

NELSON STUD WELDING FERRULE SPECIFICATION

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. The term, weld flash, is used to distinguish the weld metal at the base of a stud from the weld metal deposited by other arc welding processes, which is called weld fillet.

Standard Ferrules

These studs are intended for welding round studs perpendicular to flat surfaces.

Full Base – These standard ferrules are standard ferrules supplied with full weld base **NBL, TBL, FHL, S3L, and D3L** studs.

| Nominal Stud Size | Inside Diameter A | Neck Diameter B | Major Diameter D | Height to Neck F | Height Overall M | Ferrule Part Number |
|-------------------|-------------------|-----------------|------------------|------------------|------------------|---------------------|
| #6 | 0.138 | 0.261 | 0.375 | 0.234 | 0.390 | 100101001 |
| #8 | 0.164 | 0.291 | 0.375 | 0.234 | 0.390 | 100101002 |
| #10 | 0.187 | 0.305 | 0.390 | 0.234 | 0.390 | 100101003 |
| 1/4 | 0.250 | 0.505 | 0.640 | 0.295 | 0.437 | 100101007 |
| 5/16 | 0.312 | 0.445 | 0.578 | 0.234 | 0.390 | 100101007 |
| 3/8 | 0.375 | 0.600 | 0.795 | 0.235 | 0.390 | 100101009 |
| 7/16 | 0.437 | 0.565 | 0.795 | 0.234 | 0.422 | 100101009 |
| 1/2 | 0.500 | 0.795 | 0.875 | 0.228 | 0.390 | 100101114 |
| 5/8 | 0.562 | 0.795 | 1.030 | 0.328 | 0.515 | 100101011 |
| 3/4 | 0.625 | 1.030 | 1.150 | 0.339 | 0.526 | 100101187 |
| 7/8 | 0.750 | 1.030 | 1.215 | 0.469 | 0.656 | 100101153 |
| 1-1/8 | 0.813 | 1.210 | 1.735 | 0.290 | 0.464 | 100101178 |
| 1 1/2 | 0.875 | 1.210 | 1.413 | 0.545 | 0.730 | 100101140 |
| 1 | 1.000 | 1.405 | 1.610 | 0.633 | 0.820 | 100101045 |
| 1-1/8 | 1.125 | 1.541 | 1.795 | 0.503 | 0.815 | 100101143 |
| 1-1/4 | 1.250 | 2.015 | 2.015 | 1.030 | 1.030 | 100101146 |

Full Base – Thin Wall – These special order ferrules are available for full base studs to accommodate special situations or fixturing.

| Nominal Stud Size | Inside Diameter A | Neck Diameter B | Major Diameter D | Height to Neck F | Height Overall M | Ferrule Part Number |
|-------------------|-------------------|-----------------|------------------|------------------|------------------|---------------------|
| 1/4 | 0.250 | 0.380 | 0.455 | 0.265 | 0.390 | 100101006 |
| 3/8 | 0.375 | 0.505 | 0.640 | 0.234 | 0.390 | 100101008 |
| 1/2 | 0.500 | 0.650 | 0.795 | 0.250 | 0.438 | 100101010 |
| 5/8 | 0.625 | 0.795 | 1.030 | 0.328 | 0.515 | 100101012 |

Full Base – Low Profile, F-139 – These ferrules are available for **short studs**

| Nominal Stud Size | Inside Diameter A | Neck Diameter B | Major Diameter D | Height to Neck F | Height Overall M | Ferrule Part Number |
|-------------------|-------------------|-----------------|------------------|------------------|------------------|---------------------|
| #10 | 0.187 | 0.305 | 0.390 | 0.125 | 0.250 | 100101063 |
| 1/4 | 0.250 | 0.370 | 0.455 | 0.125 | 0.250 | 100101077 |
| 5/16 | 0.312 | 0.505 | 0.596 | 0.125 | 0.250 | 100101030 |
| 3/8 | 0.375 | 0.585 | 0.675 | 0.125 | 0.250 | 100101031 |
| 7/16 | 0.437 | 0.650 | 0.740 | 0.125 | 0.261 | 100101032 |
| 1/2 | 0.500 | 0.795 | 0.875 | 0.174 | 0.330 | 100101033 |
| 1/2 | 0.500 | 0.901 | 1.030 | 0.125 | 0.312 | 100101119 |
| 5/8 | 0.625 | 0.901 | 1.030 | 0.187 | 0.375 | 100101126 |
| 3/4 | 0.750 | 1.210 | 1.413 | 0.203 | 0.390 | 100101133 |
| 5/8 | 0.375 | 0.795 | 0.875 | 0.190 | 0.281 | 100101101 |
| 1/2 | 0.500 | 1.062 | 1.187 | 0.125 | 0.281 | 100101122 |



To determine the ferrule grips, ferrule holders, or ferrule tubes that can be used with specific ferrule types, look at the neck diameter (inside diameter) of the ferrule, then look in the accessories catalog for ferrule grips, holders, or tubes to match that inside diameter.

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

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L Towne

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the L Towne text.

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