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AUTOMOBILE INDUSTRY STANDARD
OF THE PEOPLE'S REPUBLIC OF CHINA

ICS 43.040

CCS T 31

QC/T 869-2022

Replacing QC/T 869-2011

Short-cycle drawn arc welding stud

短周期弧焊焊接螺栓

Issued on: April 08, 2022

Implemented on: October 01, 2022

Issued by: Ministry of Industry and Information Technology of PRC

Announcement of Ministry of Industry and Information Technology of PRC

No.10 of 2022

The Ministry of Industry and Information Technology approved 555 industry standards, such as the "Regulations on mechanical design of chemical plant pipelines" (see Annex 1). Among them, it includes 4 chemical industry standards, 8 petrochemical industry standards, 5 non-ferrous metal industry standards, 3 building materials industry standards, 156 machinery industry standards (including pharmaceutical equipment), 45 automobile industry standards, 6 shipping industry standards, 48 aviation industry standards, 68 light industry standards, 103 textile industry standards, 6 packaging industry standards, 18 electronics industry standards, 85 communication industry standards. It has approved the amendment of one automobile industry standard of "Tail lifting lifts for vehicles" (see Annex 2). It has approved the foreign language versions of 11 industry standards, such as "Travel luggage and bags" (see Annex 3), including 8 light industry standards, 2 textile industry standards, 1 electronics industry standard. It has approved 79 industry standard samples including "Standard sample of Sorbitite content in high carbon steel wire rod" (see Annex 4), including 78 metallurgical industry standards and 1 non-ferrous metal industry. They are all hereby announced. The industry standard amendment list and industry standard samples will be implemented from the date of release.

The above chemical industry standards (engineering construction) and automobile industry standards are published by Beijing Science and Technology Press. The petrochemical industry standards are published by Sinopec Press. The non-ferrous metal industry standards (engineering construction) are published by China Planning Press. The building material standards are published by China Building Materials Industry Press. The machinery industry standards are published by Machinery Industry Press. The machinery (pharmaceutical equipment) industry standards, textile industry standards (including foreign language versions) and packaging industry standards are published by China Standard Publishing House. The ship industry standards are published under the organization by China Shipbuilding Industry Comprehensive Technical and Economic Research Institute. The aviation industry standards are published under the organization of the China Aviation Comprehensive Technology Research Institute. The light industry standard (including the foreign language version) is published by the China Light Industry Publishing House. The electronics industry standard (including the foreign language version) is published, under the organization of the China Electronics Institute of Technical Standardization. The communication industry standard is published by the People's Posts and Telecommunications Press.

Attachment: Number, standard name and implementation dates of 45 automotive industry standards

Ministry of Industry and Information Technology of the People's Republic of China

April 8, 2022

Annex:

Number, standard name and implementation dates of 45 automotive industry standards

No.	Standard No.	Standard name	Replaced standard No.	Date of implementation
177	QC/T 1157-2022	Method of calculating comprehensive energy consumption for unit output of automobile products		2022-10-01
178	QC/T 1158-2022	Method of calculating comprehensive water consumption for unit output of automobile products		2022-10-01
179	QC/T 1159-2022	Guidelines on evaluation of automobile industry green supply chain management		2022-10-01
180	QC/T 1160-2022	Guidelines on evaluation of whole vehicle manufacturing green factory in automobile industry		2022-10-01
181	QC/T 1161-2022	Technical specifications for green-design product assessment - Automobile		2022-10-01
182	QC/T 1162-2022	Honeycomb sandwich structure product for automobile exterior decoration parts		2022-10-01
183	QC/T 1163-2022	Automotive diesel engines - Reduction agent filter for selective catalytic reduction (SCR) system		2022-10-01
184	QC/T 1164-2022	Natural gas filter for road vehicle		2022-10-01
185	QC/T 1165-2022	Carbon canister air filter for gasoline passenger car		2022-10-01
186	QC/T 1166-2022	Streaming mirror view mirror for vehicle		2022-10-01
187	QC/T 1167-2022	Service brake dynamometer squeal noise test methods for passenger cars		2022-10-01
188	QC/T 1168-2022	Performance requirements and bench test methods for vehicle electric air compressor		2022-10-01
189	QC/T 463-2022	Technical requirements and bench test methods for automotive hydrodynamic torque converter assembly		2022-10-01
190	QC/T 792-2022	Motors and controllers for electric motorcycles and electric mopeds		2022-10-01
191	QC/T 1169-2022	Liquid crystal instrument for automobile		2022-10-01
192	QC/T 1170-2022	Performance film for automotive glass		2022-10-01
193	QC/T 1171-2022	Automotive paint protection film		2022-10-01
194	QC/T 804-2022	Instrument panel assembly and Console assembly for passenger cars		2022-10-01
195	QC/T 1016-2022	Door trim panel assembly for passenger cars		2022-10-01
196	QC/T 768-2022	Toilet of passenger car		2022-10-01
197	QC/T 580-2022	Mounting dimensions of automobile transmission assembly		2022-10-01
198	QC/T 1172-2022	Performance requirements and test methods of exhaust muffler for vehicles air brake equipment		2022-10-01
199	QC/T 237-2022	Bench test methods for the performance of automobile parking brake		2022-10-01

No.	Standard No.	Standard name	Replaced standard No.	Date of implementation
200	QC/T 1173-2022	Road vehicles - Spark-plugs application test methods		2022-10-01
201	QC/T 1174-2022	High voltage fuse of electric vehicles		2022-10-01
202	QC/T 1175-2022	High voltage contactor for electric vehicles		2022-10-01
203	QC/T 1176-2022	Evaporator for automotive air conditioning		2022-10-01
204	QC/T 1177-2022	Condenser for automotive air conditioning		2022-10-01
205	QC/T 633-2022	The seats of passenger vehicles		2022-10-01
206	QC/T 80-2022	Road vehicles - Polyamide (PA) tubing for air braking systems		2022-10-01
207	QC/T 1178-2022	Motor vehicle and towed vehicle Pneumatic braking system - Tapped and male fitting		2022-10-01
208	QC/T 1179-2022	Specification for wheel bolts of automobile		2022-10-01
209	QC/T 869-2022	Short-cycle drawn arc welding stud		2022-10-01
210	QC/T 870-2022	Double end studs $b_m = 1.25d$		2022-10-01
211	QC/T 871-2022	Double end studs $b_m = 2d$		2022-10-01
212	QC/T 598-2022	Bolt-for projection welding on the bearing face		2022-10-01
213	QC/T 599-2022	Overhead projection weld bolts		2022-10-01
214	QC/T 624-2022	Rubber plugs		2022-10-01
215	QC/T 603-2022	Clips - Type A		2022-10-01
216	QC/T 604-2022	Clips - Type B		2022-10-01
217	QC/T 605-2022	Clips - Type C		2022-10-01
218	QC/T 606-2022	Clips - Type H		2022-10-01
219	QC/T 618-2022	Specification for plastic expansion nut		2022-10-01
220	QC/T 928-2022	Plastic cable and tubing clips with inter-fix hole		2022-10-01
221	QC/T 929-2022	Plastic cable and tubing clips with side-fix hole		2022-10-01

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Foreword

This document was in accordance with the requirements of GB/T 1.1-2020 "Directives for standardization - Part 1: Rules for the structure and drafting of standardizing documents".

This document replaces QC/T 869-2011 "Short-cycle drawn arc welding stud". Compared with QC/T 869-2011, except for editorial modifications, the main changes are as follows:

- CHANGE the limit deviation of "l" in the dimension, from the original tolerance to "js15" (see table 1);
- CHANGE the limit deviation value of d_k ; MAINTAIN maximum tolerance; the deviation value is h14 (see Table 1);
- CHANGE product grade of "Tolerance" in the specification, from "B" to "A" (see Table 2).

This document was proposed by AND shall be under the jurisdiction of the National Automotive Standardization Technical Committee (SAC/TC 114).

Drafting organizations of this document: Shanghai Dongfeng Motor Special Parts Co., Ltd., China FAW Group Co., Ltd. Research and Development Institute, Shanghai Automotive Passenger Vehicle Corporation.

The main drafters of this document: Xiong Yaping, Yang Chaoyang, Zhang Qiongmin.

This standard replaces the standard previously issued as follows:

- It was first published as QC/T 869-2011 in 2011;
- This is the first revision.

Short-cycle drawn arc welding stud

1 Scope

This document specifies the type, size, technical conditions of short-cycle drawn arc welding stud.

This document is applicable to short-cycle drawn arc welding studs for automobiles, which have thread specifications of M3 ~ M10 and mechanical performance grades of 4.8 and 8.8.

2 Normative references

The contents of the following documents constitute the essential provisions of this document through normative references in the text. Among them, for dated references, only the version corresponding to the date is applicable to this document; for undated references, the latest version (including all amendments) is applicable to this document.

GB/T 2 Fasteners - Ends of parts with external thread

GB/T 90.1-2002 Fasteners - Acceptance inspection

GB/T 90.2-2002 Fasteners - Marking and packaging

GB/T 196 General purpose screw threads-Basic dimensions for diameter from 1 to 600mm

GB/T 197 Common thread - Tolerances

GB/T 3098.1-2010 Mechanical properties of fasteners - Bolts, screws and studs

GB/T 3103.1-2002 Essential oils and aromatic extracts - Determination of residual benzene content

GB/T 5779.1-2000 Fasteners - Surface discontinuities - Bolts, screws and studs for general requirements

GB/T 30512 Requirements for prohibited substances on automobiles

QC/T 326 Coding rules for automotive standardized parts

QC/T 625 Metallic coatings and conversion coatings for automobiles

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