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**AUTOMOTIVE INDUSTRY STANDARD
OF THE PEOPLE'S REPUBLIC OF CHINA**

ICS 43.040

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QC/T 857-2023

Replacing QC/T 857-2011

Weld Studs

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Foreword

This Document was drafted as per the rules specified in GB/T 1.1-2020 *Directives for Standardization – Part 1: Rules for the Structure and Drafting of Standardizing Documents*.

This Document replaced QC/T 857-2011 *Weld Studs*. Compared with QC/T 857-2011, the major technical changes of this Document are as follows:

- Add the applicable system of products specified in this Document (see Clause 1 of this Edition);
- Add the mechanical property grade 8.8 of weld studs (see Table 1 of this Edition);
- Increased the tolerance product grade of weld stud threads from B to A (see Table 1 of this Edition);
- Add the types of surface treatment (see Table 2 of this Edition);
- Add the requirements for hazardous substances in automobiles (see Table 2 of this Edition).

This Document was proposed by and under the jurisdiction of National Technical Committee of Auto Standardization (SAC/TC 114).

Drafting organizations of this Document: Zhejiang Jieneng Auto Parts Co., Ltd.; Sichuan Aerospace Shiyuan Technology Co., Ltd.; Anhui Jianghuai Automobile Group Co., Ltd.; Zhejiang University of Technology; Changchun Automotive Test Center Co., Ltd.; Dongfeng Motor Corporation; and Beijing Foton Daimler Automotive Co., Ltd.

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The historical editions replaced by this Document are as follows:

- QC/T 857-2011;
- It is first-time revised hereby.

Weld Studs

1 Scope

This Document specifies the type, size, technical conditions and number of weld studs with thread specifications of M5 ~ M16, mechanical property grades 4.8 and 8.8, fastener tolerance product grade A, and no surface treatment.

This Document is applicable to weld studs that can adjust the length of the tie rod with the threaded fork after welding the tie rod with the weld studs of the automobile control mechanism.

2 Normative References

The provisions in following documents become the essential provisions of this Document through reference in this Document. For the dated documents, only the versions with the dates indicated are applicable to this Document; for the undated documents, only the latest version (including all the amendments) is applicable to this Document.

GB/T 90.1 Fasteners – Acceptance inspection

GB/T 90.2 Fasteners – Marking and packaging

GB/T 196 General Purpose Metric Screw Threads - Basic Dimensions

GB/T 197 General Purpose Metric Screw Threads - Diameter and pitch series

GB/T 3098.1 Mechanical properties of fasteners - Bolts, screws and studs

GB/T 3103.1 Tolerances for fasteners - Bolts, screws, studs and nuts

GB/T 30512 Requirements for prohibited substances on automobiles

GB/T 5779.1 Fasteners - Surface discontinuities - Bolts, screws and studs for general requirements

QC/T 326 Coding rules for automotive standardized parts

QC/T 625 Metallic coatings and conversion coatings for automobile

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