



STUD WELDING GUIDELINES

- Keep weld studs and ferrules clean and dry.
- Set the time for the appropriate weld base diameter (see chart below).
- Set the amperage for the appropriate weld base diameter (see chart below).
- Make sure the negative polarity is to the weld stud gun and ensure a good, clean ground connection.
- Align accessories so they are centered and adjust legs so that 3/16" to 1/4" of the stud protrudes beyond the ferrule.
- Make sure work surface is relatively clean so impurities do not affect weld.
- Test the welds at the beginning of each shift or change in stud. Bend two studs 30 degrees after cooling (AWS Bend Test).
- Check burn off (1/8" – 3/16"), color (silver blue and shiny), and weld fillet (360 degree).
- Visually inspect all welds.

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

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