

**EN 1992-1-1:2023**

Eurocode 2. Design of concrete structures. General rules and rules for buildings, bridges and civil engineering structures

**EN 1992-1-2:2023**

Eurocode 2. Design of concrete structures. General rules. Structural fire design

**EN 1996-3:2023**

Eurocode 6. Design of masonry structures. Simplified calculation methods for unreinforced masonry structures

**EN ISO 15614-13:2023**

Specification and qualification of welding procedures for metallic materials. Welding procedure test. Upset (resistance butt) and flash welding  
ISO 15614-13:2023

**ISO PUBLICATIONS**

**ISO 17607-6:2023**

Steel structures. Execution of structural steelwork. Bolting  
Will be implemented as an identical British Standard

**CEN TECHNICAL SPECIFICATIONS**

**CEN/TS 19102:2023**

Design of tensioned membrane structures

# AD 520: Amendment to Table 8 in the MPS-Bolts (issue 14)

The BCSA has reviewed the requirements for impact test for machined test pieces in Table 8 of the Model specification for the purchase of structural bolting assemblies and holding down bolts (MPS-Bolts) following discussions with bolt suppliers. Currently Table 8 requires a sample size of three bolts, per manufacturing lot, for property classes up to and including 8.8, and five bolts for property class 10.9, see table, top right.

For bolts used in normal UK temperatures (T), (i.e. minimum -15°C), a sample size of one bolt, per manufacturing lot, for any property class, was found to be more appropriate. This is in line with Table 9 of the MPS-Bolts. For bolts used in temperatures below -15°C but above -50°C, a sample size of three bolts, per manufacturing lot, for all property classes should be specified. For bolts used below -50°C, the purchaser should discuss the sample size with a bolt metallurgist and consider increasing the sample size. The new sample size should be communicated to the bolt supplier on the purchase order.

It is the responsibility of the purchaser to

Property (see Table 3 of BS EN ISO 898-1:2013)		Test method	Reference	Sample size	
No.				≤8.8	10.9
18	Impact strength, $K_v$	Impact test for machined test pieces	Clause 9.14 of BS EN ISO 898-1:2013	3	5

Table 8 – Inspection and testing requirements for bolts of property class 4.6 in all diameters and property class 8.8 and 10.9 up to M39

Property (see Table 3 of BS EN ISO 898-1:2013)		Test method	Reference	Sample size		
No.				T (°C)	≤8.8	10.9
18	Impact strength, $K_v$	Impact test for machined test pieces	Clause 9.14 of BS EN ISO 898-1:2013	-15	1	1
				-50<T-15	3	3
				≤ -50	Seek advice	

Table 8 – Inspection and testing requirements for bolts of property class 4.6 in all diameters and property class 8.8 and 10.9 up to M39 (revised)

confirm the sample size at the time of order, otherwise it will be assumed that the fasteners will not be used at service temperatures below -15°C.

The revised Table 8 for evaluation of the impact

strength should read as the table bottom right.

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