

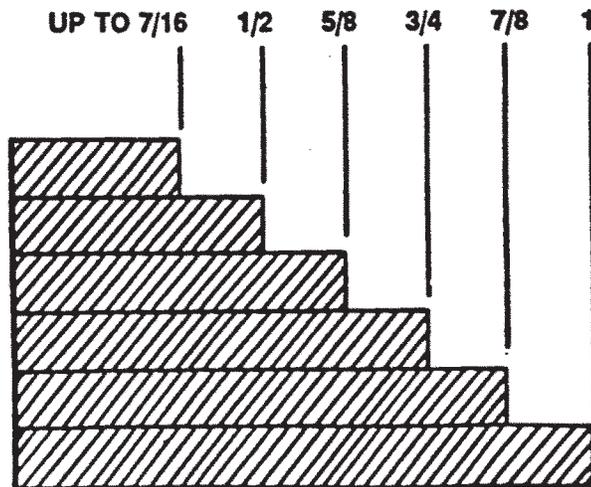
ARC STUD WELDING RECOMMENDED MINIMUM BASE METAL THICKNESS

STUD WELD BASE DIA. (in.)	STEEL		ALUMINUM	
	WITHOUT BACKUP (in.)	(gage)	WITHOUT BACKUP (in.)	WITH BACKUP (in.)
0.187	0.0359	20	0.125	0.125
0.250	0.0478	18	0.125	0.125
0.312	0.0598	16	0.187	0.125
0.375	0.0747	14	0.187	0.187
0.437	0.0897	13	0.250	0.187
0.500	0.1196	11	0.250	0.250
0.625	0.148	9		
0.750	0.187			
0.875	0.250			
1.000	0.375			

ARC STUD WELDING DC POWER SUPPLY REQUIREMENTS

POWER SUPPLY (NEMA RATED)	STUD WELD BASE DIAMETER IN INCHES
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400 AMP UNIT
 600 AMP UNIT
 TWO-400 AMP UNITS IN PARALLEL
 TWO-600 AMP UNITS IN PARALLEL
 OR ONE MIDWEST FASTENERS UA-1800-PS
 ONE-2000 AMP UNIT
 OR ONE MIDWEST FASTENERS UA-2500-PS
 TWO-2000 AMP UNITS IN PARALLEL
 OR TWO MIDWEST FASTENERS UA-2500-PS'S
 IN PARALLEL



450 Richard St.
 Miamisburg, OH 45342
 Toll Free: 800-852-8352
 Fax: 937-866-4174

www.midwestfasteners.com