

## Approximate Tensile and Torque Strengths of Capacitor Discharge Welded Studs

Stud Thread Designation	Tensile Yield Load, lb		Maximum Wrench Torque, in. lb	
<b>Annealed Carbon Steel</b>				
# 6-32	500		9	
# 18-32	650		17	
# 10-24	900		25	
# 10-32	1000		29	
# 1/4-20	1300		55	
<b>Types 304 and 305 Stainless Steel</b>				
# 6-32	930		16	
# 8-32	1360		31	
# 10-24	1630		48	
# 10-32	1960		60	
# 1/4-20	3000		120	
<b>F-22 Aluminum Alloy (5000 Series)*</b>				
Stud Size	Minimum Torque Value		Minimum Tensile Load	
	ft-lbf	J	lb	kg
6 - 32	3.5	4.7	375	170
9 - 32	7.5	10.0	635	290
10 - 24	10	13.5	770	350
1/4 - 20 U	40	54	1360	620
5/16 - 18 UN	70	95	2300	1045

\*Refer to ANSI/AWS D1.2-90



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