ISO 18954:2026-05 (E)

Steel structures - Structural bolting - Test method to determine parameters of bolt tightening procedures

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Termsanddefinitions 1

4 Symbols 2

5 General 3

6 Mechanical properties of bolting components 6

7 Fitness for purpose test 6
7.1 General 6
7.2 Test apparatus 6
7.3 Test assemblies 7
7.4 Test set-up 7
7.5 Test procedure 8
7.6 Evaluation of the test results 9
7.7 Requirements for suitability 10
7.7.1 General 10
7.7.2 Maximum individual value of the bolt force during the tightening test (Fb,max) 10
7.7.3 Angle of additional nut rotation 10
7.7.4 Individual values of the k-factor 11
7.8 Test report 11

8 Determination of tightening parameters 12
8.1 General 12
8.2 Criteria for the determination of the tightening parameters 12

Bibliography 14