

STUD PULL ELECTRODE

- *STUD PULL ELECTRODE that will not fail on any ferrite based metal or application*
- *Remove broken bolts, drill bits, taps and studs without special equipment! Quick and easy*
- *Non-conductive coating will not SIDE ARC!*
- *Slag flows to the side during build-up protecting threaded stud hole walls with a ceramic type coating*
- *You get a machinable deposit*
- *High strength and elongation withstand the torque forces of extraction*
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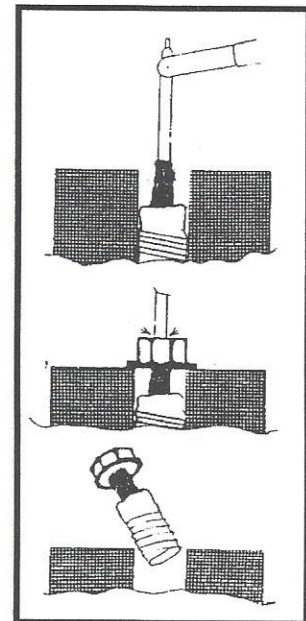
EXTRACTION PROCEDURE

1. After selecting appropriate electrode size, check amperage by striking arc on scrap metal. Arc should strike easily, with the lowest amperage.

2. With the rod centered in the hole, strike the arc on the broken stud. Maintain a very close arc with the rod contacting the center of the weld puddle. For horizontal situations strike and hold arc slightly above center. Do not use a circular or weave technique. Allow the weld deposit to build-up slowly to form a “nub” just below the housing surface. The slag will flow to the sides, protecting the side walls.

3. Allow build-up deposit to cool. Chip the slag off the top “nub” of the weldment. Select a flat washer that has a smaller inside diameter than the stud hole and place it over the hole. Place a nut on the washer and continue built-up into the nut. After weldment is built-up above the hole surface, angle the electrode slightly to weld the nut and washer to the weldment.

4. Allow whole assembly to air cool. Using hand wrench, back out nut and broken stud.



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