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Nelson ® stud welding's rich history began in 1939 with the U.S. Navy. Edward "Ted" Nelson ® invented the stud welding process at the Mare Island shipyard in Vallejo, California, as a means to speed production of shipbuilding. The first application was to secure wood decking on submarines, but was quickly adopted and used on battleships and aircraft carriers.

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Nelson® Stud Welding, founded in the USA, 75 years ago, is the leading global manufacturer and distributor of weld stud fasteners and application equipment serving a broad range of

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markets on a worldwide basis including the automotive, construction and industrial markets.

## **Nelson Stud Welding - USA**

Nelson Stud Welding, Inc. Elyria, Ohio The embedment properties of stud welded anchors have been the subject of many testing programs worldwide. Currently, design provisions for cast-in-place anchorages are included in the 2000 edition of the International Building Code (IBC 2000), and these will

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In the United States, headed stud anchorage design usually followed procedures set forth in the PCI Handbook 2 or the nuclear structures code of ACI Committee 349.3 The Concrete Capacity Design (CCD) approach for anchorage to concrete has recently been approved as Chapter 23 of the upcoming 2002 version of the ACI 318 Building Code.4, 5

## **STEEL CAPACITY OF HEADED STUDS LOADED IN SHEAR**

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describe the behavior of headed studs at early concrete ages. Ollgaard et al. (1971) proposed the first formula adopted by AISC Manual 1993 to compute the shear strength of headed studs (see Table 1). They tested 48 push out tests in lightweight and normal-weight concrete with an effective embedment depth ratio,  $h_{ef}/d$ , of 3.26.

## **Headed Steel Stud Anchors in Composite Structures: Part I ...**

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

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headed-stud connections.

## **A Review of Headed-Stud Design Criteria in the Sixth ...**

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## **Stud Welding Practices & Procedure**

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



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combined steel and concrete strength that the system relied on.

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1960's there were no established criteria for the design of cast-in-place anchors other than those published by manufacturers of welded studs (e.g., Nelson Stud Welding, 1974). These anchors

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were of limited depth and were used primarily as shear connectors. Many studies have also investigated post-installed anchors [e.g., Cook et al

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