

ISO 13918:2008-02 (E)

Welding - Studs and ceramic ferrules for arc stud welding

Contents		Page
Foreword		v
Introduction		vi
1	Scope	1
2	Normative references	1
3	Terms and definitions	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
5.4	Durability	5
6	Testing for conformity evaluation	5
6.1	General	5
6.2	Testing for dangerous substances	5
6.3	Testing of dimensional requirements of the studs	5
6.4	Testing of mechanical characteristics of studs	5
6.5	Weldability	6
7	Evaluation of conformity	6
7.1	General	6
7.2	Initial type testing	6
7.3	Factory production control (FPC)	7
8	Documentation of test results	9
9	Dimensions of studs	10
9.1	General	10
9.2	Threaded stud (PD)	10
9.3	Threaded stud with reduced shaft (RD)	12
9.4	Unthreaded stud (UD)	13
9.5	Stud with internal thread (ID)	14
9.6	Shear connector (SD)	15
9.7	Threaded stud with flange (PS)	16
9.8	Unthreaded stud (US)	18
9.9	Stud with internal thread (IS)	19
9.10	Threaded stud (PT)	20
9.11	Unthreaded stud (UT)	21
9.12	Stud with internal thread (IT)	22
10	Dimensions of ceramic ferrules	23
10.1	General	23
10.2	Ceramic ferrule for threaded stud (PF)	23
10.3	Ceramic ferrule for unthreaded stud and shear connector (UF)	24
10.4	Ceramic ferrule for threaded stud with reduced shaft (RF)	25
11	Manufacture and finish	25

11.1	Threaded studs (PD), unthreaded studs (UD), threaded studs with reduced shaft (RD)	25
11.2	Shear connectors (SD)	25
12	Inspection	26
12.1	General	26
12.2	Chemical analysis	26
12.3	Mechanical tests	26
12.4	Sample size	26
13	Marking	27
13.1	Studs	27
13.2	Ceramic ferrules	27
14	Designation	27
14.1	Studs	27
14.2	Ceramic ferrules	28
Annex A (informative) Mass of studs		29
Bibliography		32