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

GB/T 10432.2-2016

**Unthreaded stud for short-cycle drawn arc stud welding
(English Translation)**

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Foreword

This part of GB/T 10432 is one of the national standards for "welding studs and welding nails". The series includes.

--- GB/T 902.1 manual welding studs;

GB/T 902.2 welded studs for arc stud welding;

GB/T 902.3 welding studs for energy storage welding;

Welding studs for short - period arc stud welding GB/T 902.4;

GB/T 10432.1 No head welding nails for arc stud welding;

GB/T 10432.2 short-cycle arc stud welding headless welding nails;

GB/T 10432.3 headless welding rod for energy storage welding;

GB/T 10433 cylindrical studs for arc stud welding.

This part is part 2 of GB/T 10432.

This part is drafted in accordance with the rules given in GB/T 1.1-2009.

This part uses the re-drafting method to modify ISO 13918.:2008 "studs and porcelain rings for welding arc studs" (English version) Fixed screw thread (US type).

The technical differences between this section and ISO 13918.:2008 are as follows.

--- remove the ISO 13918 provisions related to product certification, market access inspection and factory production control and other "technical requirements" of the content, its and ISO/TC2 has developed a fastener product standards are very different, but also with our current actual situation is quite different;

- in the normative reference document, with our standard instead of international standards (Chapter 2), increase the reference GB/T 90.1 (Table 2), GB/T 90.2 (Table 2) and GB/T

1237 (6.1), delete ISO 4042, ISO 4964, ISO 6892, ISO 6947, ISO 14555, ISO/T R15608, EN573-3, EN1301-2, EN10088-1, EN12166, to comply with our fastener base Standard;

--- to increase the packaging technical requirements (Table 6) to meet the basic standards of China's fasteners;

--- Example of a modified mark is a simplified markup example (6.2) to comply with the requirements of GB/T 1237.

This standard has also made the following editorial changes.

--- modify the standard name;

--- Remove ISO 13918 references.

This part is made by the China Machinery Industry Federation.

This part is headed by the National Standardization Technical Committee on Fasteners (SAC/TC85).

This part is responsible for drafting units. China Machine Productivity Promotion Center.

This part participated in the drafting unit. Machinery Industry General Parts Product Quality Supervision and Testing Center, Ningbo Machinery Parts and Equipment Testing Co., Ltd.

the company.

This part is explained by the Secretariat of the National Standardization Technical Committee for Fasteners.

Non - endless welding of short - cycle arc stud welding

1 Scope

This part of GB/T 10432 specifies the type, technical conditions and marking of the headless nail for short cycle arc stud welding.

This part applies to the nominal diameter of 3mm ~ 8mm short cycle arc stud welding headless welding nail (US type).

Note: ISO 13918 provides the product type and our standard, see Appendix A.

2 Normative reference documents

The following documents are indispensable for the application of this document. For dated references, only the dated edition applies to this article Pieces. For undated references, the latest edition (including all modifications) applies to this document.

GB/T 90.1 Acceptance inspection of fasteners (GB/T 90.1-2002, idt ISO 3269..2000) GB/T 90.2 Fastener Marking and Packaging GB/T 1237 Fastener marking method (GB/T

1237-2000, eqvISO 8991. 1986) GB/T 3098.1 Fasteners - Mechanical properties - Bolts, screws and studs (GB/T 3098.1-2010, ISO 898-1.:2009, IDT) GB/T 3098.6 Fasteners - Mechanical properties - Stainless steel bolts, screws and studs (GB/T 3098.6-2014, ISO 3506-1.

2009, MOD)

GB/T 3103.1 Fasteners Tolerances Bolts, screws, studs and nuts (GB/T 3103.1-2002, idtISO 4759-1.:2000)

3.1 General rules

The length of the weld (l_2) is the design value. Properly control the welding to keep it within $l_2 \pm 1\text{mm}$. Under special conditions, such as penetrating - decorations the stud welding l_2 may differ from the nominal value.

The dimensions after welding in Figure 1 are reference values.

In Figure 1, the dimensions and tolerances not specified before welding are determined by the manufacturer. This also applies to the modification of the stud shape of the welded parts, such as Drilling and grooving do not affect weldability.

3.2 No head welding nail (US type)

The size of the headless nail (US type) is shown in Figure 1 and Table 1.