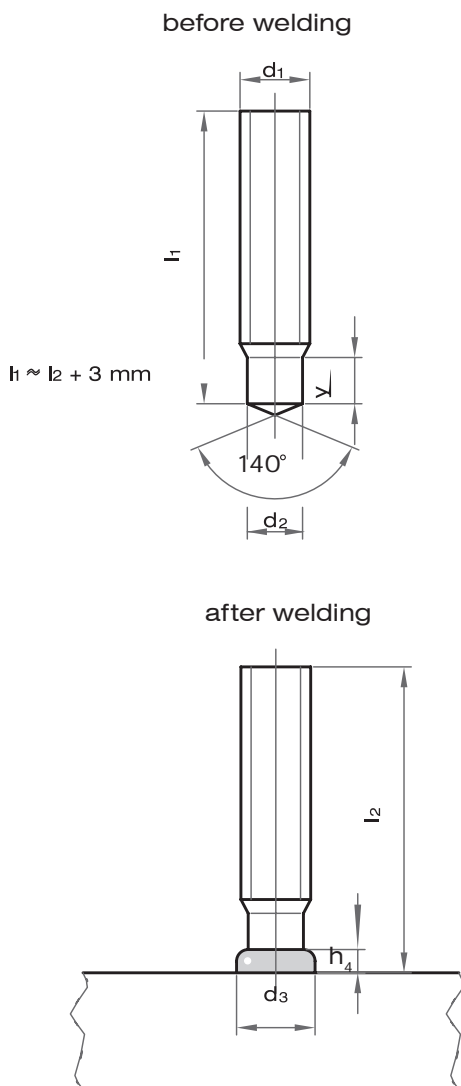


WELDING STUDS DRAWN ARC WELDING

Partial threaded studs, type PD are standard according to DIN EN ISO 13918:2018 and can be used as a stud with aluminium soldering from M6 to M20 together with ceramic ferrules of type PF or under Shielding gas without aluminium soldering (max to M12).

Threaded Stud PD



d1	M6	M8	M10	M12	M16	M20
d2	5,30	7,10	8,95	10,80	14,60	18,30
d3	8,50	10,00	12,50	15,50	19,50	24,50
h4	3,50	3,50	4,00	4,50	6,00	7,00
$\alpha \pm 7^\circ$	140°	140°	140°	140°	140°	140°
y min	9	9	9,5	11,5	13,5	15,5
b	h - y min with studs $l_2 \leq 50\text{mm}$, otherwise 1/3 of l_2 1)					
$l_2 \pm 0,05$	Weight ~ 7,85kg/dm ³ per 1.000 pcs in kg (St. 37)					
0						
15	2,6					
20	3,5	6,4	10,0			
25	4,4	8,0	12,6	18,2		
30	5,3	9,6	15,1	21,8	39,9	
35	6,2	11,1	17,6	25,4	46,6	
40	7,1	12,7	20,1	29,1	53,3	72,9
45		14,3	22,6	32,7	59,9	83,3
50		15,9	25,1	36,3	66,6	93,7
60			50,2	72,7	79,9	104,1
70			75,4	109,0	133,2	124,9
100			80,4	116,3	199,7	145,7
150						140,4

*)Other length according agreement
 1) or after according agreement

Material selection: Other materials according agreement

ISO-Standard	4.8	A2-50
Old description	St. 37	1.4301
Product key	71-xxx-xxxx	72-xxx-xxxx

Order example:

M 6 x 15 // 4.8 without Alu-ball
 Art-No.: 71-006-4015

We supply at short notice threaded and no-thread studs, shear connectors and short cycle studs from our extensive stock and also manufacture special studs to suit your specific requirements in a high standard of quality.