

NELSON[®] STUD WELDING

A Nelson Fastener Systems Company

Nelson[®] Hydraulic Cylinder Port Studs

Our Stud-Weldable 1-Piece Port Stud
Eliminates Leaks, Saves Labor & Money!

- Produced from the forging process that creates directional grain flow for added strength
- Near net shape minimizes scrap, reduces cost
- Eliminates brazed joint - **eliminates** potential for leaks
- Certified hydrostatic testing to 20,000 psi
- Formed in a die cavity, yielding close tolerances for better fit to weld gun accessories



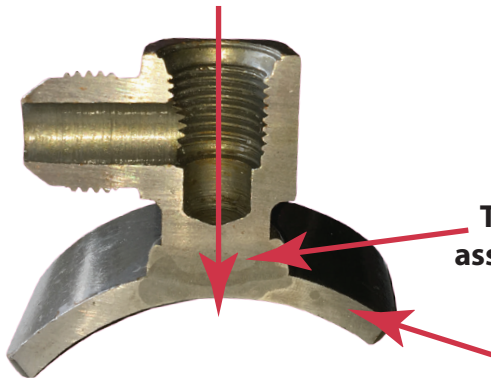
Configured to:
O-Ring Fitting Studs* & Face Seal** Fitting Studs - SAE J1453 (*ORB, **ORFS), 37° Flare Fitting Studs - SAE J514,
Pipe Thread Fitting Studs - National Pipe Threads (NPT)

BENEFITS OF A STUD WELDED PORT

- The process of stud welding cylinder ports is much faster than other methods resulting in significant labor savings
- By comparison, very little heat is created, thereby reducing or **eliminating ID tube distortion** and the related re-work cost
- The weld is a full cross-sectional weld, reducing the risk of leakage and improving strength
- Because the process is semi-automatic, unskilled labor can be used with a high degree of repeatability & reliability
- Stud welding most often times eliminates the need for leak testing



After welding, the port passage is drilled through, and an integral tool deburrs as the drill is removed



The full cross-sectional weld assures a leak-proof connection

Low heat input reduces or eliminates tube distortion

WHY USE THE NELSON[®] PORT STUD OVER THE OTHERS?

- Competitive offerings are still 2 components, brazed together, creating a potential leak point
- Manufacturers are increasing operating pressures, putting the brazed joint at more risk
- OEM's can eliminate hydraulic pressure testing in the assembly area with a 1-piece port stud - saving time & money!
- The part is labor intensive resulting in a higher cost



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