This document is a preview generated by EVS

Resistance spot welding and projection welds - Destructive testing of welds - Specimen dimensions and procedure for impact shear test and cross-tension testing

Resistance spot welding and projection welds - Destructive testing of welds - Specimen dimensions and procedure for impact shear test and cross-tension testing

EESTI STANDARDI EESSÕNA **NATIONAL FOREWORD**

Käesolev Eesti standard EVS-EN ISO 14323:2006 sisaldab Euroopa standardi EN ISO 14323:2006 ingliskeelset teksti. Käesolev dokument on jõustatud 29.06.2006 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN ISO 14323:2006 consists of the English text of the European standard EN ISO 14323:2006. This document is endorsed on 29.06.2006 with the notification being published in the official publication of the Estonian national standardisation organisation. The standard is available from Estonian standardisation organisation.

Käsitlusala: This International Standard covers destructive testing of welds. This International Standard specifies specimen dimensions and testing procedures for impact shear and cross-tension testing of resistance spot and embossed projection welds in overlapping sheets, in any metallic material of thickness 0,5 mm to 4 mm.	**Scope:** This International Standard covers destructive testing of welds. This International Standard specifies specimen dimensions and testing procedures for impact shear and cross-tension testing of resistance spot and embossed projection welds in overlapping sheets, in any metallic material of thickness 0,5 mm to 4 mm.

ICS 25.160.40

Võtmesõnad:

The document is a preview generated by EVS

Standardite reprodutseerimis- ja levitamisõigus kuulub Eesti Standardikeskusele

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 14323

May 2006

ICS 25.160.40

English Version

Resistance spot welding and projection welds - Destructive testing of welds - Specimen dimensions and procedure for impact shear test and cross-tension testing (ISO 14323:2006)

Soudage par résistance par points et par bossages - Essais destructifs des soudures - Dimensions des éprouvettes et procédure d'essai de cisaillement par choc et d'essai de traction par choc sur éprouvettes en croix (ISO 14323:2006)

Widerstandspunkt- und Buckelschweißen - Zerstörende Prüfung von Schweißverbindungen - Probenabmessungen und Durchführung des Schlagscherzugversuchs und des Schlagkopfzugversuchs (ISO 14323:2006)

This European Standard was approved by CEN on 9 March 2006.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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

Management Centre: rue de Stassart, 36 B-1050 Brussels

© 2006 CEN All rights of exploitation in any form and by any means reserved worldwide for CEN national Members.

Ref. No. EN ISO 14323:2006: E

This document is a preview generated by EVS

Foreword

This document (EN ISO 14323:2006) has been prepared by Technical Committee IIW "International Institute of Welding" in collaboration with Technical Committee CEN/TC 121 "Welding", 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 November 2006, and conflicting national standards shall be withdrawn at the latest by November 2006.

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

Endorsement notice

The text of ISO 14323:2006 has been approved by CEN as EN ISO 14323:2006 without any modifications.

This document is a preview generated by EVS

INTERNATIONAL STANDARD

ISO 14323

First edition
2006-05-01

Resistance spot welding and projection welds — Destructive testing of welds — Specimen dimensions and procedure for impact shear test and cross-tension testing

Soudage par résistance par points et par bossages — Essais destructifs des soudures — Dimensions des éprouvettes et procédure d'essai de cisaillement par choc et d'essai de traction par choc sur éprouvettes en croix

This document is a preview generated by EVS

Reference number
ISO 14323:2006(E)

© ISO 2006

PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

This document is a preview generated by EVS

© ISO 2006

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

 © ISO 2006 – All rights reserved

Contents

Page

This document is a preview generated by EVS

© ISO 2006 – All rights reserved

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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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

ISO 14323 was prepared by the International Institute of Welding, recognized as an international standardizing body in the field of welding in accordance with Council Resolution 42/1999.

This document is a preview generated by EVS

© ISO 2006 – All rights reserved

Introduction

Requests for official interpretations of provisions in this standard should be made in writing and sent to the ISO Central Secretariat who will forward them to the IIW Secretariat for an official response.

This document is a preview generated by EVS

© ISO 2006 – All rights reserved

Resistance spot welding and projection welds — Destructive testing of welds — Specimen dimensions and procedure for impact shear test and cross-tension testing

This document is a preview generated by EVS

1 Scope

This International Standard covers destructive testing of welds.

This International Standard specifies specimen dimensions and testing procedures for impact shear and cross-tension testing of resistance spot and embossed projection welds in overlapping sheets, in any metallic material of thickness 0,5 mm to 4 mm.

2 Normative references

The following referenced documents are indispensable for the application 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 14272, *Specimen dimensions and procedure for cross tension testing resistance spot and embossed projection welds*

ISO 14329, *Resistance welding — Destructive tests of welds — Failure types and geometric measurements for resistance spot, seam and projection welds*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 669 and ISO 14329 and the following apply.

3.1
corona bond
area of the weld at the faying surfaces in which solid-phase bonding has occurred

3.2
impact cross-tension failure energy
failure energy measured in the impact cross-tension test

3.3
impact cross-tension force
maximum force measured in the impact cross-tension test

3.4
impact shear failure energy
failure energy measured in the impact shear test

© ISO 2006 – All rights reserved