

ARC WELD Studs

Full Thread Mild Steel

		BODY DIAMETER & THREAD PITCH					
		1/4-20	5/16-18	3/8-16	1/2-13	5/8-11	3/4-10
Length	5/8	FTC25-62	FTC31-62	FTC37-62			
	3/4	FTC25-75	FTC31-75	FTC37-75			
	7/8	FTC25-87	FTC31-87	FTC37-87			
	1	FTC25-1	FTC31-1	FTC37-1	FTC50-1		
	1 1/8	FTC25-112	FTC31-112	FTC37-112	FTC50-112		
	1 1/4	FTC25-125	FTC31-125	FTC37-125	FTC50-125		
	1 3/8	FTC25-137	FTC31-137	FTC37-137	FTC50-137		
	1 1/2	FTC25-150	FTC31-150	FTC37-150	FTC50-150		
	1 5/8	FTC25-162	FTC31-162	FTC37-162	FTC50-162	FTC62-162	FTC75-162
	1 3/4	FTC25-175	FTC31-175	FTC37-175	FTC50-175	FTC62-175	FTC75-175
	1 7/8	FTC25-187	FTC31-187	FTC37-187	FTC50-187	FTC62-187	FTC75-187
	2	FTC25-2	FTC31-2	FTC37-2	FTC50-2	FTC62-2	FTC75-2
	2 1/4	FTC25-225	FTC31-225	FTC37-225	FTC50-225	FTC62-225	FTC75-225
	2 1/2	FTC25-250	FTC31-250	FTC37-250	FTC50-250	FTC62-250	FTC75-250
	2 3/4	FTC25-275	FTC31-275	FTC37-275	FTC50-275	FTC62-275	FTC75-275
	3	FTC25-3	FTC31-3	FTC37-3	FTC50-3	FTC62-3	FTC75-3
	MIN L	5/8	5/8	5/8	1	1 5/8	1 5/8
	MAX L	Up to 3" is considered a stocking size. Beyond 3" is a custom order.					
Fillet	Height	.12 ± .02"	.12 ± .02"	.14 ± .02"	.17 ± .02"	.25 ± .02"	.32 ± .02"
	Diameter	.36 ± .02"	.43 ± .02"	.49 ± .02"	.63 ± .02"	.77 ± .02"	.97 ± .02"
After Weld Length Reduction (approx)		.12"	.12"	.12"	.12"	.19"	.19"

STANDARD ACCESSORIES						
Chuck	C25	C31	C37	C50	C62	C75
Grip	G25	G31	G37	G50	G62	G75
Foot	FTS20	FTS20	FTS20	FTS20	FTM20	FTM20
Ferrule	25F	31F	37F	50F	62F	75F

MECHANICAL PROPERTIES						
(see appendix tables for calculation details particularly when comparing different manufacturers)						
Min Working Tensile	1,074 lb	1,770 lb	2,615 lb	4,789 lb	7,628 lb	11,288 lb
Min Yield Shear	918 lb	1,513 lb	2,236 lb	4,094 lb	6,520 lb	9,649 lb
Min Working Torque	4.5 ft•lb	9.3 ft•lb	16.3 ft•lb	39.9 ft•lb	79.4 ft•lb	141.1 ft•lb
Min Yield Torque	5.4 ft•lb	11.1 ft•lb	19.6 ft•lb	47.9 ft•lb	95.3 ft•lb	169.3 ft•lb

Full Thread Studs are one of the two most common studs. The threads on a Full Thread Stud run the full length of the fastener (hence full thread). This simplifies many mating part concerns and is a favorite of engineering. A Pitch Diameter Stud requires that the mating part(s) cover the unthreaded portion of the fastener. Also, a Pitch Diameter Stud is marginally stronger in shear than a Full Thread Stud due to the slightly larger diameter in the shear area.



IMAGE INDUSTRIES INC.

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Full Thread Stainless Steel

DRAWN ARC WELD STUD

		BODY DIAMETER & THREAD PITCH					
		1/4-20	5/16-18	3/8-16	1/2-13	5/8-11	3/4-10
Length	5/8	FTS25-62	FTS31-62	FTS37-62			
	3/4	FTS25-75	FTS31-75	FTS37-75			
	7/8	FTS25-87	FTS31-87	FTS37-87			
	1	FTS25-1	FTS31-1	FTS37-1	FTS50-1		
	1 1/8	FTS25-112	FTS31-112	FTS37-112	FTS50-112		
	1 1/4	FTS25-125	FTS31-125	FTS37-125	FTS50-125		
	1 3/8	FTS25-137	FTS31-137	FTS37-137	FTS50-137		
	1 1/2	FTS25-150	FTS31-150	FTS37-150	FTS50-150		
	1 5/8	FTS25-162	FTS31-162	FTS37-162	FTS50-162	FTS62-162	FTS75-162
	1 3/4	FTS25-175	FTS31-175	FTS37-175	FTS50-175	FTS62-175	FTS75-175
	1 7/8	FTS25-187	FTS31-187	FTS37-187	FTS50-187	FTS62-187	FTS75-187
	2	FTS25-2	FTS31-2	FTS37-2	FTS50-2	FTS62-2	FTS75-2
	2 1/4	FTS25-225	FTS31-225	FTS37-225	FTS50-225	FTS62-225	FTS75-225
	2 1/2	FTS25-250	FTS31-250	FTS37-250	FTS50-250	FTS62-250	FTS75-250
	2 3/4	FTS25-275	FTS31-275	FTS37-275	FTS50-275	FTS62-275	FTS75-275
	3	FTS25-3	FTS31-3	FTS37-3	FTS50-3	FTS62-3	FTS75-3
		MIN L	5/8	5/8	5/8	1	1 5/8
	MAX L	Up to 3" is considered a stocking size. Beyond 3" is a custom order.					
Fillet	Height	.12 ± .02"	.12 ± .02"	.14 ± .02"	.17 ± .02"	.25 ± .02"	.32 ± .02"
	Diameter	.36 ± .02"	.43 ± .02"	.49 ± .02"	.63 ± .02"	.77 ± .02"	.97 ± .02"
After Weld Length Reduction (approx)		.12"	.12"	.12"	.12"	.19"	.19"

STANDARD ACCESSORIES						
Chuck	C25	C31	C37	C50	C62	C75
Grip	G25	G31	G37	G50	G62	G75
Foot	FTS20	FTS20	FTS20	FTS20	FTM20	FTM20
Ferrule	25F	31F	37F	50F	62F	75F

MECHANICAL PROPERTIES						
(see appendix tables for calculation details particularly when comparing different manufacturers)						
Min Working Tensile	644 lb	1,062 lb	1,569 lb	2,873 lb	4,577 lb	6,773 lb
Min Yield Shear	551 lb	908 lb	1,341 lb	2,456 lb	3,912 lb	5,790 lb
Min Working Torque	2.7 ft•lb	5.5 ft•lb	9.8 ft•lb	23.9 ft•lb	47.7 ft•lb	84.7 ft•lb
Min Yield Torque	3.3 ft•lb	6.7 ft•lb	11.8 ft•lb	28.8 ft•lb	57.2 ft•lb	101.6 ft•lb

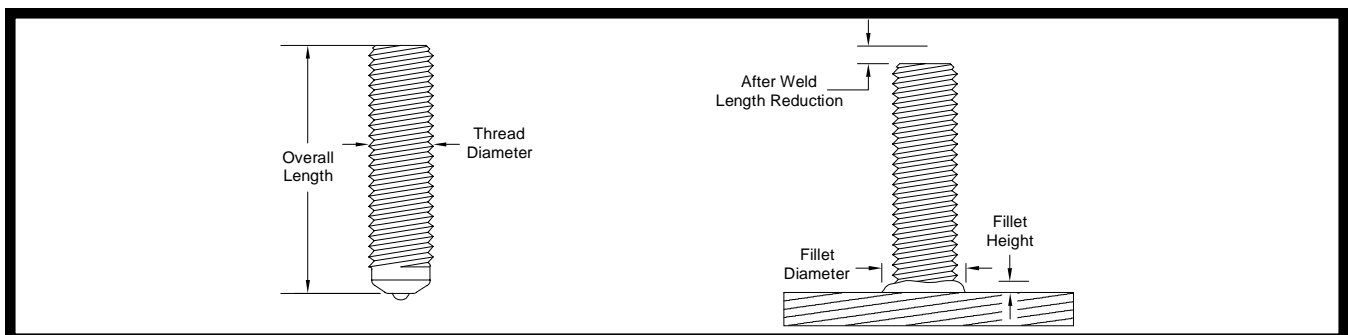


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