

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

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>See Eesti standard EVS-EN ISO 15614-13:2023 sisaldab Euroopa standardi EN ISO 15614-13:2023 ingliskeelset teksti.</p> <p>Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas</p> <p>Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 22.11.2023.</p> <p>Standard on kättesaadav Eesti Standardimis-ja Akrediteerimiskeskusest.</p>	<p>This Estonian standard EVS-EN ISO 15614-13:2023 consists of the English text of the European standard EN ISO 15614-13:2023.</p> <p>This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation and Accreditation.</p> <p>Date of Availability of the European standard is 22.11.2023.</p> <p>The standard is available from the Estonian Centre for Standardisation and Accreditation.</p>
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English Version

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

Descriptif et qualification d'un mode opératoire de
soudage pour les matériaux métalliques - Épreuve de
qualification d'un mode opératoire de soudage - Partie
13: Soudage en bout par résistance pure et soudage par
étincelage (ISO 15614-13:2023)

Anforderung und Qualifizierung von Schweißverfahren
für metallische Werkstoffe -
Schweißverfahrensprüfung - Teil 13: Pressstumpf- und
Abbrennstumpfschweißen (ISO 15614-13:2023)

This European Standard was approved by CEN on 7 July 2023.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

European foreword

This document (EN ISO 15614-13:2023) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2024, and conflicting national standards shall be withdrawn at the latest by May 2024.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 15614-13:2021.

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

Endorsement notice

The text of ISO 15614-13:2023 has been approved by CEN as EN ISO 15614-13:2023 without any modification.

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 6, *Resistance welding and allied mechanical joining*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 15614-13:2021), which has been technically revised.

The main changes are as follows:

- petal test changed to bend test and bend test changed to three-point bend test;
- scope aligned with ISO 15614-1;
- [Clauses 2, 3, 7 and 8](#) updated;
- clause numbering revised;
- [Annex A](#) and Annex B combined into a new [Annex A](#).
- [Table 1](#) modified;
- Clause 9 aligned with ISO 15614-1;

A list of all parts in the ISO 15614 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html. Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

Introduction

It is intended that all new welding procedure qualifications be carried out in accordance with this document from the date of its publication.

However, this document does not invalidate previous welding procedure qualifications made to other standards or specifications, provided the intent of its technical requirements is satisfied and the previous welding procedure qualifications are relevant to the application and production work on which they are to be employed.

The primary purpose of welding procedure qualification is to demonstrate that the joining process proposed for construction is capable of producing joints having the required mechanical properties for the intended application.

Details of the ISO 15614 series are given in ISO 15607:2019, Annex A.

Specification and qualification of welding procedures for metallic materials — Welding procedure test —

Part 13: Upset (resistance butt) and flash welding

1 Scope

This document specifies how a preliminary welding procedure specification (pWPS) is qualified by welding procedure tests.

This document defines the conditions for the execution of welding procedure tests and the range of qualification for welding procedures for all welding operations within the qualification of this document.

Two classes of welding procedure tests are given in order to permit application to a wide range of welded fabrication. They are designated by classes A and B. In class A, the extent of testing is greater and the ranges of qualification are more restrictive than in class B.

Procedure tests carried out to class A automatically qualify for class B requirements, but not vice-versa.

When no class is specified in a contract or application standard, all the requirements of class A apply.

NOTE Class B corresponds to level 1 and class A corresponds to level 2 in accordance with ISO 15614-1.

This document applies to upset (resistance butt) welding and flash welding of any metallic materials in all product forms (e.g. with solid, tubular, flat or circular cross-sections). It covers the following resistance welding processes, as defined in ISO 4063:2023:

- 24 – flash welding, using direct current or alternating current with various movement sequences, constant flashing and pulsed flashing;
- 25 – resistance butt welding (upset welding), using direct current or alternating current with various current and pressure sequences.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 669, *Resistance welding — Resistance welding equipment — Mechanical and electrical requirements*

ISO 4136, *Destructive tests on welds in metallic materials — Transverse tensile test*

ISO 5173, *Destructive tests on welds in metallic materials — Bend tests*

ISO 6520-2, *Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 2: Welding with pressure*

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

ISO 9015-2, *Destructive tests on welds in metallic materials — Hardness testing — Part 2: Microhardness testing of welded joints*

ISO 11666, *Non-destructive testing of welds — Ultrasonic testing — Acceptance levels*

ISO 14732, *Welding personnel — Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials*

ISO 15607:2019, *Specification and qualification of welding procedures for metallic materials — General rules*

ISO 15609-5, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 5: Resistance welding*

ISO 15620:2019, *Welding — Friction welding of metallic materials*

ISO 17639, *Destructive tests on welds in metallic materials — Macroscopic and microscopic examination of welds*

ISO 17640, *Non-destructive testing of welds — Ultrasonic testing — Techniques, testing levels, and assessment*

ISO 23277, *Non-destructive testing of welds — Penetrant testing — Acceptance levels*

ISO 23279, *Non-destructive testing of welds — Ultrasonic testing — Characterization of discontinuities in welds*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 669, ISO 6520-2 and ISO 15607 apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

4 Preliminary welding procedure specification

The pWPS shall be prepared in accordance with ISO 15609-5. It shall specify all relevant parameters and requirements.

5 Welding procedure test

The welding and testing of test pieces shall be in accordance with [Clauses 6](#) and [7](#).

Any weld setter for resistance welding who satisfactorily undertakes the welding procedure test in accordance with this document shall be qualified for the appropriate range of qualification given in ISO 14732.

6 Test pieces and test specimens

6.1 General

The welded assembly tested shall be the actual component used in production. Test specimens shall be cut from the actual component.

If not possible, comparable welds shall be performed on test specimens according to references included in [6.2](#).