SLOVENSKI STANDARD
SIST EN ISO 13918:2018

01-oktober-2018

Nadomešča:
SIST EN ISO 13918:2008

Varjenje - Čepi in keramični obroči za obločno varjenje čepov (ISO 13918:2017, popravljena verzija 2018-05)

Welding - Studs and ceramic ferrules for arc stud welding (ISO 13918:2017, Corrected version 2018-05)

Schweißen - Bolzen und Keramikringe für das Lichtbogenbolzenschweißen (ISO 13918:2017, korrigierte Fassung 2018-05)

Soudage - Goujons et bagues céramiques pour le soudage à l'arc des goujons (ISO 13918:2017, Version corrigée 2018-05)

Ta slovenski standard je istoveten z: **EN ISO 13918:2018**

ICS:

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

SIST EN ISO 13918:2018 **en,fr,de**

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 13918

January 2018

ICS 21.060.10; 25.160.10

Supersedes EN ISO 13918:2008

English Version

Welding - Studs and ceramic ferrules for arc stud welding (ISO 13918:2017, Corrected version 2018-05)

Soudage - Goujons et bagues céramiques pour le soudage à l'arc des goujons (ISO 13918:2017, Version corrigée 2018-05)

Schweißen - Bolzen und Keramikringe für das Lichtbogenbolzenschweißen (ISO 13918:2017, korrigierte Fassung 2018-05)

This European Standard was approved by CEN on 21 November 2017.

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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

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European foreword

This document (EN ISO 13918:2018) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 “Welding and allied processes” 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of an identical text or by endorsement, at the latest by July 2018, and conflicting national standards shall be withdrawn at the latest by July 2018.

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

This document supersedes EN ISO 13918:2008.

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, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 13918:2017, Corrected version 2018-05 has been approved by CEN as EN ISO 13918:2018 without any modification.

INTERNATIONAL STANDARD

ISO 13918

Third edition
2017-11

Corrected version
2018-05

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 13918:2017(E)

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Quality management in the field of welding*.

This third edition cancels and replaces the second edition (ISO 13918:2008), which has been technically revised.

The main changes compared to the previous edition are as follows:

a) everything according conformity evaluation has been deleted from this document;

b) fully-threaded stud (FD), virtually fully-threaded stud (MD) and insulation pin/nail (ND) have been introduced;

c) threaded stud has been renamed to partially threaded stud (PD);

d) abbreviation *P* for pitch has been introduced;

e) that a stud may consist of two different materials combined by friction welding has been introduced in 5.3.3.1;

f) value for CEV (CEV ≤ 0,38) in Table 2 has been changed;

g) SD3 materials according ISO 15510 have been introduced in Table 2;

h) PT, UT and IT materials according ISO/TR 15608 have been introduced in Table 2;

i) where applicable, the dimensions d_3 and h_4 are now for guidance only.

j) "y_{min}" has been changed to "$y + 2P$" in Table 5, column l_2;

k) "$y_{min} + 1$" has been changed to "$y + 2P$ in Table 6, column d_1";

l) "$\alpha \pm 2{,}5°$" has been changed to "$\alpha \pm 7°$" in Table 6,column d_1;

m) "α ± 2,5°" has been changed to "α ± 7°" in Table 9, column D_6;

n) "b" has been changed to "$b + 2P$" and values for M 5 and M 8 have been changed to 7,5 mm and 12 mm in Table 9, column D_6;

o) the column header "$d_1 - 0{,}4$" has been changed to "$d_1 \pm 0{,}4$" in Table 10;

p) "α ± 2,5"has been changed to "α ± 7" in Table 10;

q) the column header "b_{min}" has been changed to "$b_{min} + 2P$" in Table 13;

r) the column header "b" has been changed to "$b_{min} + 2P$" in Table 16;

s) a nominal diameter (d_1 ± 0,1) of 8 mm has been introduced with an internal thread diameter (D_6) of M5 and M6 in Table 16;

t) in all tables for the dimensions of ceramic ferrules, the values for the nominal diameter (D_7), the grip diameter (d_8), the base diameter (d_9) and the height (h_2) have been deleted;

u) Table 17 has been introduced;

v) a note that stud and ceramic ferrule are generally a coordinated system from the same manufacturer has been introduced in Clause 7;

w) 10.1 has been introduced;

x) Annex A has been deleted;

y) figures, normative references and layout have been editorially revised.

Requests for official interpretations of any aspect of this document should be directed to the Secretariat of ISO/TC 44 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

This corrected version of ISO 13918:2017 incorporates the following correction:

— footnote [b] in Table 11 has been modified.

Introduction

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

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