GST NO.: 29AHZPU5620Q1ZZ

An ISO 9001:2015 Certified Company

ROYAL INDUSTRIAL SUPPLIERS

QUALITY FASTENERS SPECIALIST

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TECHNICAL DATA SHEET

CD WELD STUD



MATERIAL- STAINLESS STEEL

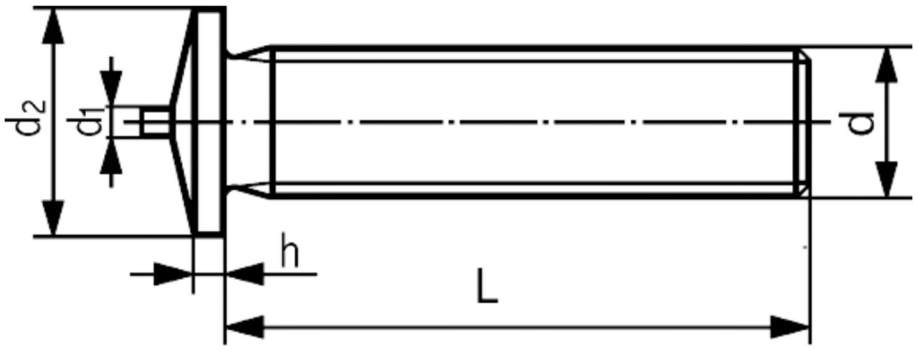
GRADE-SS304 (A2-70)

AS PER-ISO-13918

CATALOGUE NO. R4G72

INSTALLATION GUIDE

- VERIFY THE STUD DIAMETER, LENGTH, MATERIAL GRADE, AND WELDING SPECIFICATION BEFORE INSTALLATION.
- ENSURE THE BASE METAL IS SUITABLE FOR CAPACITOR DISCHARGE (CD) STUD WELDING.
- INSPECT THE STUD FOR THREAD DAMAGE, BENDING, OR SURFACE DEFECTS.
- CLEAN THE WELDING SURFACE TO REMOVE OIL, GREASE, RUST, PAINT, AND OTHER CONTAMINANTS.
- ENSURE THE BASE MATERIAL IS FLAT, CLEAN, AND PROPERLY PREPARED FOR WELDING.
- SELECT A SUITABLE CD STUD WELDING MACHINE AND WELDING PARAMETERS FOR THE STUD SIZE AND MATERIAL.
- POSITION THE STUD PERPENDICULARLY TO THE WORKPIECE AT THE REQUIRED WELDING LOCATION.
- ENSURE THE WELDING GUN, CHUCK, AND STUD ARE PROPERLY ALIGNED BEFORE WELDING.
- SET THE WELDING CURRENT, TIME, AND OTHER PARAMETERS ACCORDING TO THE MACHINE AND STUD MANUFACTURER'S RECOMMENDATIONS.
- PLACE THE STUD FERRULE OR IGNITION TIP CORRECTLY AGAINST THE BASE MATERIAL, AS APPLICABLE.
- PERFORM THE WELDING OPERATION USING THE APPROVED CD WELDING PROCEDURE.
- ALLOW THE WELDED STUD AND BASE MATERIAL TO COOL BEFORE HANDLING OR APPLYING LOAD.
- INSPECT THE WELD FOR PROPER FUSION, ALIGNMENT, AND VISIBLE DEFECTS.
- PERFORM REQUIRED WELD STRENGTH OR BEND TESTS AS PER THE APPLICABLE SPECIFICATION.
- ENSURE THE FINAL WELDED STUD IS SECURELY ATTACHED AND THE THREADS REMAIN UNDAMAGED.



Size	M3x0.5	M4x0.7	M5x0.8	M6x1.0	M8x1.25	M10x1.5
h	0.6 to 1.5					
d2 ± 0.4	4.50	5.50	6.50	7.50	9.00	11.72
d1 ± 0.1	0.60	0.65	0.75	0.75	0.75	1.10

Quote the PART NUMBER given below with your order/ inquiries: All Dimensions in mm

Length/Dia	M3x0.5	M4x0.7	M5x0.8	M6x1.0	M8x1.25	M10x1.5
6	R4G7203006	R4G7204006	R4G7205006			
8	R4G7203008	R4G7204008	R4G7205008	R4G7206008	R4G7208008	R4G7210008
10	R4G7203010	R4G7204010	R4G7205010	R4G7206010	R4G7208010	R4G7210010
12	R4G7203012	R4G7204012	R4G7205012	R4G7206012	R4G7208012	R4G7210012
16	R4G7203016	R4G7204016	R4G7205016	R4G7206016	R4G7208016	R4G7210016
20	R4G7203020	R4G7204020	R4G7205020	R4G7206020	R4G7208020	R4G7210020
25	R4G7203025	R4G7204025	R4G7205025	R4G7206025	R4G7208025	R4G7210025
30	R4G7203030	R4G7204030	R4G7205030	R4G7206030	R4G7208030	R4G7210030
35	R4G7203035	R4G7204035	R4G7205035	R4G7206035	R4G7208035	R4G7210035
40	R4G7203040	R4G7204040	R4G7205040	R4G7206040	R4G7208040	R4G7210040
45	R4G7203045	R4G7204045	R4G7205045	R4G7206045	R4G7208045	R4G7210045
50		R4G7204050	R4G7205050	R4G7206050	R4G7208050	R4G7210050
55		R4G7204055	R4G7205055	R4G7206055	R4G7208055	R4G7210055
60		R4G7204060	R4G7205060	R4G7206060	R4G7208060	R4G7210060

Sizes in BLUE are non-preferred. Availability is limited and MOQ is applied. *Data is strictly informative*

Note: All Austenitic Stainless-Steel Fasteners may exhibit some Magnetic Properties due to the Manufacturing Process.
Refer: ISO 3506-2 Annex F