

Welding — Studs and ceramic ferrules for arc stud welding

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National foreword

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Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, the EN ISO title page, pages 2 to 22 and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

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(ISO 13918:1998)

Soudage — Goujons et bagues en céramique
pour le soudage à l'arc des goujons
(ISO 13918:1998)

Schweißen — Bolzen und Keramikringe zum
Lichtbogenbolzenschweißen
(ISO 13918:1998)

This European Standard was approved by CEN on 14 May 1998.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

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Foreword

The text of prEN ISO 13918:1998 has been prepared by Technical Committee CEN/TC 121 “Welding”, the secretariat of which is held by DS, in collaboration with Technical Committee ISO/TC 44 “Welding and allied processes”.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association. This European Standard is considered to be a supporting standard to those application and product standards which in themselves support an essential safety requirement of a New Approach Directive and which make reference to this European Standard.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 1999, and conflicting national standards shall be withdrawn at the latest by April 1999.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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1 Scope

This standard includes the most important dimensions of studs and ceramic ferrules for arc stud welding. The range of types of studs specified in this standard accounts for customary applications. Further types may be specified as required for special application. This standard can be used in all fields of the metal-working industry.

Table 1 shows types of studs and the symbols for studs and ceramic ferrules, which are used in this standard.

Table 1 — Type of studs and symbols for studs and ceramic ferrules

Type of studs			Symbols for studs	Symbols for ceramic ferrules
drawn arc	drawn arc stud welding with	threaded stud (pitch)	PD	PF
		threaded stud with reduced shaft	RD	RF
	ceramic ferrule or shielding gas	unthreaded stud	UD	UF
		shear connector	SD	UF
	short-cycle drawn arc stud welding	threaded stud with flange	FD	—
tip ignition	threaded stud (pitch)		PT	—
	unthreaded stud		UT	—
	stud with internal thread		IT	—

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 573-3, *Aluminium and aluminium alloys — Chemical compositions and forms of wrought products — Part 3: Chemical composition*.

EN 10025, *Hot rolled products of non-alloy structural steels — Technical delivery conditions*.

EN 10088-1, *Stainless steels — Part 1: List of stainless steels*.

EN 20898-1, *Mechanical properties of fasteners — Part 1: Bolts, screws and studs (ISO 898-1:1988)*.

EN ISO 6947, *Welds — Working positions — Definitions of angles of slope and rotation (ISO 6947:1993)*.

prEN ISO 14555, *Welding — Arc stud welding of metallic materials (ISO/FDIS 14555:1998)*.

ISO 426-1, *Wrought copper-zinc alloys — Chemical composition and forms of wrought products — Part 1: Non-lead and special copper-zinc alloys*.

ISO 724, *ISO general-purpose metric screw threads — Basic dimensions*.

ISO 1638, *Wrought copper and copper alloy wire — Technical conditions of delivery*.

EN ISO 3506-3, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 3: Set screws and similar fasteners not under tensile stress (ISO 3506-3:1997)*.

ISO 4042, *Threaded components — Electroplated coatings*.

ISO 4759-1, *Tolerances for fasteners — Part 1: Bolts, screws and nuts with thread diameters between 1,6 (inclusive) and 150 mm (inclusive) and product grades A, B and C*.