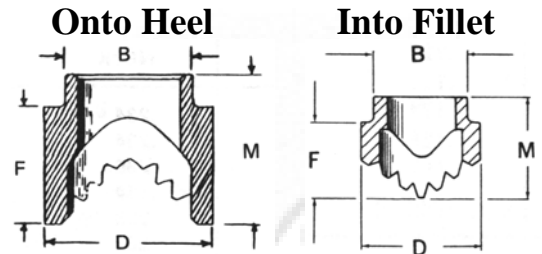


NELSON STUD WELDING

FERRULE SPECIFICATIONS: Special Ferrule for Welding Into Fillets and Onto Heels

The radius of the tip of these ferrules is important. The radius of the ferrules needs to match the radius on the angle to which the studs are to be welded in order to properly shield the weld arc and prevent the loss of metal.

If the radius and the angle cannot be determined, it is better to select the ferrule with the larger radius since it is less detrimental to have a gap at the center of the angle than along both edges of the angle.



Into Fillet – inside corner of 90° angle

Stud Diameter A	Radius	Neck Diameter B	Major Diameter D	Height to Neck F	Height Overall M	Ferrule Part Number
1/4	0.125	0.380	0.578	0.350	0.500	100106001
3/8	0.250	0.505	0.640	0.375	0.480	100106002
1/2	0.375	0.650	0.795	0.500	0.688	100103011
5/8	0.375	0.785	1.030	0.687	0.875	100106005
1/2	0.250	0.650	0.687	0.795	0.500	100103009
3/4	0.750	1.030	1.218	0.687	0.875	100103012
3/4	0.375	1.030	1.218	0.562	0.937	100106004

Onto Heel – outside corner of 90° angle

Stud Diameter A	Neck Diameter B	Major Diameter D	Height to Neck F	Height Overall M	Ferrule Part Number
1/4	0.380	0.555	0.125	0.380	100102005
3/8	0.585	0.703	0.550	0.706	100105001
1/2	0.785	1.030	0.625	0.812	100105002
5/8	0.785	1.030	0.703	0.891	100101003
3/4	1.303	1.215	0.844	1.031	100105005
7/8	1.210	1.410	0.938	0.938	100105006

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