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## **Welding — Arc stud welding of metallic materials**

*Soudage — Soudage à l'arc des goujons sur les matériaux métalliques*



Reference number  
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## Contents

	Page
<b>Foreword</b> .....	<b>vi</b>
<b>Introduction</b> .....	<b>vii</b>
<b>1 Scope</b> .....	<b>1</b>
<b>2 Normative references</b> .....	<b>1</b>
<b>3 Terms and definitions</b> .....	<b>2</b>
<b>4 Symbols and abbreviated terms</b> .....	<b>3</b>
4.1 Symbols.....	3
4.2 Abbreviated terms.....	4
<b>5 Technical review</b> .....	<b>4</b>
<b>6 Welding personnel</b> .....	<b>5</b>
6.1 Stud-welding operators.....	5
6.2 Welding coordination.....	5
<b>7 Equipment</b> .....	<b>6</b>
7.1 Production equipment.....	6
7.2 Description of the equipment.....	6
7.3 Maintenance.....	6
<b>8 Production planning</b> .....	<b>7</b>
<b>9 Welding procedure specification (WPS)</b> .....	<b>7</b>
9.1 General.....	7
9.2 Information related to the manufacturer.....	7
9.2.1 Identification of the manufacturer.....	7
9.2.2 Identification of the WPS.....	7
9.2.3 Reference to the welding procedure qualification record (WPQR) or other relevant documents.....	7
9.3 Information related to the parent material.....	7
9.3.1 Parent material type.....	7
9.3.2 Dimensions.....	7
9.4 Welding process.....	8
9.5 Joint.....	8
9.5.1 Joint design.....	8
9.5.2 Welding position.....	8
9.5.3 Preparation of parent material surface.....	8
9.5.4 Jigs and fixtures.....	8
9.5.5 Support.....	8
9.6 Studs.....	8
9.6.1 Designation.....	8
9.6.2 Handling.....	8
9.7 Auxiliaries.....	8
9.7.1 Ceramic ferrules (if any).....	8
9.7.2 Protective gas (if any).....	8
9.8 Power source.....	9
9.9 Movable fixtures.....	9
9.9.1 Welding gun/lift mechanism.....	9
9.9.2 Shielding gas system (if used).....	9
9.9.3 Stud feeding system (if any).....	9
9.10 Welding variables.....	9
9.10.1 Drawn-arc stud welding with ceramic ferrule or shielding gas and short-cycle drawn-arc stud welding.....	9
9.10.2 Capacitor discharge drawn-arc stud welding or capacitor discharge stud welding with tip ignition.....	9
9.11 Thermal conditions.....	9

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9.12	Post-weld heat-treatment .....	10
9.13	Non-thermal treatment after welding .....	10
<b>10</b>	<b>Welding procedure qualification .....</b>	<b>10</b>
10.1	Principles .....	10
10.2	Welding procedure tests .....	10
10.2.1	Application .....	10
10.2.2	Proof of conformity of parent materials and stud materials .....	10
10.2.3	Shape and dimensions of test pieces .....	11
10.2.4	Welding .....	11
10.2.5	Scope of examination and testing .....	11
10.2.6	Acceptance criteria .....	11
10.2.7	Re-testing .....	12
10.2.8	Range of qualification .....	12
10.3	Pre-production tests .....	14
10.3.1	Pre-production test for workshop applications .....	14
10.3.2	Pre-production test for stud welding on site (for through-deck stud welding) .....	14
10.4	Previous experience .....	15
10.5	Welding procedure qualification record (WPQR) .....	15
<b>11</b>	<b>Examination and testing .....</b>	<b>15</b>
11.1	General .....	15
11.2	Visual examination .....	15
11.3	Bend testing .....	16
11.4	Tensile testing .....	19
11.5	Torque test .....	22
11.6	Macro examination .....	22
11.7	Radiographic examination .....	22
11.8	Ring test .....	23
<b>12</b>	<b>Acceptance criteria .....</b>	<b>23</b>
12.1	General .....	23
12.2	Acceptance criteria for visual examination .....	23
12.3	Acceptance criteria for bend testing .....	23
12.4	Acceptance criteria for tensile testing .....	24
12.5	Acceptance criteria for torque testing .....	24
12.6	Acceptance criteria for macro examination .....	24
12.7	Acceptance criteria for radiographic examination .....	24
12.8	Acceptance criteria for ring tests .....	24
12.9	Acceptance criteria for additional tests .....	24
<b>13</b>	<b>Workmanship .....</b>	<b>24</b>
<b>14</b>	<b>Process control .....</b>	<b>25</b>
14.1	General .....	25
14.2	Production test .....	25
14.2.1	General .....	25
14.2.2	Production test for drawn-arc stud welding with ceramic ferrule or shielding gas and short-cycle drawn-arc stud welding .....	26
14.2.3	Production test for capacitor discharge stud welding with tip ignition and capacitor discharge drawn-arc stud welding .....	26
14.3	Simplified production test .....	26
14.4	Re-testing for production test or simplified production test .....	26
14.5	Production surveillance .....	27
14.5.1	Visual examination .....	27
14.5.2	Checking the welding parameters .....	27
14.5.3	Other examinations and tests .....	27
14.5.4	Production surveillance for drawn-arc stud welding with ceramic ferrule with qualification according to <a href="#">10.3.2</a> .....	<a href="#">27</a>
14.6	Production surveillance record .....	27
14.7	Non-conformance and corrective actions .....	27

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14.8	Calibration of the measuring and testing equipment.....	28
<b>Annex A</b>	<b>(informative) Processing of stud welding.....</b>	<b>29</b>
<b>Annex B</b>	<b>(normative) Quality requirements for stud welding.....</b>	<b>48</b>
<b>Annex C</b>	<b>(informative) Manufacturer's welding procedure specification (WPS).....</b>	<b>49</b>
<b>Annex D</b>	<b>(informative) Welding procedure qualification record form (WPQR) (for drawn-arc stud welding with ceramic ferrule or shielding gas and short-cycle drawn-arc stud welding).....</b>	<b>50</b>
<b>Annex E</b>	<b>(informative) Welding procedure qualification record form (WPQR) (for capacitor discharge stud welding with tip ignition and capacitor discharge drawn-arc stud welding).....</b>	<b>54</b>
<b>Annex F</b>	<b>(informative) Test results — Production test (for drawn-arc stud welding with ceramic ferrule or shielding gas and short-cycle drawn-arc stud welding).....</b>	<b>58</b>
<b>Annex G</b>	<b>(informative) Test results — Production test (for capacitor discharge stud welding with tip ignition and capacitor discharge drawn-arc stud welding).....</b>	<b>61</b>
<b>Annex H</b>	<b>(informative) Example of production surveillance record.....</b>	<b>64</b>
<b>Bibliography</b>	<b>.....</b>	<b>65</b>

## Foreword

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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)).

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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 fourth edition cancels and replaces the third edition (ISO 14555:2014), of which it constitutes a minor revision and contains the following changes:

- undated references to ISO 14732, ISO 13918 and ISO 15607;
- the expression “welding diameter” has been changed to “welded cross-section” in [3.6](#);
- the word “deformability” has been changed to “deformation” in the last sentence of [12.3](#);
- the second and third paragraphs of [12.4](#) have been combined;
- the expression “welding diameter” has been changed to “visible width of the welding zone” in [12.6](#);
- the appearance “Collar off-centre with unacceptable undercut” is now given under “Visual examination or macro cut” in [Table A.5](#);
- the missing symbol “≤” in [Annex D](#) has been introduced for application ≤100 °C.

Requests for official interpretations of any aspect of this document should be directed to the Secretariat of ISO/TC 44/SC 10 via your national standards body. A complete listing of these bodies can be found at [www.iso.org](http://www.iso.org).

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## Introduction

The purpose of arc stud welding is to weld predominantly pin-shaped metal parts to metal workpieces. In this document, it is referred to simply as stud welding. Among other things, stud welding is used in bridge building (especially in composite structures), steel structures, shipbuilding, facade-wall fabrication, vehicle manufacture, apparatus engineering, steam-boiler construction, and the manufacture of household appliances.

The quality of a stud weld depends not only on strict compliance with the welding procedure specification but also on the correct function of the actuating mechanism (e.g. welding guns), and on the condition of the components, of the accessories and of the power supply.

This document does not invalidate former specifications, providing the technical requirements are equivalent and satisfied.