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design values, a large-diameter stud can be stronger than the surrounding concrete and the concrete can crush around the stud, losing bond between the two materials. And as the studs lose bond, the composite system will lose part, if not all, of the combined steel and concrete strength that the system relied on.

refining the design procedures as published in the fifth edition of the PCI Design Handbook,<sup>7</sup> or (d) writing a new design procedure independent of ACI 318, which is permitted in the code. This paper examines the background of the ACI 318 Appendix D design provisions and how the provisions apply to headed-stud connections.

dh diameter of the head of headed stud ds diameter of the shaft of headed stud ds, re diameter of the stirrup ds, nom nominal diameter of the anchor shaft dw diameter of the washer ex, y length between the bolt axis and the edge of the plate e eccentricity fbd design bond strength according to EN1992-1-1:2004 fcd design strength of concrete

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The stud is first placed in contact with the base material (SEE FIGURE 1). Verify that the gun is held perpendicular to the work. Pulling the trigger discharges the capacitors through the stud which va-porizes the tip. The proper tip design is critical. This is what determines the length of time of the weld. An

The purpose of this article is to present the fundamental principles of stud welding and implementing practices so that the user may be confident in the ensuing welding results and performance of the finished product. References. 1. Stud Welding Applications: Concrete Connections, Nelson Stud Welding, Inc., Elyria, OH, 1988. 2.

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- Adjust stud spacing when plates are used at the edges of walls, columns, or slabs. Embed details often indicate that studs are about 2 in. from the edge of a plate; however, if the plate is to be located at an edge, then the first row of studs will probably conflict with a reinforcing bar (Fig. 5).

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