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STAUFF SWG Stud Welding System

In many areas, stud welding is considered to be the most economic fastening method for components and is sometimes even the only technically feasible solution. Because the stud is joined with the substructure over the entire surface of the stud, a high strength of the joint can be achieved.

STAUFF is now using this proven principle for the installation of pipe, tube, hose and cable clamps in the Standard Series (according to DIN 3015, part 1) as well as in the Twin Series (according to DIN 3015, part 3) with M6 mounting thread, where female threaded weld studs replace the regular weld plates; distance plates made from plastic provide the necessary spacing between the clamp bodies and the substructure.

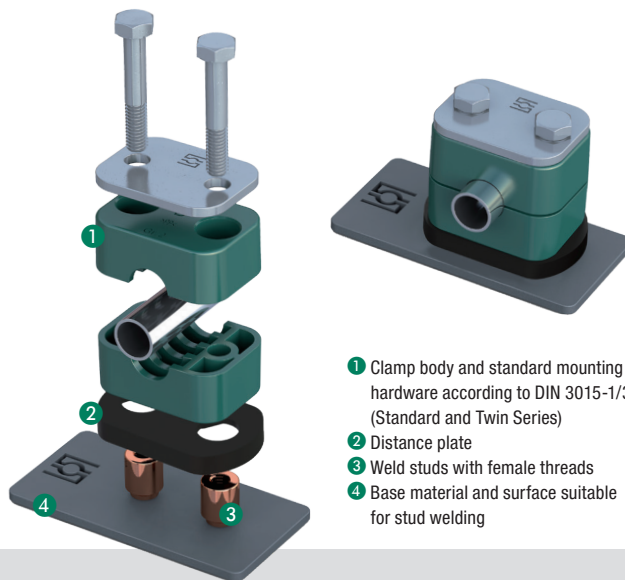
If required, the system can also be adopted for alternative fastening methods, e.g. for clamping belts, cable ties or conduit hoses.

In addition to the individual components – weld studs, distance plates, clamp bodies and metal hardware required – STAUFF also provides the correspondingly designed assembly tools such as the weld inverter and the weld gun with distance tube, stud retainer and distance adaptor for DIN 3015 clamps. The lightweight and compact weld inverter works without high-voltage current.

Thanks to increased productivity and flexibility for the installation of clamps, the system offers considerable savings potentials for users with significant processing volumes, especially when working in horizontal or overhead position. The amount of rework on welding locations can be significantly decreased, and material distortion is reduced to a minimum through low thermal stress.

The joint of the weld stud with the substructure impresses in particular with a high degree of strength and safety, which is at least at the same level as for regular weld plates.

- Developed and optimised to the functions of original STAUFF Clamps in the Standard Series (DIN 3015, Part 1)
- Versatile combination and adaptation options available (e.g. fastening elements for conduit hoses, clamping belts and cable ties)
- All installation options are fully covered by only one weld stud
- Significant time and cost savings by a quicker welding process and reduced rework on welding locations
- Material distortion reduced to a minimum through low thermal stress (particularly significant when handling thin metal sheets)
- High degree of safety and protection against corrosion due to a welded joint over the whole surface
- Lightweight and compact designed welding inverter
- By default no shielding gas or ceramic ferrule required
- Works without high-voltage current



- 1 Clamp body and standard mounting hardware according to DIN 3015-1/3 (Standard and Twin Series)
- 2 Distance plate
- 3 Weld studs with female threads
- 4 Base material and surface suitable for stud welding

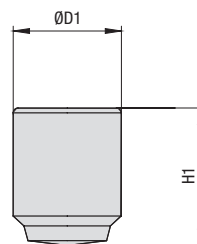
Assembly using weld plates
100%

Reduction of the assembly time per clamp*

Assembly using the stud welding system
23%

*For a typical assembly procedure in production environments.

Weld Stud with Female Thread Type SWG-SF



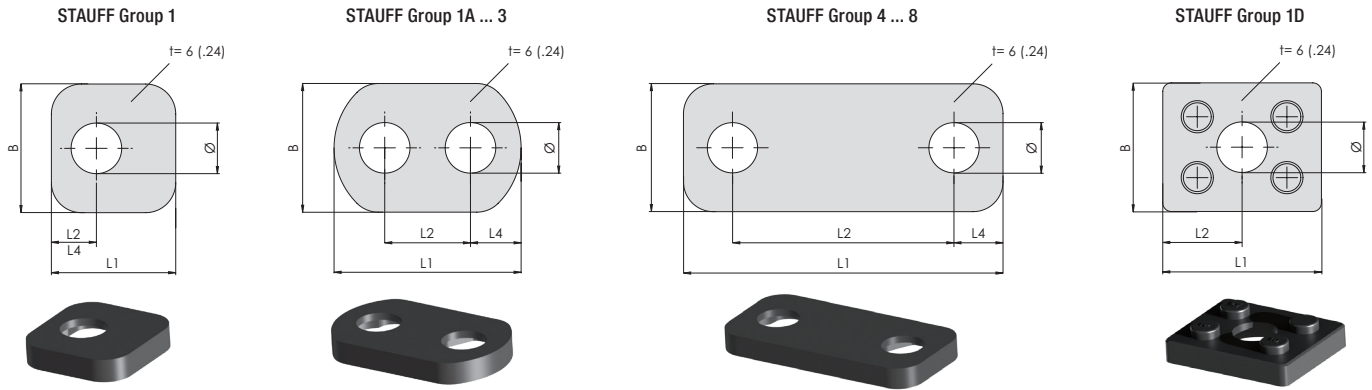
Ordering Codes			
Weld Stud	*SWG-SF-*M6x11x14-*W124		
* Weld Stud with Female Thread	SWG-SF		
* Thread code	Metric ISO thread Unified coarse (UNC) thread	M6x11x14 UNC1/4-20x11x14	
* Material code	Steel 4.8 with galvanised copper coating C1E (DIN EN ISO 4042)	W124	

Group	Dimensions (mm/in)	Order Codes (Standard Options)	Packaging Units (in pcs. / per bag)			
STAUFF	DIN	Thread G	ØD1	H1		
1 ... 8	0 ... 8	M6	11	14	SWG-SF-M6x11x14-W124	100
			.43	.55		
		1/4-20 UNC	11	14	SWG-SF-UNC1/4-20x11x14-W124	100
			.43	.55		

Alternative materials are available upon request. Please contact STAUFF for further information.

Maximum torque rating: 6 N-m / 4.43 ft-lb. Specific series can further limit the torque rating. The maximum loads in pipe direction listed on page 185 reduce accordingly. In case of doubt, please contact STAUFF in advance.



**Distance Plate for DIN 3015 Clamps
Type SWG-DIP**


Group STAUFF	DIN	Pipe/Tube-Ø (mm/in)	Dimensions (mm/in)					Order Codes (Standard Options)	Packaging Units (in pcs. / per bag)
		Clamp Body	L1	L2*	L4	B	Ø		
1	0	6 ... 12	29	10,5	10,5	30	11,8	SWG-DIP-1-PP-BK	25
		.2448	1.14	.41	.41	1.18	.46		
1A	1	6 ... 12	43,5	20	11,8	30	11,8	SWG-DIP-1A-PP-BK	25
		.2448	1.71	.79	.46	1.18	.46		
2	2	12,7 ... 18	48,5	26	11,3	30	11,8	SWG-DIP-2-PP-BK	25
		.5071	1.90	1.02	.44	1.18	.46		
3	3	19 ... 25,4	56,5	33	11,8	30	11,8	SWG-DIP-3-PP-BK	25
		.75 ... 1.00	2.22	1.30	.46	1.18	.46		
4	4	26,9 ... 32	62	40	11	30	11,8	SWG-DIP-4-PP-BK	25
		1.06 ... 1.26	2.44	1.57	.43	1.18	.46		
5	5	32 ... 42	75	52	11,5	30	11,8	SWG-DIP-5-PP-BK	25
		1.26 ... 1.65	2.95	2.05	.45	1.18	.46		
6	6	44,5 ... 54	88	66	11	30	11,8	SWG-DIP-6-PP-BK	25
		1.75 ... 2.12	3.46	2.60	.43	1.18	.46		
7	7	57,2 ... 76,1	121	94	13,5	30	11,8	SWG-DIP-7-PP-BK	10
		2.25 ... 3.00	4.76	3.70	.53	1.18	.46		
8	8	88,9 ... 102	147	120	13,5	30	11,8	SWG-DIP-8-PP-BK	10
		3.50 ... 4.00	5.78	4.72	.53	1.18	.46		
1D	1	6 ... 12	37	18,5	-	30	11,8	SWG-DIP-1D-PP-BK	25
		.2448	1.45	.73	-	1.18	.46		

Ordering Codes
Distance Plate *SWG-DIP*2*PP-BK

* Distance Plate SWG-DIP

* STAUFF Group 2

* Material code Polypropylene (Colour: Black) PP-BK

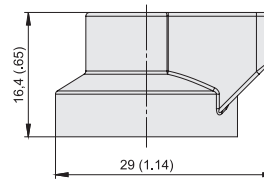
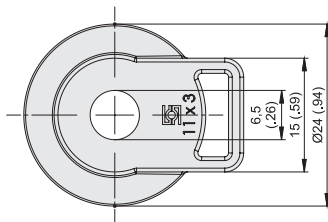
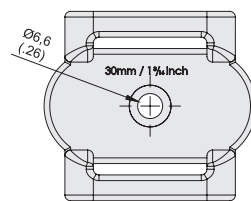
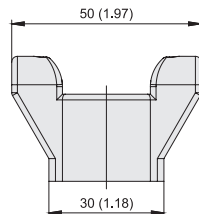
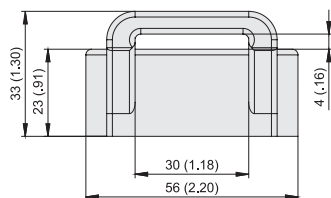
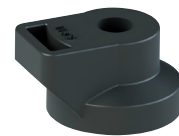
Alternative materials are available upon request. Please contact STAUFF for further information.

* ±0,1(.003)

Material: Polyamide (reinforced)

Suitable for hexagon socket button cap screws M6x12 (ISO 7380-1)

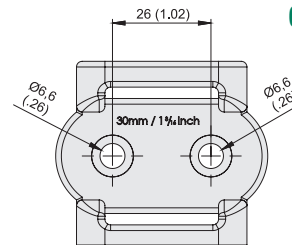
Standard packaging unit: 25 pcs.


**Cable Tie Holder
Type SWG-CTH-11-M6**

**Cable Tie / Tension Belt Holder
Type SWG-CTH-30-M6-1**


Material: Polyamide (reinforced)

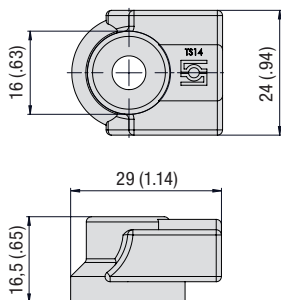
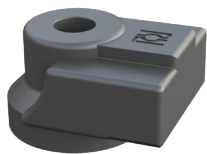
Suitable for socket cap screws M6x12 (ISO 4762) or hexagon socket button cap screws M6x12 (ISO 7380-1)

Standard packaging unit: 25 pcs.


**Cable Tie / Tension Belt Holder
Type SWG-CTH-30-M6-2**


Dimensional drawings: All dimensions in mm (in).

Fastening Adaptor
(for Use with Mounting Rail TS)
Type SWG-MRA-TS14-S-A

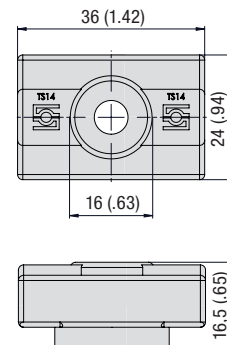


Product Features

Fastening Adaptor for Direct Screw Mounting of STAUFF Mounting Rails Type TS-14 with Weld Studs M6 and Bolts M6 or 1/4-20 UNC (Support Sleeve / Washer Recommended). For more information, please see Page 25.

Material: Polyamide

Fastening Adaptor
(for Use with Mounting Rail TS)
Type SWG-MRA-TS14-D-A



Product Features

Fastening Adaptor for Direct Screw Mounting of STAUFF Mounting Rails Type TS-14 with Weld Studs M6 and Bolts M6 or 1/4-20 UNC (Support Sleeve / Washer Recommended). For more information, please see Page 25.

Material: Polyamide

F

Starterkit
Type Kit-SWG-WI06-Starter



Starterkit including:

- 1 Weld Inverter **SWG-WI06**
- 1 Weld Gun **SWG-WG**
- 1 Ground Cable **SWG-GC**
- 1 Distance Tube **DIT-SR6-SWG-WG30** (for STAUFF Groups 2 to 8)
- 5 Stud Retainer **SWG-SR6**
- 1 Toolkit (Box Spanner/Hex Wrench)
- Operating Manual (English / German)

Required Accessories:

- Distance Adaptor **SWG-AGS-...** for DIN 3015 Clamps
- Weld Stud **SWG-SF**
- Distance Tube **DIT-SR6-SWG-WG25** (for STAUFF Group 1A, if required)

Weld Inverter
Type SWG-WI06



Characteristics

- Works without high-voltage current
- No heavy extension cords required
- Extremely powerful and robust
- Compact in design
- Lightweight with only 18 kg / 40 lbs
- Welding current: 100 ... 650 A (stepless control)
- Welding time: 5 ... 200 ms (stepless control)
- Connection Cable: 3 m / 9.84 ft

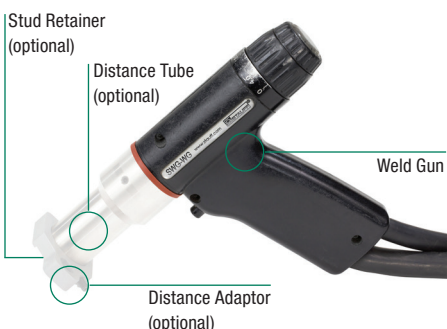
Required Accessories

- Weld Gun **SWG-WG** and Accessories
- Ground Cable **SWG-GC**

Technical Data

- Primary Power**
 - 100 V to 240 V, 1 phase, 50/60 Hz, 16 AT
- Primary Plug**
 - 16 A 2-pin grounded safety plug (plug type F CEE 7/4)
- IP Code**
 - IP 44 (also permits operation outdoors)
- Ambient Temperature Limits**
 - ±0 °C ... +40 °C / +32 °F ... +104 °F
- Dimensions (L x W x H)**
 - 474 x 337 x 351 mm / 18.66 x 13.27 x 13.82 in

Weld Gun - Arc Ignition
Type SWG-WG



Characteristics

- Compact in design
- Lightweight with only 0,8 kg / 1.8 lbs (without cable)
- Ergonomic handle
- Comfortable setup
- Connection Cable: 5 m / 16.40 ft

Required Accessories

- Distance Adaptor **SWG-AGS-...** for DIN 3015 Clamps
- Distance Tube **DIT-SR6-SWG-WG30** (for STAUFF Groups 2 to 8)
- Distance Tube **DIT-SR6-SWG-WG25** (for STAUFF Group 1A)
- Stud Retainer **SWG-SR6**

Technical Data

- Lift**
 - Adjustment range 3 mm / .11 in, lockable
- Workplace noise level**
 - Up to 90 dB (A) may occur during welding
- Dimensions (L x W x H)**
 - 200 x 65 x 140 mm / 7.87 x 2.56 x 5.51 in (without cable, without distance tube)



**Distance Adaptor
Type SWG-AGS**

Group STAUFF	DIN	for use with	Ordering Codes
1	0	Distance Tube Type A	NO DISTANCE ADAPTOR REQUIRED
1A	1	Distance Tube Type A	SWG-AGS-1A
2	2	Distance Tube Type B	SWG-AGS-2
3	3	Distance Tube Type B	SWG-AGS-3
4	4	Distance Tube Type B	SWG-AGS-4
5	5	Distance Tube Type B	SWG-AGS-5
6	6	Distance Tube Type B	SWG-AGS-6
7	7	Distance Tube Type B	SWG-AGS-7
8	8	Distance Tube Type B	SWG-AGS-8
1D	1D	Distance Tube Type A	NO DISTANCE ADAPTOR REQUIRED


**Distance Tube
Type DIT-SR6-SWG**

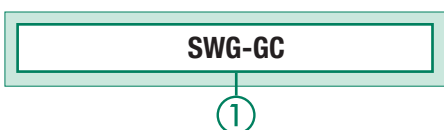
Type	for use with	Ordering Codes
A	Distance Adaptor SWG-AGS-1A	DIT-SR6-SWG-WG25
B	Distance Adaptor SWG-AGS-2...8	DIT-SR6-SWG-WG30


F
**Stud Retainer
Type SWG-SR6**
Order Code

① Type

 Stud Retainer **SWG-SR6**

Standard packaging unit: 5 pcs.


Order Code

① Type

 Ground Cable **SWG-GC**
Characteristics

- Cable length: 5 m / 16.40 ft
- Equipped with 2 vice grips 10"

**Ground Cable
Type SWG-GC**
