SLOVENSKI STANDARD
SIST EN ISO 13918:2008

01-september-2008

Nadomešča:
SIST EN ISO 13918:1999

Varjenje - Čepi in keramični obroči za obločno varjenje čepov (ISO 13918:2008)

Welding - Studs and ceramic ferrules for arc stud welding (ISO 13918:2008)

Schweißen - Bolzen und Keramikringe für das Lichtbogenbolzenschweißen (ISO 13918:2008)

Soudage - Goujons et bagues céramiques pour le soudage a l'arc des goujons (ISO 13918:2008)

Ta slovenski standard je istoveten z: EN ISO 13918:2008

ICS:

21.060.10	Sorniki, vijaki, stebelni vijaki	Bolts, screws, studs
25.160.10	Varilni postopki in varjenje	Welding processes

SIST EN ISO 13918:2008 **en,fr,de**

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 13918

May 2008

ICS 21.060.10; 25.160.10

Supersedes EN ISO 13918:1998

English Version

Welding - Studs and ceramic ferrules for arc stud welding (ISO 13918:2008)

Soudage - Goujons et bagues céramiques pour le soudage à l'arc des goujons (ISO 13918:2008)

Schweißen - Bolzen und Keramikringe für das Lichtbogenbolzenschweißen (ISO 13918:2008)

This European Standard was approved by CEN on 16 January 2008.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: rue de Stassart, 36 B-1050 Brussels

Ref. No. EN ISO 13918:2008: E

Contents

Page

Foreword

This document (EN ISO 13918:2008) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 “Welding” the secretariat of which is held by DIN.

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 November 2008, and conflicting national standards shall be withdrawn at the latest by November 2008.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 13918:1998.

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

Endorsement notice

The text of ISO 13918:2008 has been approved by CEN as a EN ISO 13918:2008 without any modification.

INTERNATIONAL STANDARD

ISO 13918

Second edition
2008-02-15

Welding — Studs and ceramic ferrules for arc stud welding

Soudage — Goujons et bagues céramiques pour le soudage à l'arc des goujons

Reference number
ISO 13918:2008(E)

PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

COPYRIGHT PROTECTED DOCUMENT

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

Contents

Page

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 13918 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Unification of requirements in the field of metal welding*.

This second edition cancels and replaces the first edition (ISO 13918:1998), which has been technically revised.

Introduction

The range of types of studs specified in this International Standard represents customary applications.

This International Standard can be used in all fields of the metal-working industry.

Welding — Studs and ceramic ferrules for arc stud welding

1 Scope

This International Standard specifies:

— requirements for studs and ceramic ferrules for arc stud welding;

— dimensions, materials, mechanical properties and, when required, conditions of evaluation of conformity.

Table 1 shows types of studs and the symbols for studs and ceramic ferrules that are covered by this document.

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

Welding technique	Type of stud[a]	Symbol for studs	Symbol for ceramic ferrules
Drawn arc stud welding with ceramic ferrule or shielding gas	threaded stud (pitch)	PD	PF
	threaded stud with reduced shaft	RD	RF
	unthreaded stud	UD	UF
	stud with internal thread	ID	UF
	shear connector	SD	UF
Short-cycle drawn arc stud welding	threaded stud with flange (pitch)	PS	—
	unthreaded stud	US	—
	stud with internal thread	IS	—
Stud welding with tip ignition	threaded stud (pitch)	PT	—
	unthreaded stud	UT	—
	stud with internal thread	IT	—
[a] Further types of stud and ceramic ferrules can be specified as required for special applications.			

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 898-1, *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 1: Bolts, screws and studs*

ISO 3506-1, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 1: Bolts, screws and studs*

ISO 4042, *Fasteners — Electroplated coatings*