0511-1110-40	20.68	0511-1112-40	30.31	0511-1116-40	54.25
45	0511-1106-45	7.83	0511-1108-45	14.44	0511-1110-45	22.95	0511-1112-45	33.88	0511-1116-45	60.56
50	0511-1106-50	8.66	0511-1108-50	15.96	0511-1110-50	25.52	0511-1112-50	37.43	0511-1116-50	66.87
55	0511-1106-55	9.48	0511-1108-55	17.48	0511-1110-55	27.79	0511-1112-55	40.99	0511-1116-55	73.18
60	0511-1106-60	10.31	0511-1108-60	19.01	0511-1110-60	30.35	0511-1112-60	44.56	0511-1116-60	79.49
65	0511-1106-65	11.13	0511-1108-65	20.52	0511-1110-65	32.76	0511-1112-65	48.13	0511-1116-65	85.8
70	0511-1106-70	11.96	0511-1108-70	22.04	0511-1110-70	35.04	0511-1112-70	51.69	0511-1116-70	92.1

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

MD

全螺纹拉弧螺柱

Virtually fully-threaded studs Similar Type MD

Material: Stainless steel (A2-50.A4-50)

Specification: Without flux

Recommend Welding Process: Shield gas welding



d_1	l_2	$d_2 \pm 0.1$	d_3	$y+2p$	h_4	$a \pm 7^\circ$	
M6	See table	5.35	9	5.5	3.5	140°	
M8		7.19	9.9	6	3		
M10		9.03	12.5	6.5	3.4		
M12		10.86	14.5	7.5	4.2		
M16		14.6	17.8	11	5.8		

d_1										
l_2 (mm)	M6		M8		M10		M12		M16	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—	—	—
10	0721-1106-10	2.13	0721-1106-10	3.92	—	—	—	—	—	—
12	0721-1106-12	2.47	0721-1108-12	4.55	—	—	—	—	—	—
16	0721-1106-16	3.15	0721-1108-16	5.81	0721-1110-16	9.23	—	—	—	—
20	0721-1106-20	3.83	0721-1108-20	6.97	0721-1110-20	11.23	0721-1112-20	16.56	0721-1116-20	29.31
25	0721-1106-25	4.68	0721-1108-25	8.63	0721-1110-25	13.72	0721-1112-25	20.24	0721-1116-25	35.82
30	0721-1106-30	5.53	0721-1108-30	10.20	0721-1110-30	16.21	0721-1112-30	23.92	0721-1116-30	42.33
35	0721-1106-35	6.38	0721-1108-35	11.77	0721-1110-35	18.71	0721-1112-35	27.61	0721-1116-35	48.85
40	0721-1106-40	7.23	0721-1108-40	13.34	0721-1110-40	21.20	0721-1112-40	31.29	0721-1116-40	55.36
45	0721-1106-45	8.09	0721-1108-45	14.91	0721-1110-45	23.69	0721-1112-45	34.97	0721-1116-45	61.87
50	0721-1106-50	8.94	0721-1108-50	16.48	0721-1110-50	26.19	0721-1112-50	38.65	0721-1116-50	68.39
55	0721-1106-55	9.79	0721-1108-55	18.05	0721-1110-55	28.69	0721-1112-55	42.33	0721-1116-55	74.89
60	0721-1106-60	10.64	0721-1108-60	19.62	0721-1110-60	31.18	0721-1112-60	46.01	0721-1116-60	81.41
65	0721-1106-65	11.49	0721-1108-65	21.19	0721-1110-65	33.68	0721-1112-65	49.69	0721-1116-65	87.93
70	0721-1106-70	12.34	0721-1108-70	22.76	0721-1110-70	36.17	0721-1112-70	53.37	0721-1116-70	94.44

Note:

1. All the wt digit in above table unit is Kg.

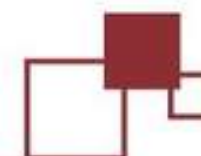
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



案例展示 Case Presentation



专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



UD

无螺纹拉弧螺柱

Unthreaded studs type UD

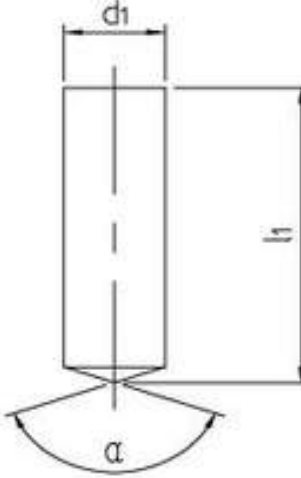
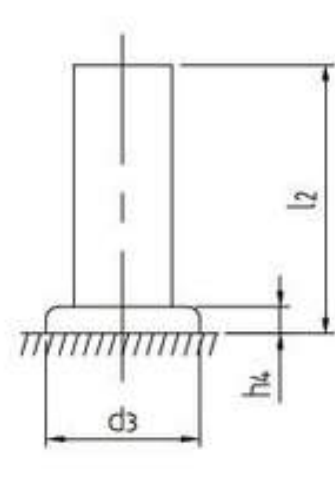
无螺纹螺柱设计用于焊接到重型设备厚板上。它们通常用作定位销、轴、枢轴点、垫片和止动件。在锅炉等发电行业中，它们用于将耐火材料锚固到水冷壁上，促进燃煤炉中的热传递。

Unthreaded studs are designed to be used as locator pins, axles, pivot points, spacers, and stops. In the power generation market, they are used to anchor refractory to water walls and to facilitate heat transfer in coal burning furnaces.

Material: Mid steel 4.8

Specification: Without flux

Recommend Welding Process: Shield gas welding

$d_1 \pm 0.1$	d_3	$l_2 \pm 1$	h_4	$a \pm 7^\circ$		
6	8.5	See table	4	140°		
8	11		4			
10	13		4			
12	16		5			
14.6	18.5		6			
16	21		7			

d_1								
l_2 (mm)	Ø6		Ø8		Ø10		Ø12	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—
10	—	—	—	—	—	—	—	—
12	—	—	—	—	—	—	—	—
16	0914-3006-16	3.65	0914-3008-16	6.55	0914-3010-16	9.98	—	—
20	0914-3006-20	4.50	0914-3008-20	8.09	0914-3010-20	12.69	0914-3012-20	17.91
25	0914-3006-25	5.58	0914-3008-25	10.01	0914-3010-25	15.72	0914-3012-25	22.28
30	0914-3006-30	6.65	0914-3008-30	11.93	0914-3010-30	18.75	0914-3012-30	26.65
35	0914-3006-35	7.73	0914-3008-35	13.86	0914-3010-35	21.77	0914-3012-35	31.02
40	0914-3006-40	8.80	0914-3008-40	15.79	0914-3010-40	24.79	0914-3012-40	35.39
45	0914-3006-45	9.88	0914-3008-45	17.71	0914-3010-45	27.82	0914-3012-45	39.75
50	0914-3006-50	10.95	0914-3008-50	19.64	0914-3010-50	30.85	0914-3012-50	44.12
55	0914-3006-55	12.03	0914-3008-55	21.56	0914-3010-55	33.86	0914-3012-55	48.49
60	0914-3006-60	13.10	0914-3008-60	23.49	0914-3010-60	36.88	0914-3012-60	52.86

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

UD

无螺纹拉弧螺柱

Unthreaded studs ype UD

Material: Stainless steel A2-50 A4-50

Specification: Without flux

Recommend Welding Process: Shield gas welding



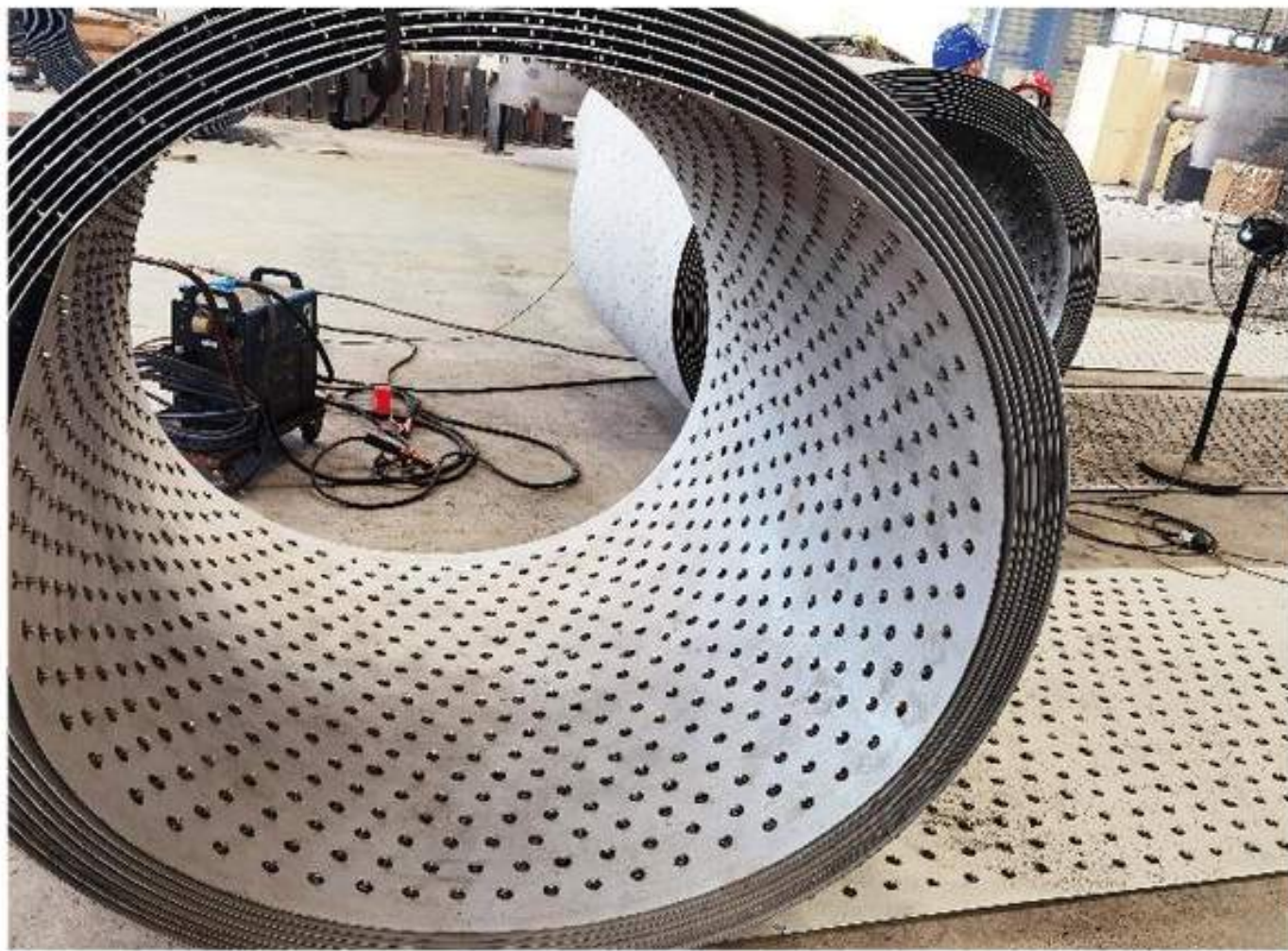
d_1	l_2	$d_2 \pm 0.1$	d_3	$y+2p$	h_4	$a \pm 7^\circ$	
M6	See table	5.35	9	5.5	3.5	140°	
M8		7.19	9.9	6	3		
M10		9.03	12.5	6.5	3.4		
M12		10.86	14.5	7.5	4.2		
M16		14.6	17.8	11	5.8		

d_1								
l_2 (mm)	Ø6		Ø8		Ø10		Ø12	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—
10	—	—	—	—	—	—	—	—
12	—	—	—	—	—	—	—	—
16	0924-3006-16	3.65	0924-3008-16	6.56	0924-3010-16	10.30	—	—
20	0924-3006-20	4.45	0924-3008-20	8.15	0924-3010-20	12.79	0924-3012-20	18.50
25	0924-3006-25	5.65	0924-3008-25	10.14	0924-3010-25	15.90	0924-3012-25	23.00
30	0924-3006-30	6.76	0924-3008-30	12.13	0924-3010-30	19.04	0924-3012-30	27.51
35	0924-3006-35	7.87	0924-3008-35	14.11	0924-3010-35	22.16	0924-3012-35	32.02
40	0924-3006-40	8.98	0924-3008-40	16.10	0924-3010-40	25.29	0924-3012-40	36.53
45	0924-3006-45	10.09	0924-3008-45	18.02	0924-3010-45	28.41	0924-3012-45	41.04
50	0924-3006-50	11.20	0924-3008-50	20.08	0924-3010-50	31.53	0924-3012-50	45.56
55	0924-3006-55	12.31	0924-3008-55	22.06	0924-3010-55	34.65	0924-3012-55	50.06
60	0924-3006-60	13.42	0924-3008-60	24.05	0924-3010-60	37.78	0924-3012-60	54.57

Note:
1. All the wt digit in above table unit is Kg.
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

案例展示

Case Presentation



UD

无螺纹拉弧螺柱

Unthreaded studs ype UD

Material: Mid steel 4.8

Specification: With flux

Recommend Welding Process: Cermaic ferrule welding



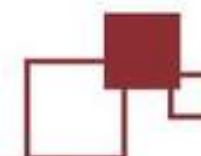
d_1	l_2	$d_2 \pm 0.1$	d_3	$y+2p$	h_4	$a \pm 7^\circ$	
M6	See table	5.35	9	5.5	3.5	140°	
M8		7.19	9.9	6	3		
M10		9.03	12.5	6.5	3.4		
M12		10.86	14.5	7.5	4.2		
M16		14.6	17.8	11	5.8		

d_1								
l_2 (mm)	Ø6		Ø8		Ø10		Ø12	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—
10	—	—	—	—	—	—	—	—
12	—	—	—	—	—	—	—	—
16	0914-3006-16	3.65	0914-3008-16	6.55	0914-3010-16	9.98	—	—
20	0914-3006-20	4.50	0914-3008-20	8.09	0914-3010-20	12.69	0914-3012-20	17.91
25	0914-3006-25	5.58	0914-3008-25	10.01	0914-3010-25	15.72	0914-3012-25	22.28
30	0914-3006-30	6.65	0914-3008-30	11.93	0914-3010-30	18.75	0914-3012-30	26.65
35	0914-3006-35	7.73	0914-3008-35	13.86	0914-3010-35	21.77	0914-3012-35	31.02
40	0914-3006-40	8.80	0914-3008-40	15.79	0914-3010-40	24.79	0914-3012-40	35.39
45	0914-3006-45	9.88	0914-3008-45	17.71	0914-3010-45	27.82	0914-3012-45	39.75
50	0914-3006-50	10.95	0914-3008-50	19.64	0914-3010-50	30.85	0914-3012-50	44.12
55	0914-3006-55	12.03	0914-3008-55	21.56	0914-3010-55	33.86	0914-3012-55	48.49
60	0914-3006-60	13.10	0914-3008-60	23.49	0914-3010-60	36.88	0914-3012-60	52.86

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



UD

无螺纹拉弧螺柱

Unthreaded studs type UD

Material: Stainless steel (A2-50,A4-50)

Specification: With flux

Recommend Welding Process: Cermaic ferrule welding



d_1	l_2	$d_2 \pm 0.1$	d_3	$y+2p$	h_4	$a \pm 7^\circ$	
M6	See table	5.35	9	5.5	3.5	140°	
M8		7.19	9.9	6	3		
M10		9.03	12.5	6.5	3.4		
M12		10.86	14.5	7.5	4.2		
M16		14.6	17.8	11	5.8		

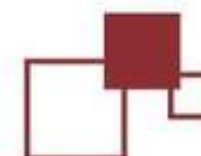
d_1								
l_2 (mm)	Ø6		Ø8		Ø10		Ø12	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
6	—	—	—	—	—	—	—	—
8	—	—	—	—	—	—	—	—
10	—	—	—	—	—	—	—	—
12	—	—	—	—	—	—	—	—
16	0924-3006-16	3.65	0924-3008-16	6.56	0924-3010-16	10.30	—	—
20	0924-3006-20	4.45	0924-3008-20	8.15	0924-3010-20	12.79	0924-3012-20	18.50
25	0924-3006-25	5.65	0924-3008-25	10.14	0924-3010-25	15.90	0924-3012-25	23.00
30	0924-3006-30	6.76	0924-3008-30	12.13	0924-3010-30	19.04	0924-3012-30	27.51
35	0924-3006-35	7.87	0924-3008-35	14.11	0924-3010-35	22.16	0924-3012-35	32.02
40	0924-3006-40	8.98	0924-3008-40	16.10	0924-3010-40	25.29	0924-3012-40	36.53
45	0924-3006-45	10.09	0924-3008-45	18.02	0924-3010-45	28.41	0924-3012-45	41.04
50	0924-3006-50	11.20	0924-3008-50	20.08	0924-3010-50	31.53	0924-3012-50	45.56
55	0924-3006-55	12.31`	0924-3008-55	22.06	0924-3010-55	34.65	0924-3012-55	50.06
60	0924-3006-60	13.42	0924-3008-60	24.05	0924-3010-60	37.78	0924-3012-60	54.57

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



ID

内螺纹拉弧螺柱

Studs with internal threaded Type ID

Material: Mid steel 4.8

Specification: Without flux

Recommend Welding Process: Shield gas welding



D ₆	d ₂ +0.1	d ₃	b+2p	h ₄	l ₂	a±7°
M5	10	13	7.5	4	See table	140°
M6	10	13	9	4		
M8	12	16	12	5		
M8	14.6	18.5	15	6		
M10	14.6	18.5	15	6		
M10	16	21	15	7		
M12	18.38	23	18	7		

D ₆								
l ₂ (mm)	Ø10-M5		Ø10-M6		Ø12-M8		Ø14.6-M8	
	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg
15	0814-2105-15	8.20	0814-2106-15	7.67	0814-2108-15	9.47	0814-2108-15	14.53
20	0814-2105-20	11.20	0814-2106-20	10.69	0814-2108-20	13.85	0814-2108-20	20.58
25	0814-2105-25	14.32	0814-2106-25	13.70	0814-2108-25	18.24	0814-2108-25	26.63
30	0814-2105-30	17.34	0814-2106-30	16.44	0814-2108-30	22.59	0814-2108-30	32.67

D ₆						
l ₂ (mm)	Ø14.6-M10		Ø16-M10		Ø18.38-M12	
	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg
15	0814-2110-15	10.63	0814-2110-15	15.89	0814-2112-15	16.53
20	0814-2110-20	16.68	0814-2110-20	23.69	0814-2112-20	26.53
25	0814-2110-25	22.73	0814-2110-25	31.49	0814-2112-25	36.53
30	0814-2110-30	28.77	0814-2110-30	39.29	0814-2112-30	46.54

Note:
 1. All the wt digit in above table unit is Kg.
 2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

ID

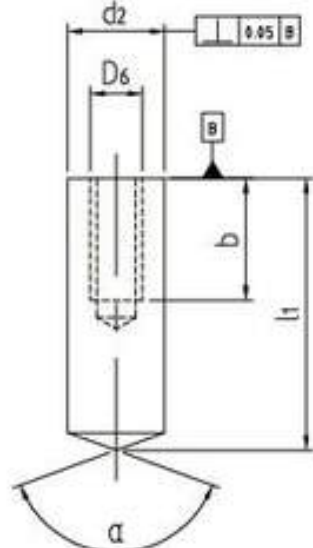
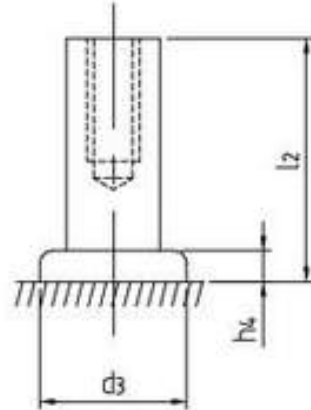
内螺纹拉弧螺柱

Studs with internal threaded Type ID

Material: Stainless steel (A2-50,A4-50)

Specification: Without flux

Recommend Welding Process: Shield gas welding

D ₆	d ₂ ±0.1	d ₃	b+2p	h ₄	l ₂	a±7°		
M5	10	13	7.5	4	See table	140°		
M6	10	13	9	4				
M8	12	16	12	5				
M8	14.6	18.5	15	6				
M10	14.6	18.5	15	6				
M10	16	21	15	7				
M12	18.38	23	18	7				

D ₆								
l ₂ (mm)	Ø10-M5		Ø10-M6		Ø12-M8		Ø14.6-M8	
	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg
15	0824-2105-15	8.56	0824-2106-15	8.40	0824-2108-15	9.73	0824-2108-15	16.18
20	0824-2105-20	11.68	0824-2106-20	10.80	0824-2108-20	14.14	0824-2108-20	22.88
25	0824-2105-25	14.80	0824-2106-25	14.10	0824-2108-25	18.65	0824-2108-25	29.58
30	0824-2105-30	17.93	0824-2106-30	17.20	0824-2108-30	27.67	0824-2108-30	36.27

D ₆						
l ₂ (mm)	Ø14.6-M10		Ø16-M10		Ø18.38-M12	
	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg
15	0824-2110-15	13.38	0824-2110-15	13.79	0824-2112-15	17.90
20	0824-2110-20	19.08	0824-2110-20	20.95	0824-2112-20	27.40
25	0824-2110-25	25.78	0824-2110-25	28.13	0824-2112-25	37.73
30	0824-2110-30	32.47	0824-2110-30	35.29	0824-2112-30	48.05

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

案例展示
Case Presentation



ID

内螺纹拉弧螺柱

Studs with internal threaded Type ID

Material: Mid steel 4.8

Specification: With flux

Recommend Welding Process: Cermaic ferrule welding



D_6	$d_2 \pm 0.1$	d_3	$b+2p$	h_4	l_2	$a \pm 7^\circ$		
M5	10	13	7.5	4	See table	140°		
M6	10	13	9	4				
M8	12	16	12	5				
M8	14.6	18.5	15	6				
M10	14.6	18.5	15	6				
M10	16	21	15	7				
M12	18.38	23	18	7				

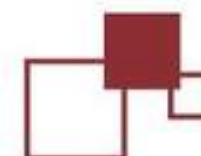
D_6								
l_2 (mm)	Ø10-M5		Ø10-M6		Ø12-M8		Ø14.6-M8	
	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg
15	0814-2105-15	8.20	0814-2106-15	7.67	0814-2108-15	9.47	0814-2108-15	14.53
20	0814-2105-20	11.20	0814-2106-20	10.69	0814-2108-20	13.85	0814-2108-20	20.58
25	0814-2105-25	14.32	0814-2106-25	13.70	0814-2108-25	18.24	0814-2108-25	26.63
30	0814-2105-30	17.34	0814-2106-30	16.44	0814-2108-30	22.59	0814-2108-30	32.67

D_6						
l_2 (mm)	Ø14.6-M10		Ø16-M10		Ø18.38-M12	
	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg
15	0814-2110-15	10.63	0814-2110-15	15.89	0814-2112-15	16.53
20	0814-2110-20	16.68	0814-2110-20	23.69	0814-2112-20	26.53
25	0814-2110-25	22.73	0814-2110-25	31.49	0814-2112-25	36.53
30	0814-2110-30	28.77	0814-2110-30	39.29	0814-2112-30	46.54

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



ID

内螺纹拉弧螺柱

Studs with internal threaded Type ID

Material: Stainless steel (A2-50,A4-50)

Specification: With flux

Recommend Welding Process: Cermaic ferrule welding



D_6	$d_2 \pm 0.1$	d_3	$b+2p$	h_4	l_2	$a \pm 7^\circ$	
M5	10	13	7.5	4	See table	140°	
M6	10	13	9	4			
M8	12	16	12	5			
M8	14.6	18.5	15	6			
M10	14.6	18.5	15	6			
M10	16	21	15	7			
M12	18.38	23	18	7			

D_6								
l_2 (mm)	Ø10-M5		Ø10-M6		Ø12-M8		Ø14.6-M8	
	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg
15	0824-2105-15	8.56	0824-2106-15	8.40	0824-2108-15	9.73	0824-2108-15	16.18
20	0824-2105-20	11.68	0824-2106-20	10.80	0824-2108-20	14.14	0824-2108-20	22.88
25	0824-2105-25	14.80	0824-2106-25	14.10	0824-2108-25	18.65	0824-2108-25	29.58
30	0824-2105-30	17.93	0824-2106-30	17.20	0824-2108-30	27.67	0824-2108-30	36.27

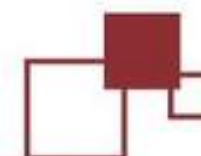
D_6						
l_2 (mm)	Ø14.6-M10		Ø16-M10		Ø18.38-M12	
	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg	Order No.	Wt 1000/kg
15	0824-2110-15	13.38	0824-2110-15	13.79	0824-2112-15	17.90
20	0824-2110-20	19.08	0824-2110-20	20.95	0824-2112-20	27.40
25	0824-2110-25	25.78	0824-2110-25	28.13	0824-2112-25	37.73
30	0824-2110-30	32.47	0824-2110-30	35.29	0824-2112-30	48.05

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



PS

带法兰外螺纹螺柱

Threaded studs with flange type PS

短周期螺柱的设计为了解决将螺柱焊接在薄金属板上的难题，通常使用短周期模式下的拉弧式焊接方法。短周期螺柱焊接完后带有一个法兰焊接底座，焊接底座的直径略大于其自身螺纹外径，超出约为1/32英寸（1mm）。“C”法兰允许自动螺柱进料，以提高生产速度，通常生产的长度从10毫米到35毫米。

Short cycle studs are designed to be welded to thin sheet metal using the drawn-arc method of stud welding or rectifier power-control source in the short-cycle mode.

Short cycle studs have a flanged weld base that is about 1/32" (1mm) greater than the nominal stud diameter. The "C" flange allows automatic stud feeding for increased production speeds and the length produced from 10mm to 35mm normally.

Material: Mild steel 4.8, 6.8 or 8.8

Surface: Copper planted

Recommend Welding Process: Shield gas welding



d_1	$l_1+0.6$	$d_2 \pm 0.2$	$h_5 \max$	h_1	$\alpha+2^\circ$	
M5	See table	6	1.0	0.7-1.4	166°	
M6		7				
M8		9	1.5	0.8-1.4		

d_1								
l_1 (mm)	M5		M6		M8		M10	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
8	1011-1105-08	6.10	1011-1106-08	1.45	—	—	—	—
10	1011-1105-10	1.25	1011-1106-10	1.80	1011-1108-10	3.29	—	—
12	1011-1105-12	1.55	1011-1106-12	2.40	1011-1108-12	3.95	—	—
16	1011-1105-16	1.88	1011-1106-16	2.75	1011-1108-16	5.20	1011-1110-16	8.45
20	1011-1105-20	2.40	1011-1106-20	3.30	1011-1108-20	6.50	1011-1110-20	10.6
25	1011-1105-25	3.00	1011-1106-25	3.50	1011-1108-25	7.85	1011-1110-25	13
30	1011-1105-30	3.65	1011-1106-30	4.35	1011-1108-30	9.40	1011-1110-30	15.4
35	1011-1105-35	4.26	1011-1106-35	5.23	1011-1108-35	10.80	1011-1110-35	17.8
40	1011-1105-40	4.87	1011-1106-40	6.95	1011-1108-40	12.30	1011-1110-40	20

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

PS

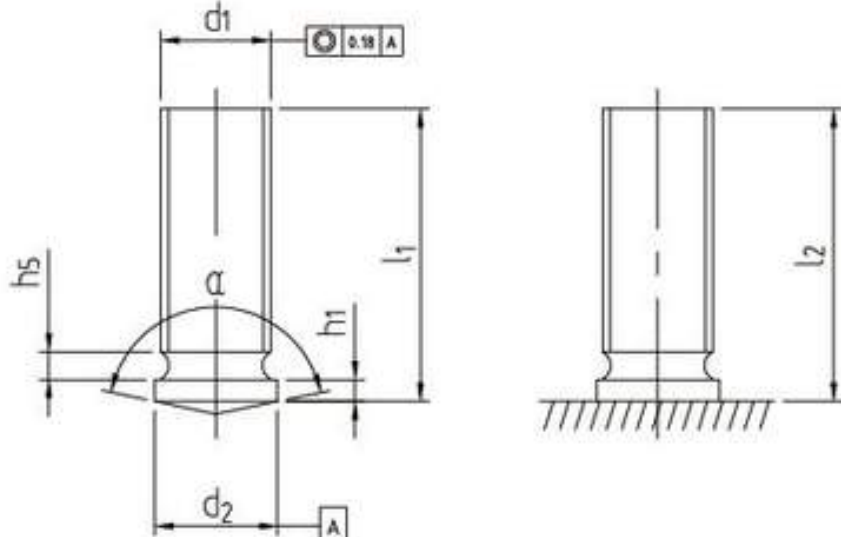
带法兰外螺纹螺柱

Threaded studs with flange type PS

Material: Stainless steel (A2-50,A4-50)

Recommend Welding Process: Shield gas welding



d_1	$l_1+0.6$	$d_2\pm0.2$	$h_5\max$	h_1	$a+2^\circ$	
M5	See table	6	1.0	0.7-1.4	166°	
M6		7				
M8		9	1.5	0.8-1.4		

d_1								
l_1 (mm)	M5		M6		M8		M10	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
8	1024-1105-08	0.90	1024-1106-08	1.50	—	—	—	—
10	1024-1105-10	1.28	1024-1106-10	1.87	1024-1108-10	3.77	—	—
12	1024-1105-12	1.42	1024-1106-12	2.25	1024-1108-12	4.39	—	—
16	1024-1105-16	1.80	1024-1106-16	2.65	1024-1108-16	5.65	1024-1110-16	8.98
20	1024-1105-20	2.40	1024-1106-20	3.56	1024-1108-20	6.90	1024-1110-20	10.98
25	1024-1105-25	3.05	1024-1106-25	4.40	1024-1108-25	8.48	1024-1110-25	13.50
30	1024-1105-30	3.63	1024-1106-30	5.25	1024-1108-30	10.05	1024-1110-30	15.97
35	1024-1105-35	4.25	1024-1106-35	6.10	1024-1108-35	11.61	1024-1110-35	18.46
40	1024-1105-40	4.85	1024-1106-40	6.96	1024-1108-40	13.18	1024-1110-40	20.96

Note:

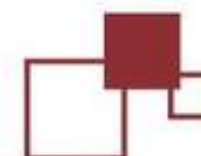
1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

案例展示
Case Presentation



专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



US

带法兰无螺纹螺柱

Unthreaded studs with flange type US

Material: Mild steel 4.8, 6.8 or 8.8

Surface: Copper planted

Recommend Welding Process: Shield gas welding



$d_1 \pm 0.1$	$l_1 + 0.6$	$d_2 \pm 0.2$	h_1	$a \pm 2^\circ$
5	See table	6	0.7-1.40	166°
6		7		
7.1		9	0.80-1.40	
8				

d_1								
l_1 (mm)	Ø5		Ø6		Ø7.1		Ø8	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
8	1211-3005-08	6.10	1211-3006-08	1.45	—	—	—	—
10	1211-3005-10	1.25	1211-3006-10	1.80	1211-3007-10	3.64	1211-3008-10	4.62
12	1211-3005-12	1.55	1211-3006-12	2.40	1211-3007-12	4.26	1211-3008-12	5.39
16	1211-3005-16	1.88	1211-3006-16	2.75	1211-3007-16	5.47	1211-3008-16	6.93
20	1211-3005-20	2.40	1211-3006-20	3.30	1211-3007-20	6.69	1211-3008-20	8.47
25	1211-3005-25	3.00	1211-3006-25	3.50	1211-3007-25	8.21	1211-3008-25	10.39
30	1211-3005-30	3.65	1211-3006-30	4.35	1211-3007-30	9.73	1211-3008-30	12.32
35	1211-3005-35	4.26	1211-3006-35	5.23	1211-3007-35	11.25	1211-3008-35	14.25
40	1211-3005-40	4.87	1211-3006-40	6.95	1211-3007-40	12.77	1211-3008-40	16.17

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

US

带法兰无螺纹螺柱

Unthreaded studs with flange type US

Material: Stainless steel (A2-50,A4-50)

Recommend Welding Process: Shield gas welding



$d_1 \pm 0.1$	$l_1 \pm 0.6$	$d_2 \pm 0.2$	h_1	$a \pm 2^\circ$
5	See table	6	0.7-1.40	166°
6		7		
7.1		9	0.80-1.40	
8				

Technical drawing of a stud. The main view shows a vertical cylinder with dimensions: d_1 (top diameter), l_1 (height), d_2 (base diameter), h_1 (base height), and a (base angle). A detail view shows a circular feature with diameter $\phi 0.18$ and feature A.

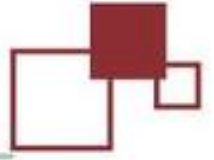
d_1								
l_1 (mm)	Ø5		Ø6		Ø7.1		Ø8	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
8	1224-3005-08	0.90	1224-3006-08	1.50	—	—	—	—
10	1224-3005-10	1.28	1224-3006-10	1.87	1224-3007-10	3.58	1224-3008-10	3.77
12	1224-3005-12	1.42	1224-3006-12	2.25	1224-3007-12	4.21	1224-3008-12	4.39
16	1224-3005-16	1.80	1224-3006-16	2.65	1224-3007-16	5.46	1224-3008-16	5.65
20	1224-3005-20	2.40	1224-3006-20	3.56	1224-3007-20	6.75	1224-3008-20	6.90
25	1224-3005-25	3.05	1224-3006-25	4.40	1224-3007-25	8.27	1224-3008-25	8.48
30	1224-3005-30	3.63	1224-3006-30	5.25	1224-3007-30	9.83	1224-3008-30	10.05
35	1224-3005-35	4.25	1224-3006-35	6.10	1224-3007-35	11.39	1224-3008-35	30.61
40	1224-3005-40	4.85	1224-3006-40	6.96	1224-3007-40	12.95	1224-3008-40	13.18

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).





IS

带法兰内螺纹螺柱

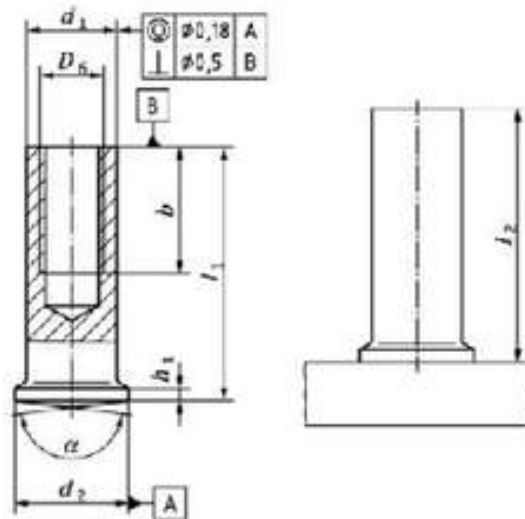
Studs with internal threaded and flange type IS

Material: Mild steel 4.8, 6.8 or 8.8

Surface: Copper plated

Recommend Welding Process: Shield gas welding



D ₆	l ₁ +0.6	b+2P	d ₂ ±0.2	d ₁ ±0.1	h ₁	a±2°	
M3	See table	5	6.0	5.0	0.7-1.40	166°	
M4		6	7.0	6.0			
M5			9.0	7.1	0.80-1.40		
M5				7.5			
M6		9					

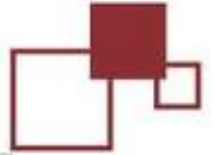
d_1								
l_1 (mm)	Ø5/M3		Ø6/M4		Ø7.1/M5		Ø8/M6	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
8	1111-2103-08	6.10	1111-2104-08	1.45	—	—	—	—
10	1111-2103-10	1.25	1111-2104-10	1.80	1111-2105-10	2.88	1111-2106-10	3.29
12	1111-2103-12	1.55	1111-2104-12	2.40	1111-2105-12	3.49	1111-2106-12	3.95
16	1111-2103-16	1.88	1111-2104-16	2.75	1111-2105-16	4.70	1111-2106-16	5.20
20	1111-2103-20	2.40	1111-2104-20	3.30	1111-2105-20	5.91	1111-2106-20	6.50
25	1111-2103-25	3.00	1111-2104-25	3.50	1111-2105-25	7.42	1111-2106-25	7.85

Note:

1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



SC

木螺纹螺柱 SC Fir Tree Studs

Material: Mild steel (4.8, 6.8 or 8.8)

Surface: Copper planted

Recommend Welding Process: Shield gas welding



	d_1	$l_1+0.6$	d_3	
SC Tree studs	5.0	See table	6.0	
	6.0		7.0	

l_1 (mm)	d_1			
	Ø5		Ø6	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
9	1311-1105-09	1.80	1311-1106-09	2.65
14.2	1311-1105-14.2	2.40	1311-1106-14.2	3.56
18	1311-1105-18	3.05	1311-1106-18	4.40
25	1311-1105-25	3.63	1311-1106-25	5.25

Note:
1. All the wt digit in above table unit is Kg.
2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

油槽短周期螺柱 Paint Clearing threaded Studs

Material: Mild steel (4.8, 6.8 or 8.8)

Surface: Copper planted

Recommend Welding Process: Shield gas welding



d_1	$l_1+0.6$	$d_2\pm0.2$	$d_4\pm0.08$	$l_3\pm0.05$	h_1	$a\pm1^\circ$	
M5	See table	6.50	0.75	0.80	0.70-1.40	3°	
M6		7.50					
M8		9		0.85	0.80-1.40		

d_1						
l_1 (mm)	M5		M6		M8	
	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS	Order No.	Wt 1000/PCS
10	1011-1105-10	1.25	1011-1106-10	1.80	1011-1108-10	3.29
12	1011-1105-12	1.55	1011-1106-12	2.40	1011-1108-12	3.95
16	1011-1105-16	1.88	1011-1106-16	2.75	1011-1108-16	5.20
20	1011-1105-20	2.40	1011-1106-20	3.30	1011-1108-20	6.50
25	1011-1105-25	3.00	1011-1106-25	3.50	1011-1108-25	7.85
30	1011-1105-30	3.65	1011-1106-30	4.35	1011-1108-30	9.40

Note:

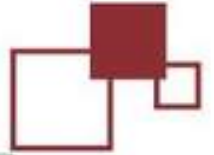
1. All the wt digit in above table unit is Kg.

2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).

案例展示
Case Presentation



专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS

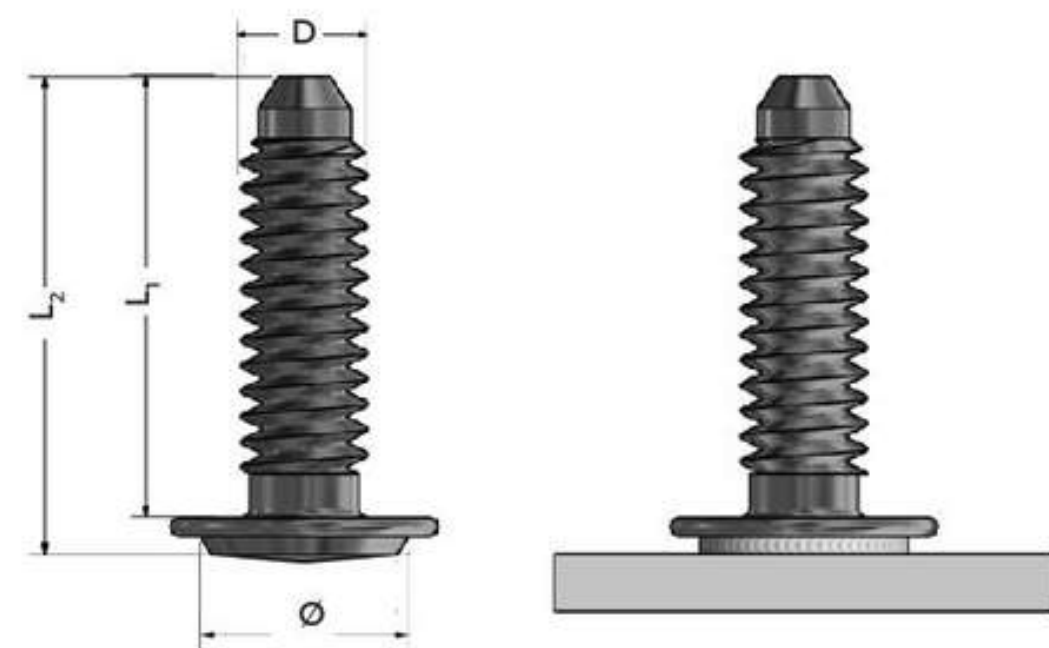


大法兰短周期螺柱 Large Flange Short cycle Studs

这款螺钉主要供货汽车行业应用，由于每个汽车主机厂的独立设计，导致每个主机厂所设计的大法兰螺钉的尺寸都有所差异。这款螺钉普遍使用的长度从12mm到20mm之间。所以针对该款螺钉，公司将根据客户的具体图纸进行评审后反馈交货期及价格。

Large Flange Ground Studs main supply to auto industry caused the stud's dimensions are different for each customer. The studs length can be produced from 12mm to 20mm in Zhuan Cheng factory. So this studs not standard parts it needs depend on customer's drawing to review and reply to delivery time and price upon request.

Material: Mild steel (4.8, 6.8 or 8.8)
Surface: Copper planted
Recommend Welding Process: Shield gas welding



Short Cycle Large Flange Studs					
D	$\varnothing \pm 0.2$	$L_1 + 0.6$	$L_2 + 0.6$	Material Grade	Coating
M6	13	18.5	12	4.8/6.8/8.8	Copper/Znic
M6	13	17.7	16	4.8/6.8/8.8	Copper/Znic
M6	13	20	18	4.8/6.8/8.8	Copper/Znic
M6	13	20	20	4.8/6.8/8.8	Copper/Znic

Note:
 1. All the wt digit in above table unit is Kg.
 2. Studs' threads are available in both imperial UNC-2A and Metric (Class 6g).



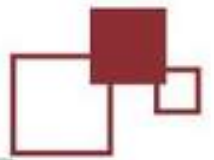
非标焊接螺柱 Non-Standard weld Studs



非标焊接螺柱 Non-Standard weld Studs



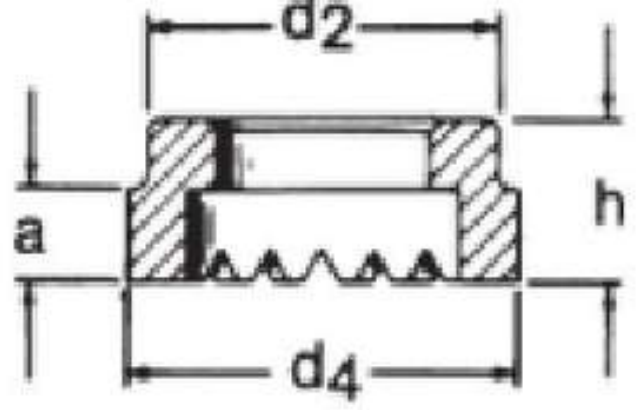
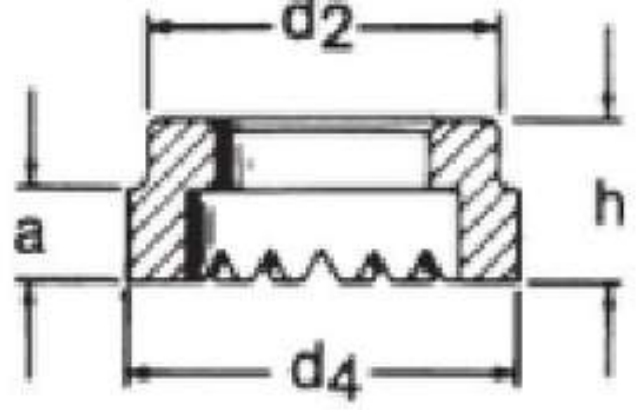
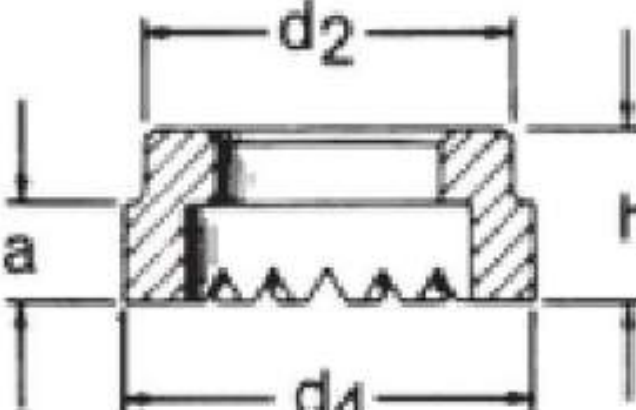
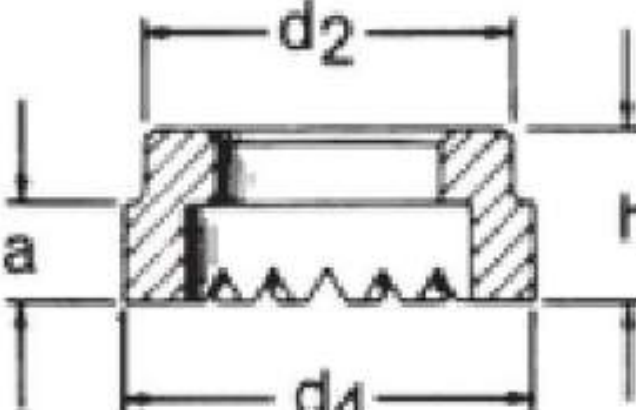
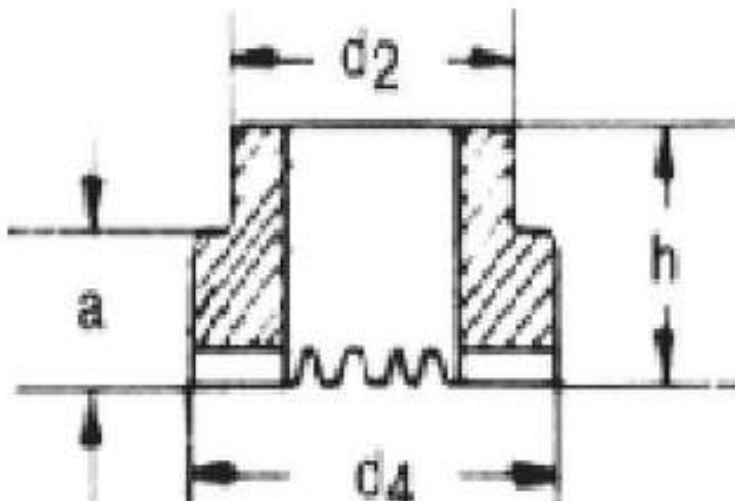
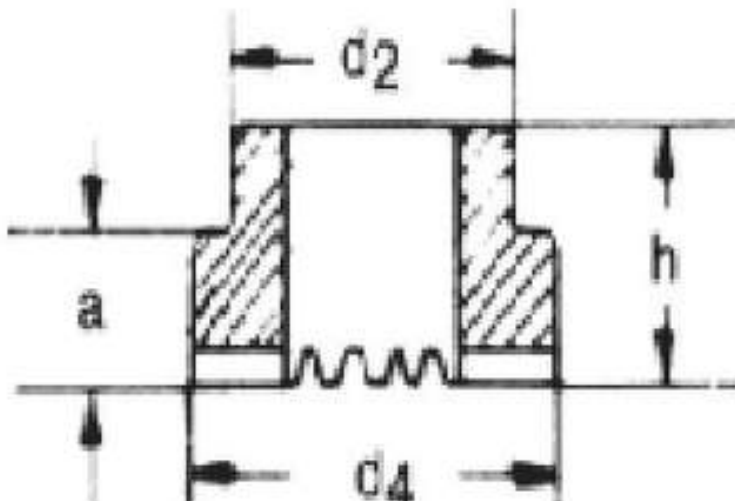
专成牌螺柱焊钉
SPECIALIZED BRAND WELDING STUDS



陶瓷磁环 Ceramic Ferrules

陶瓷环是拉弧焊接工艺过程中的一种必要的辅助焊接耗材。陶瓷环的设计是为了让螺柱在焊接过程中保护电弧不产生偏弧，也使得熔融金属材料能够被限制在螺柱根部的一定空间内成型。陶瓷环可以充当熔焊金属材料的模具，它能够让熔焊的金属材料的在螺柱的根部形成比较统一的形状，也称焊瘤。本图册中介绍的几种普遍常用的磁环都是在螺柱垂直母材表面焊接的工艺中使用。

Ceramic ferrules are an essential part of the standard drawn arc stud welding process. They are designed to encircle the weld stud to protect the weld arc and limit it to a specific area of the base material. They also contain the molten weld metal and act as a mold to give a uniform shape to this metal, also called the weld flash. These ferrules are intended for welding round studs perpendicular to flat surfaces.

Ferrules					
Type	Ø d2 (mm)	Ø d4 (mm)	a (mm)	h (mm)	
	± 0,3	± 0,4	± 0,3	± 0,3	
PF 6	9,6	11,6	4,7	8,7	
PF 8	11,3	13,6	3,2	6,5	
PF 10	14,8	17,8	3,5	6,7	
PF 12	16,5	20,0	5,2	9,2	
PF 16	19,9	26,0	7,0	11,0	
UF Series					
UF 8	14,8	17,8	4,7	8,7	
UF 10	14,8	17,8	5,1	9,9	
UF 12	19,9	22,2	5,9	10,6	
UF 16	26,1	26,1	8,6	13,3	
UF 19	26,1	30,8	11,9	16,7	
UF 20	26,1	32,8	9,5	14,2	
UF 22	30,7	38,5	13,8	18,6	
UF 25	35,5	40,5	16,5	20,8	
RF Series					
RF 6	9,6	11,6	5,9	10,0	
RF 8	12,5	15,4	7,1	11,0	
RF 10	14,8	17,8	7,1	11,0	
RF 12	16,5	20,1	8,3	13,0	
RF 16	19,9	26,1	9,9	14,7	

**为客户创造价值，提供有
竞争力螺柱焊解决方案和服务**







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