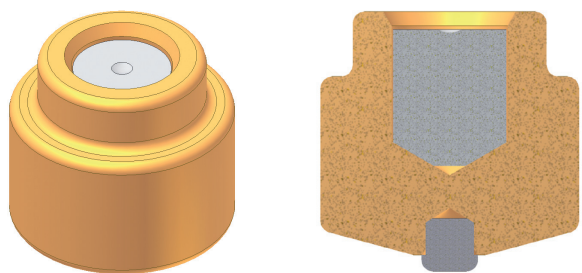


# Welding instructions BETEK TungStuds®



## The process:

In drawn arc stud welding, an arc is drawn between a TungStud and the working surface, melting some of the metal on both parts. At the end of the welding time the TungStud is plunged into the weld pool, the welding current is switched off and the weld pool solidifies.

## Current source:

400V 63A three-phase current

## State of the welding surface:

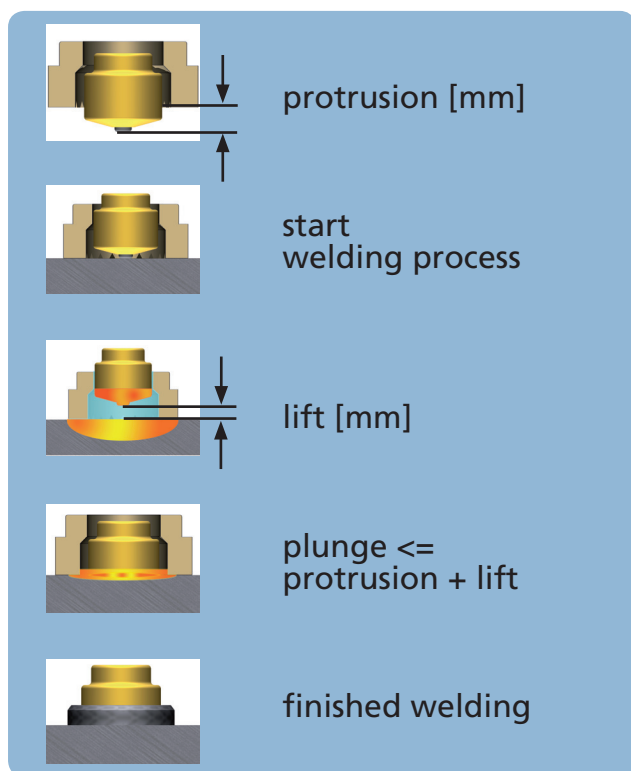
appropriate	inappropriate
bright metal *	hot-dip galvanised
rolling skin	loose layers of scale
welding primer	protective coating
surface rust	heavy corrosion

\*For best welding results we recommend bright metal surfaces.

## Characteristics of a good welded joint:

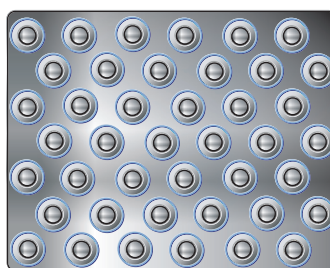
closed welding bead
shiny blue-grey bead
consistent "welding star" around the TungStud
no welding splash
no porous bead surface

## Settings of the arc welding machine as a function of the diameter:

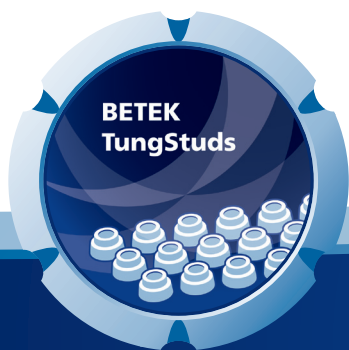


TungStud ø [mm]	current [A]	welding time [s]	lift [mm]	protrusion [mm]
16	1200	0,6	3	4
19	1300	0,7	3	4
22	1400	0,8	3	4

## Recommended welding pattern:



**Caution!** The welding machine should be operated only by qualified staff. We recommend the use of adequate security working clothes. Please adhere strictly to the operating instructions supplied by the welding machine manufacturer.



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Progress!