

ICS 21.060.10
CCS J 13



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 10432-1989

**Unthreaded studs for drawn arc stud welding with ceramic
ferrule**

(English Translation)

Issued on: January 10, 2011

Implemented on: October 1, 2011

Issued by: Standardization Administration of China

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Foreword

This section GB/T 10432 (hereinafter referred to in this section) is one of the national standard "stud welding and welding nails" product series standards, the department Columns include.

- GB/T 902.1-2008 manual welding with welding studs;
- GB/T 902.2-2010 stud welding arc stud welding;
- GB/T 902.3-2008 discharge welding studs;
- GB/T 902.4-2010 short cycle stud welding arc stud welding;
- GB/T 10432.2-2010 short cycle stud welding arc welding with headless nails;
- GB/T 10432.3-2010 discharge welding of the headless studs;
- GB/T 10433-2002 arc stud welding with welding cylinder head nails.

This part of GB/T 10432 Part 1.

The partial modification of the use of ISO 13918:2008 "with the stud welding arc stud welding and magnetic" provides non-threaded studs (UD type) (In English).

This part of ISO 13918:2008 without threaded studs (UD type) the main changes are as follows.

- ISO 13918 certification provisions covering products, market access for testing and factory production control, and ISO/TC2 developed Fastener different product standards, there are also quite different from the actual situation of our country, so were not used;
- In the reference file, instead of using our standards with international standards (Chapter 2);
- ISO 13918 does not provide packaging technology requirements in this section shall be

specified (see Table 3);

--- ISO 13918 does not provide for a simplified mark, according to this part of GB/T 1237 presents a simplified markup (see 6.1.2).

This section in Appendix A and Appendix B is an informative annex.

This part is proposed by China Machinery Industry Federation.

This part of the National Standardization Technical Committee fasteners (SAC/TC85) centralized.

This section is responsible for drafting unit. Productivity Promotion Center in the machine.

Participated in the drafting of this section. Beijing Hongguang Electrical Equipment Factory, Ningbo Kowloon Fastener Manufacturing Co., Ltd.

Arc stud welding of the headless studs

1 Scope

This section GB/T 10432 specifies the nominal diameter of 6mm ~ 16mm arc stud welding with headless studs (UD type) and distribution Magnetic ring sets used (UF type).

Type of product standards ISO 13918 and control provisions, see Appendix A.

2 Normative references

The following documents contain provisions which, through reference GB/T 10432 in this section constitute provisions of this section. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest versions apply to this section.

GB/T 90.1 fasteners acceptance inspection (GB/T 90.1-2002, idt ISO 3269:2000) GB/T 90.2 Fasteners marking and packaging GB/T 1237 fasteners labeling method (GB/T 1237-2000, eqv ISO 8991. 1986) GB/T 3098.1 Mechanical properties of fasteners Bolts, screws and studs (GB/T 3098.1-2010, ISO 898-1:2009, IDT) GB/T 3098.6 Mechanical properties of fasteners stainless steel bolts, screws and studs (GB/T 3098.6-2000, idt ISO 3506-1.

1997)

GB/T 3103.1 Tolerances for fasteners - Bolts, screws, studs and nuts (GB/T 3103.1-2002, ISO 4759-1:2000, IDT)

3.1 General

--- Weld length (l_2) is the design value. Appropriately controlled welding to maintain l_2 within $\pm 1\text{mm}$. Under special conditions, such as penetration - loaded Accessories Stud Welding l_2 may be different from the nominal value.

--- No threaded stud (UD) tip should be fitted with press-fitted aluminum rod or aluminum coating. Diameter stainless steel studs and $\leq 10\text{mm}$, and Inert gas welding of the case, this requirement may be omitted.

After welding size --- Figure 1 shows the reference value.

--- A) of Figure 1 is not specified dimensions and tolerances, determined by the manufacturer. This also applies to the shape of the stud welding position changes, such as drilling and slotting not affect the weldability.

D7 --- bead diameter is the main factor affecting the quality of welding; changes in other dimensions without impairing the quality of welding.

--- Headless studs (UD type) quality, see Appendix B.

3.2 Headless studs (UD type)

Headless studs (UD-type) type dimensions shown in Figure 1 and Table 1.