

This is a preview of "ISO 13918:2017". [Click here to purchase the full version from the ANSI store.](#)

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)

© ISO 2017

This is a preview of "ISO 13918:2017". [Click here to purchase the full version from the ANSI store.](#)



COPYRIGHT PROTECTED DOCUMENT

© ISO 2017

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Fax: +41 22 749 09 47
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

This is a preview of "ISO 13918:2017". [Click here to purchase the full version from the ANSI store.](#)

Contents

	Page
Foreword	v
Introduction	vii
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Symbols and abbreviated terms	2
5 Requirements	3
5.1 Ordering information.....	3
5.2 Dangerous substances.....	3
5.3 Product requirements.....	3
5.3.1 Dimensions and tolerances on dimensions, form and position.....	3
5.3.2 Coating.....	3
5.3.3 Materials and mechanical characteristics.....	3
5.3.4 Weldability.....	4
5.4 Durability.....	5
6 Dimensions of studs	5
6.1 General.....	5
6.2 Fully-threaded stud (FD).....	6
6.3 Virtually fully-threaded stud (MD).....	7
6.4 Partially threaded stud (PD).....	8
6.5 Threaded stud with reduced shaft (RD).....	9
6.6 Unthreaded stud (UD).....	10
6.7 Insulation pin/nail (ND).....	11
6.8 Stud with internal thread (ID).....	12
6.9 Shear connector (SD).....	13
6.10 Threaded stud with flange (PS).....	14
6.11 Unthreaded stud (US).....	16
6.12 Stud with internal thread (IS).....	17
6.13 Threaded stud (PT).....	18
6.14 Unthreaded stud (UT).....	20
6.15 Stud with internal thread (IT).....	21
7 Dimensions of ceramic ferrules	21
8 Manufacture	23
8.1 Fully-threaded stud (FD), virtually fully-threaded stud (MD), partially threaded stud (PD), threaded stud with reduced shaft (RD), unthreaded stud (UD), stud with internal thread (ID).....	23
8.2 Shear connectors (SD).....	23
9 Inspection	23
9.1 General.....	23
9.2 Chemical analysis.....	24
9.3 Mechanical tests.....	24
9.4 Sample size.....	24
10 Marking	24
10.1 Traceability.....	24
10.2 Studs.....	24
10.3 Ceramic ferrules.....	25
11 Designation	25
11.1 Studs.....	25
11.2 Ceramic ferrules.....	25

This is a preview of "ISO 13918:2017". [Click here to purchase the full version from the ANSI store.](#)

Bibliography	26
---------------------------	-----------

This is a preview of "ISO 13918:2017". [Click here to purchase the full version from the ANSI store.](#)

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).

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).

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 ($CEV \leq 0,38$) 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 ;

This is a preview of "ISO 13918:2017". Click here to purchase the full version from the ANSI store.

- 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.

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

- footnote ^b in [Table 11](#) has been modified.

This is a preview of "ISO 13918:2017". [Click here to purchase the full version from the ANSI store.](#)

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.