

**Keevitamine. Metallide vastakkaarseevitus**

**Welding - Arc stud welding of metallic materials (ISO 14555:2014)**

EVS

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

See Eesti standard EVS-EN ISO 14555:2014 sisaldab Euroopa standardi EN ISO 14555:2014 inglisekeelset teksti.	This Estonian standard EVS-EN ISO 14555:2014 consists of the English text of the European standard EN ISO 14555:2014.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
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Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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English Version

**Welding - Arc stud welding of metallic materials (ISO  
14555:2014, Corrected version 2014-06-01)**

Soudage - Soudage à l'arc des goujons sur les matériaux  
métalliques (ISO 14555:2014, Version corrigée 2014-06-01)

Schweißen - Lichtbogenbolzenschweißen von metallischen  
Werkstoffen (ISO 14555:2014, korrigierte Fassung 2014-  
06-01)

This European Standard was approved by CEN on 20 March 2014.

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

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

## Foreword

This document (EN ISO 14555:2014) 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of an identical text or by endorsement, at the latest by October 2014, and conflicting national standards shall be withdrawn at the latest by October 2014.

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 14555:2006.

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, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

### Endorsement notice

The text of ISO 14555:2014, Corrected version 2014-06-01 has been approved by CEN as EN ISO 14555:2014 without any modification.

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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 meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Unification of requirements in the field of metal welding*.

This third edition cancels and replaces the second edition (ISO 14555:2006), which has been technically revised.

This corrected version of ISO 14555:2014 incorporates the following corrections:

- 9.5.6 was renumbered 9.6; consequently, subclauses 9.7 to 9.12 were also renumbered;
- in 11.1, "The methods described in 11.2 to 11.7 may be used ..." was replaced with "The methods described in 11.2 to 11.8 may be used ...";
- in Table A.6, No. 5, the incorrect figure was replaced with the correct one;
- in Annex C, "☒ no" was replaced with "☐ yes      ☐ no".

## Introduction

The purpose of arc stud welding is to weld predominantly pin-shaped metal parts to metal workpieces. In this International Standard it is referred to simply as stud welding. Amongst other things, stud welding is used in bridge building (especially in composite structures), steel structures, shipbuilding, facade-wall fabrication, vehicle manufacture, equipment design, 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 International Standard does not invalidate former specifications, providing the technical requirements are equivalent and satisfied.

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# Welding — Arc stud welding of metallic materials

## 1 Scope

This International Standard covers arc stud welding of metallic materials subject to static and fatigue loading. It specifies requirements that are particular to stud welding, in relation to welding knowledge, quality requirements, welding procedure specification, welding procedure qualification, qualification testing of operators and testing of production welds.

This International Standard is appropriate where it is necessary to demonstrate the capability of a manufacturer to produce welded construction of a specified quality.

NOTE General quality requirements for fusion welding of metallic materials are given in ISO 3834-1, ISO 3834-2, ISO 3834-3, ISO 3834-4 and ISO 3834-5.

This International Standard has been prepared in a comprehensive manner, with a view to it being used as a reference in contracts. The requirements contained within it can be adopted in full, or partially, if certain requirements are not relevant to a particular construction (see Annex B).

## 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 857-1, *Welding and allied processes — Vocabulary — Part 1: Metal welding processes*

ISO 3834-1, *Quality requirements for fusion welding of metallic materials — Part 1: Criteria for the selection of the appropriate level of quality requirements*

ISO 3834-2, *Quality requirements for fusion welding of metallic materials — Part 2: Comprehensive quality requirements*

ISO 3834-3, *Quality requirements for fusion welding of metallic materials — Part 3: Standard quality requirements*

ISO 3834-4, *Quality requirements for fusion welding of metallic materials — Part 4: Elementary quality requirements*

ISO 4063, *Welding and allied processes — Nomenclature of processes and reference numbers*

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

ISO 9606-1, *Approval testing of welders — Fusion welding — Part 1: Steels*

ISO 9606-2, *Qualification test of welders — Fusion welding — Part 2: Aluminium and aluminium alloys*

ISO 13918:2008, *Welding — Studs and ceramic ferrules for arc stud welding*

ISO 14175, *Welding consumables — Shielding gases for arc welding and cutting*

ISO 14731, *Welding coordination — Tasks and responsibilities*

ISO 14732:1998, *Welding personnel — Approval testing of welding operators for fusion welding and of resistance weld setters for fully mechanized and automatic welding of metallic materials*

ISO 15607:2003, *Specification and qualification of welding procedures for metallic materials — General rules*

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

ISO 15611, *Specification and qualification of welding procedures for metallic materials — Qualification based on previous welding experience*

ISO 15613, *Specification and qualification of welding procedures for metallic materials — Qualification based on pre-production welding test*

ISO 15614-1:2004, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys*

ISO 15614-2, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 2: Arc welding of aluminium and its alloys*

ISO 17636-1, *Non-destructive testing of welds — Radiographic testing — X- and gamma-ray techniques with film*

ISO 17636-2, *Non-destructive testing of welds — Radiographic testing — X- and gamma-ray techniques with digital detectors*

ISO 17662, *Welding — Calibration, verification and validation of equipment used for welding, including ancillary activities*

### 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 857-1, ISO 3834-1, ISO 4063, ISO 14731, ISO 14732 and ISO 15607 and the following apply.

#### 3.1 stud

fastener to be attached by stud welding

#### 3.2 auxiliaries

ceramic ferrules and shielding gases

#### 3.3 stud-welding operator

operating personnel for stud-welding equipment

Note to entry In special cases (e.g. mass production at the manufacturer's factory) the welding can be carried out by suitable auxiliary personnel, appropriately trained and supervised.

#### 3.4 stud diameter

*d*

stud nominal diameter

Note 1 to entry See ISO 13918.