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Welding - Studs and ceramic ferrules for arc stud welding (ISO 13918:2017)

Táto norma obsahuje anglickú verziu európskej normy.  
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 06/18

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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)

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**EN ISO 13918:2018 (E)**

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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of an identical text or by endorsement, at the latest by July 2018, and conflicting national standards shall be withdrawn at the latest by July 2018.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

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**13918**

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2018-05

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## **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](http://www.iso.org/directives)).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

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](http://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 ( $CEV \leq 0,38$ ) 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) " $\alpha \pm 2,5^\circ$ " has been changed to " $\alpha \pm 7^\circ$ " in [Table 6](#), column  $d_1$ ;

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- m) " $\alpha \pm 2,5^\circ$ " has been changed to " $\alpha \pm 7^\circ$ " 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) " $\alpha \pm 2,5$ " has been changed to " $\alpha \pm 7$ " 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 ( $d_1 \pm 0,1$ ) 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](http://www.iso.org).

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

- footnote <sup>b</sup> 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.



# Welding — Studs and ceramic ferrules for arc stud welding

## 1 Scope

This document specifies the following:

- requirements for studs and ceramic ferrules for arc stud welding;
- dimensions, materials and mechanical properties.

[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 <sup>a</sup>	Symbol for studs	Symbol for ceramic ferrules
Drawn arc stud welding with ceramic ferrule or shielding gas	Fully-threaded stud	FD	UF
	Virtually fully-threaded stud <sup>b</sup>	MD	MF
	Partially threaded stud	PD	PF
	Threaded stud with reduced shaft	RD	RF
	Unthreaded stud	UD	UF
	Insulation pin/nail	ND	UF
	Stud with internal thread	ID	UF
	Shear connector	SD	UF/DF
Short-cycle drawn arc stud welding	Threaded stud with flange	PS	—
	Unthreaded stud	US	—
	Stud with internal thread	IS	—
Stud welding with tip ignition	Threaded stud	PT	—
	Unthreaded stud	UT	—
	Stud with internal thread	IT	—
<sup>a</sup> Further types of stud and ceramic ferrules can be specified as required for special applications.			
<sup>b</sup> Also called MPF, stud with a nearly full thread and a minimum length of the unthreaded part.			

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 with specified property classes — Coarse thread and fine pitch thread*

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

ISO 4042, *Fasteners — Electroplated coatings*

ISO 4759-1, *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C*

ISO 6947, *Welding and allied processes — Welding positions*

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ISO 15510, *Stainless steels — Chemical composition*

ISO/TR 15608, *Welding — Guidelines for a metallic materials grouping system*

ISO 16120-2, *Non-alloy steel wire rod for conversion to wire — Part 2: Specific requirements for general purpose wire rod*

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