ISO 13918:2017-11 (E)

Welding - Studs and ceramic ferrules for arc stud welding

Contents

Page

Foreword v

Introduction vii

1 Scope 1

2 Normative references 1

3 Termsanddefinitions 2

4 Symbols and abbreviated terms 2

5 Requirements 3
5.1 Ordering information 3
5.2 Dangerous substances 3
5.3 Product requirements 3
5.3.1 Dimensions and tolerances on dimensions, form and position 3
5.3.2 Coating 3
5.3.3 Materials and mechanical characteristics 3
5.3.4 Weldability 4
5.4 Durability 5

6 Dimensions of studs 5
6.1 General 5
6.2 Fully-threaded stud (FD) 6
6.3 Virtually fully-threaded stud (MD) 7
6.4 Partially threaded stud (PD) 8
6.5 Threaded stud with reduced shaft (RD) 9
6.6 Unthreaded stud (UD) 10
6.7 Insulation pin/nail (ND) 11
6.8 Stud with internal thread (ID) 12
6.9 Shear connector (SD) 13
6.10 Threaded stud with flange (PS) 14
6.11 Unthreaded stud (US) 16
6.12 Stud with internal thread (IS) 17
6.13 Threaded stud (PT) 18
6.14 Unthreaded stud (UT) 20
6.15 Stud with internal thread (IT) 21

7 Dimensions of ceramic ferrules 21

8 Manufacture 23
8.1 Fully-threaded stud (FD), virtually fully-threaded stud (MD), partially threaded stud (PD), threaded stud with reduced shaft (RD), unthreaded stud (UD), stud with internal thread (ID) 23
8.2 Shear connectors (SD) 23

9 Inspection 23
9.1 General 23
9.2 Chemical analysis 24
9.3 Mechanical tests 24
9.4 Sample size 24

10 Marking 24
10.1 Traceability 24
10.2 Studs 24
10.3 Ceramic ferrules 25

11 Designation 25
11.1 Studs 25
11.2 Ceramic ferrules 25

Bibliography 26