

GENERAL INFORMATION

	CAPACITOR DISCHARGE	ARC
MATERIAL:	Low carbon steel, 18-8 stainless, and 6061, and 5000 series aluminum. Brass and other grades of stainless steel are also available.	Low carbon steel and 18-8 stainless. Aluminum, monel, inconel, and other grades of stainless steel are available.
PLATING:	Copper plating is standard. Nickel, zinc, and other platings are available.	Zinc to ASTM-B 633 (formerly A 164) and other platings are available. Non-weldable plating is removed from the weld end to avoid contamination of the weld.
ANNEALING:	All low carbon steel and stainless steel studs are annealed where required.	Low carbon steel can be annealed to a maximum of 75 Rockwell B and a stainless steel to a maximum of 90 Rockwell B.
THREADS:	UNC-2A is standard for external threads prior to plating and UNC-2B for internal threads. Metric and other thread sizes are available.	
WELD BASE:	Flanged, mini-flanged, and non-flanges are available.	1/4" diameter and over have solid flux. Diameters under 1/4" are standard pointed, and flux is optional.
STUD LENGTH:	CD studs have no appreciable length reduction after welding.	Arc Stud length reduction varies with stud diameter. Consult chart below.
FERRULES:	Does not apply to CD.	All orders include ferrules when they are required.

Sizes not specified can be made to order on request.

ARC STUD LENGTH REDUCTION AFTER WELD

STUD DIAMETER	APPROXIMATE REDUCTION
3/16" thru 1/2"	1/8"
5/8" Thru 7/8"	3/16"
1" and over	1/4"
1/8" wide rectangulars	1/8"

