

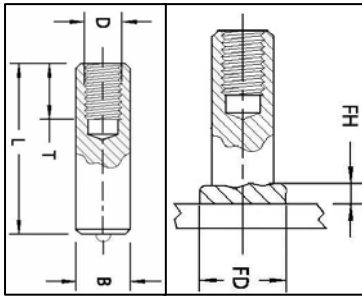


TRU-WELD Stud Welding

INTERNALLY TAPPED STUD – FULL WELD BASE

TYPE IT STUD

TYPE F FERRULE SUPPLIED



| B Stud Diameter | D Tap Diameter | L Length (BW) | T Tap Depth | TRU-WELD Part Number | FD Weld Fillet Diameter | FH Weld Fillet Height | Ferrule Part Number |
|-----------------------|----------------------|---------------------|-------------------|-------------------------|-------------------------------|-----------------------------|------------------------|
| 1/4 | #8-32 | 5/8 | 1/4 | IT04-010-11-IC-004 | 23/64 | 7/64 | FER04-F |
| 5/16 | #10-24 | 5/8 | 5/16 | IT05-010-11-KF-005 | 7/16 | 7/64 | FER05-F |
| 3/8 | 1/4-20 | 13/16 | 3/8 | IT06-013-11-04-006 | 1/2 | 1/8 | FER06-F |
| 7/16 | 5/16-18 | 1 | 1/2 | IT07-016-11-05-008 | 19/32 | 9/64 | FER07-F |
| 1/2 | 3/8-16 | 1-1/8 | 9/16 | IT08-018-11-06-009 | 11/16 | 5/32 | FER08-F |
| 5/8 | 7/16-14 | 1-3/16 | 5/8 | IT10-019-11-07-010 | 7/8 | 3/16 | FER10-F |
| 3/4 | 1/2-13 | 1-7/16 | 3/4 | IT12-023-11-08-012 | 1-1/16 | 1/4 | FER12-F |
| 7/8 | 5/8-11 | 1-5/8 | 15/16 | IT14-026-11-10-015 | 1-1/8 | 5/16 | FER14-F |
| 1 | 3/4-10 | 2-1/4 | 1-1/8 | IT16-036-11-12-018 | 1-3/8 | 3/8 | FER16-F |

Tapped Studs are used in all types of applications. They can be welded to a flat surface, or to the inside or outside of an angle.

Length: Length is listed before weld. Diameters 1/2" and below will be approx. 1/8" shorter after weld. 5/8" and above will be 3/16" shorter. TRU-WELD IT Studs can be made in any length above the standard minimum.

Material: Low Carbon Steel, ASTM A29, 1010-1020. IT Studs are also available in weldable stainless steel.

| Mechanical Property Requirements | |
|----------------------------------|-----------------|
| Tensile Strength | 61,000 psi min. |
| Yield Strength | 49,000 psi min. |
| Elongation (% in 2 in.) | 17% min. |
| Elongation (% in 5x dia.) | 14% min. |
| Reduction of Area | 50% min. |

| DIAMETER | CHUCK PART # | Light Duty Standard | | Light Duty Split | | Standard Combination |
|----------|-----------------|------------------------|-------------|------------------|-------------|-------------------------|
| | | FOOT PART # | GRIP PART # | FOOT PART # | GRIP PART # | FOOT AND GRIP # |
| 1/4 | CN-025 | B-1N | GN-025 | B-1C | GC-025 | QN-025 |
| 5/16 | CN-031 | B-1N | GN-031 | B-1C | GC-031 | QN-031 |
| 3/8 | CN-037 | B-1N | GN-050 | B-1C | GC-050 | QN-050 |
| 7/16 | CN-043 | B-1N | GN-043 | B-1C | GC-043 | QN-044 |
| 1/2 | CN-050 | B-1C | GN-062 | B-2C | GC-062 | QN-062 |
| 5/8 | CN-062 | B-1C | GN-075 | B-2C | GC-075 | QN-075 |
| 3/4 | CN-075 | B-1C | GN-075 | B-2C | GC-075 | QN-075 |
| 7/8 | CN-087 | B-3N | GN-087 | B-3C | GC-087 | QN-087 |
| 1 | CN-100 | B-3N | GN-100 | B-3C | GC-100 | QN-100 |