



## CD stud welding up to M12



Test welds were conducted by the SLV Munich (Training and Testing Institute of Welding). The welding results shown were achieved using the following dimensions and materials:

Stud diameter:	M12
Material:	S235 (St 37-3)
Sheet thickness:	2 mm



### CD stud welding from M3 to M12

Capacitor discharge stud welding has been successfully used for many years all over the world. So far this stud welding method has only been able to weld studs with a maximum diameter of M8. When used in conjunction with SOYER weld studs, the advanced CD stud welding process allows the welding range to be extended to a maximum of M12. This innovation allows studs from M3 to M12 to be welded in an instant and opens up new fields of application in stud welding technology.

#### Technical data

<b>Dimensions:</b>	M3 studs with a reduced flange diameter up to M12 studs with a standard flange
<b>Material:</b>	Steel and stainless steel
<b>Welding process:</b>	Capacitor discharge stud welding
<b>Field of application:</b>	Mobile and stationary use
<b>Operation mode:</b>	Manual and fully automatic operation
<b>System components:</b>	All CD stud welding products with appropriate accessories



Above illustration shows a welded M12 stud. This weld was examined and approved as an optimum weld by the SLV Munich. The regular shape of the weld collar verifies the premium quality of this stud welded joint.

# Fax Reply

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## Please contact us!

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## SOYER – Your reliable partner in stud welding technology!

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- send us detailed product information on the following subject:

\_\_\_\_\_

## Capacitor discharge stud welding

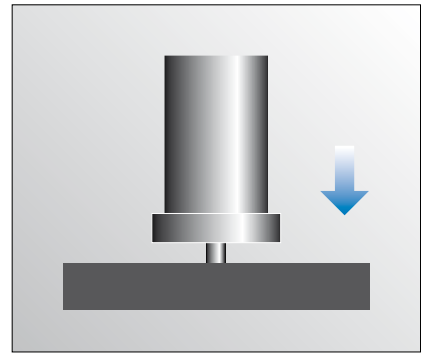
CD stud welding provides the following benefits:

- ▶ Low weld penetration of approx. 0.1 mm
- ▶ Suitable for thin gauge sheet metal with a minimum thickness of 0.5 mm
- ▶ No reverse marking such as discolouration or deformation even if the sheet surface has been plastic-laminated or electroplated
- ▶ Designed specifically for all stud welding tasks where the decorative appearance of the visible side has to be retained

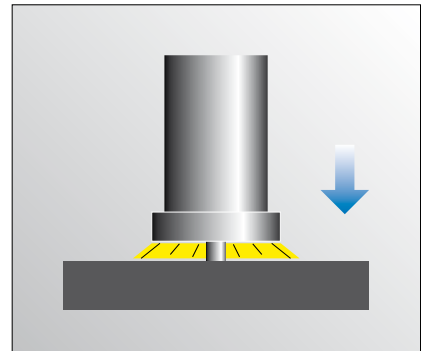
For more detailed information about the individual system components, please refer to the respective product information sheet or visit us online at [www.soyer.com](http://www.soyer.com).

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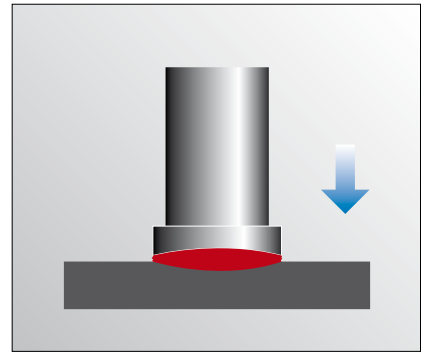
Please also visit our Online Shop [www.soyer-shop.de](http://www.soyer-shop.de).



Stud tip touches workpiece. Electric arc is initiated.



Ignited arc creates a thin fusion zone on stud and workpiece.



Stud is plunged into molten pool. Material solidifies and stud is welded.

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1.4301, 1.4303,  
1.4401, 1.4404,  
1.4541, 1.4571  
Z30.3-6

SOYER  
Bolzenschweiß-  
technik  
DIN EN ISO 13918  
Type PD, RD, LD,  
FD, IT, PT, UT,  
MD, RD, ID  
Material: Stahl 4.8  
schweißgeeignet  
AlMg3

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