



根据DIN EN ISO 14555已认证的生产管制测试 Qualified Production Control Test as per DIN EN ISO 14555

拉弧式螺柱焊 — SRM-Technology®

Drawn arc stud welding — SRM-Technology®



HZ-1 Stud HZ-1 螺柱	Material according to DIN EN ISO 10888	Breaking force ²⁾	Welding current	Welding time
Dimension 尺寸	材料标准 DIN EN ISO 10888	断裂力/kN ²⁾	焊接电流/A	焊接时间/ms
M8	X5CrNi18-10 (A2-50)	27	550	100
M10	X5CrNi18-10 (A2-50)	45	720	180
M12	X5CrNi18-10 (A2-50)	61	940	200

断裂力相当于HZ-1螺钉的抗拉强度¹⁾
Breaking force corresponds to tensile strength of the HZ-1 weld stud¹⁾

焊接位置: PA、PC、PE | 保护气: 82%Ar+18%CO₂
Welding position: PA, PC, PE | Process gas: 82%Ar+18%CO₂

- 1) 螺钉每次均是在螺钉法兰上或焊接范围外断裂。HZ-1 SOYER 螺钉的抗拉强度 $R_m = 20\% > 500 \text{ N/mm}^2$ (A2-50)
2) 测试中最低的断裂力
- 1) Stud always breaks above the stud flange or welding zone. Tensile strength of HZ-1 SOYER welding studs $R_m = 20\% > 500 \text{ N/mm}^2$ (A2-50)
2) Minimum measured breaking force



a) M8
屈曲角度: >60°测试代表成功
TEST Bending angle:
>60° Test regarded as successful.

b) M10
熔融区很薄却有好的熔深
Good penetration form with a thin
melting zone.

b) M12
抗拉力测试, 螺柱断裂
Tensile test. Weld stud fracture.

图片来源/Image source: GSI mbH NL SLV München

以上结果是根据GSI mbH NL SLV München独立进行的「DIN EN ISO 14555 已认证的生产管制测试」并于生产环境使用X5CrNi18-10材料的M8、M10及M12螺钉进行三项额外测试（目视检测、屈曲测试、抗拉强度测试及分析抛光后的焊接熔融区）。

The results correspond to a “Qualified Production Control Test as per DIN EN ISO 14555” carried out by the GSI mbH NL SLV Munich and are based on production tests with M8, M10 and M12 weld studs made of X5CrNi18-10 using an expanded scope of testing (visual inspection, bend test, tensile test and assessment of the fusion zone's polished section).

技术规格如有变更, 恕不另行通知。 | 请关注www.soyer.com.cn, 获取更多信息。

