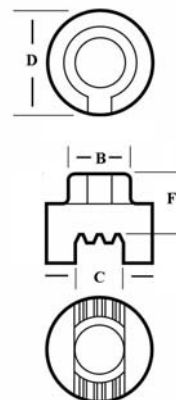


NELSON STUD WELDING

FERRULE SPECIFICATIONS: *Welding to Edges of Base Plates*

Over the years, Nelson Stud Welding has developed several ferrules that permit welding of full base studs to the edges of plate or bars that are the same thickness as the stud diameter.

These ferrules are constructed with ears or tabs, which extend down over the sides of the base material, and with vents and a cavity that is limited to the base material thickness. Due to the limited base material width, the weld cavities are run along the edge for a distance greater than the normal flash diameter used for welding studs perpendicular to flat plates. This special ferrule design allows development of full stud strength when welding to the edges of plates or bars.



Stud Diameter A	Base Material Thickness C	Ferrule Neck Diameter B	Major Diameter D	Effective Height F	Overall Height M	Ferrule Part Number
1/4	1/4	0.380	0.555	0.468	0.468	100101223
3/8	3/8	0.650	0.795	0.562	0.577	100101204
1/2	1/2	0.785	1.030	0.625	0.640	100101205

The neck diameters of the ferrules are shown to assist in the selection of ferrule tube, ferrule holders, and foot plates.

The 3/8" and the 1/2" ferrules have standard necks, while the neck of the 1/4" ferrule has an orientation key on the neck. The key on the 1/4" ferrule requires either bending up one of the narrow gripping tines on the standard 1/4" ferrule grip, #501001005, or the use of a special 1/4" grip, #501008005, which has two notches in it to accept the key on the neck of the ferrule, as well as the two normal gripping tines.

The #100101223 ferrule has the orientation key because it was designed for use with a production unit, where the ferrule must be aligned with the base material. The 3/8" and 1/2" ferrules without the key on the neck were designed for use with hand held guns, where the gun can be turned to align the ferrule with the base material.

These ferrules are designed for use with Nelson full base diameter studs. This includes **H4L, S3L, D2L, NBL, TBL**, and other stud styles having full diameter weld bases.

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