

DIN EN ISO 13918:2021-12 (E)

Welding - Studs and ceramic ferrules for arc stud welding (ISO 13918:2017 + Amd 1:2021) (includes Amendment :2021)

| Contents | Page |
|---|-------------|
| European foreword | 4 |
| A1 European foreword to Amendment A1 | 5 |
| Foreword | 6 |
| A1 Foreword to Amendment A1 | 8 |
| Introduction | 9 |
| 1 Scope | 10 |
| 2 Normative references | 10 |
| 3 Terms and definitions | 11 |
| 4 Symbols and abbreviated terms | 11 |
| 5 Requirements | 12 |
| 5.1 Ordering information | 12 |
| 5.2 Dangerous substances | 12 |
| 5.3 Product requirements | 12 |
| 5.3.1 Dimensions and tolerances on dimensions, form and position | 12 |
| 5.3.2 Coating | 12 |
| 5.3.3 Materials and mechanical characteristics | 12 |
| 5.3.4 Weldability | 13 |
| 5.4 Durability | 14 |
| 6 Dimensions of studs | 14 |
| 6.1 General | 14 |
| 6.2 Fully-threaded stud (FD) | 15 |
| 6.3 Virtually fully-threaded stud (MD) | 16 |
| 6.4 Partially threaded stud (PD) | 17 |
| 6.5 Threaded stud with reduced shaft (RD) | 18 |
| 6.6 Unthreaded stud (UD) | 19 |
| 6.7 Insulation pin/nail (ND) | 20 |
| 6.8 Stud with internal thread (ID) | 21 |
| 6.9 Shear connector (SD) | 22 |
| 6.10 Threaded stud with flange (PS) | 23 |
| 6.11 Unthreaded stud (US) | 25 |
| 6.12 Stud with internal thread (IS) | 26 |
| 6.13 Threaded stud (PT) | 27 |
| 6.14 Unthreaded stud (UT) | 29 |
| 6.15 Stud with internal thread (IT) | 30 |
| 7 Dimensions of ceramic ferrules | 30 |
| 8 Manufacture | 32 |
| 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) | 32 |

| | | |
|-----------|-----------------------|-----------|
| 8.2 | Shear connectors (SD) | 32 |
| 9 | Inspection | 32 |
| 9.1 | General | 32 |
| 9.2 | Chemical analysis | 33 |
| 9.3 | Mechanical tests | 33 |
| 9.4 | Sample size | 33 |
| 10 | Marking | 33 |
| 10.1 | Traceability | 33 |
| 10.2 | Studs | 33 |
| 10.3 | Ceramic ferrules | 34 |
| 11 | Designation | 34 |
| 11.1 | Studs | 34 |
| 11.2 | Ceramic ferrules | 34 |
| | Bibliography | 35 |