

STANDARDS AUSTRALIA/STANDARDS NEW ZEALAND

Amendment No. 1
to
AS/NZS 1554.2:2003
Structural steel welding
Part 2: Stud welding (steel studs to steel)

CORRECTION

The 2003 edition of AS/NZS 1554.2 is amended as follows; the amendment(s) should be inserted in the appropriate place(s).

SUMMARY: This Amendment applies to Clause 6.1.2.

Published on 29 December 2003.

AMDT
No. 1
DEC
2003

Page 20 Clause 6.1.2 (new)

Add the following clause after Clause 6.1.1:

6.1.2 Placed by a stud welding machine that does not record weld cycle parameters

For non-threaded studs, where visual inspection reveals any stud that has been repaired by welding, such stud shall be bent to an angle of approximately 15° from its original axis. The direction of bending for studs with less than a 360° flash shall be opposite to the missing portion of the flash.

The method of bending shall be in accordance with Clause 4.1.2. Bending shall preferably be done by continual slow application of load. At temperatures below 0°C, impact loading, such as striking with a hammer, shall not be used.

Studs that show no signs of fracture shall be acceptable for use and left in the bent position, unless otherwise required by the inspecting authority or principal. For studs that crack in the weld, the base metal or shank under inspection shall be replaced.

In addition, the inspecting authority or principal may select up to 1 in 100 studs at random for statically loaded structures and up to 1 in 20 studs at random for dynamically loaded structures to be tested as specified above.

NOTE: The inspecting authority or principal should stipulate which loading condition applies and the number of additional studs to be tested.

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