

**Specification and qualification of welding
procedures for metallic materials - Welding
procedure test - Part 13: Resistance butt
and flash welding**

Specification and qualification of welding procedures
for metallic materials - Welding procedure test - Part
13: Resistance butt and flash welding

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 15614-13:2005 sisaldab Euroopa standardi EN ISO 15614-13:2005 ingliskeelset teksti. Käesolev dokument on jõustatud 28.04.2005 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN ISO 15614-13:2005 consists of the English text of the European standard EN ISO 15614-13:2005. This document is endorsed on 28.04.2005 with the notification being published in the official publication of the Estonian national standardisation organisation. The standard is available from Estonian standardisation organisation.
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Käsitlusala: This part of ISO 15614 specifies the tests which should be used for qualification of welding procedure specifications. It applies to resistance butt welding and flash welding of metallic materials, e.g. with solid, tubular, flat or circular cross-section. The basic principles of this part of ISO 15614 may be applied to other resistance welding processes when this is specified in the specification.	Scope: This part of ISO 15614 specifies the tests which should be used for qualification of welding procedure specifications. It applies to resistance butt welding and flash welding of metallic materials, e.g. with solid, tubular, flat or circular cross-section. The basic principles of this part of ISO 15614 may be applied to other resistance welding processes when this is specified in the specification.
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ICS 25.160.10

English version

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 13: Resistance butt and flash welding (ISO 15614-13:2005)

Descriptif et qualification d'un mode opératoire de soudage pour les matériaux métalliques - Epreuve de qualification d'un mode opératoire de soudage - Partie 13: Soudage en bout par résistance pure et soudage par étincelage (ISO 15614-13:2005)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 13: Pressstumpf- und Abbrennstumpfschweißen (ISO 15614-13:2005)

This European Standard was approved by CEN on 3 February 2005.

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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.

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EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (EN ISO 15614-13:2005) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DIN, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

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 August 2005, and conflicting national standards shall be withdrawn at the latest by August 2005.

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, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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

**Part 13:
Resistance butt and flash welding**

*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*



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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.

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 15614-13 was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding*, in collaboration with Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Unification of requirements in the field of metal welding*, in accordance with the Agreement on Technical cooperation between ISO and CEN (Vienna Agreement).

ISO 15614 consists of the following parts, under the general title *Specification and qualification of welding procedures for metallic materials — Welding procedure test*:

- *Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys*
- *Part 2: Arc welding of aluminium and its alloys*
- *Part 3: Arc welding of cast iron*
- *Part 4: Finishing welding of aluminium castings*
- *Part 5: Arc welding of titanium, zirconium and their alloys*
- *Part 6: Arc welding of copper and its alloys*
- *Part 7: Overlay welding*
- *Part 8: Welding of tubes to tube-plate joints*
- *Part 9: Arc underwater hyperbaric wet welding*
- *Part 10: Hyperbaric dry welding:*
- *Part 11: Electron and laser beam welding*
- *Part 12: Spot, seam and projection welding*
- *Part 13: Resistance butt and flash welding*

For the purposes of this part of ISO 15614, the CEN annex regarding fulfilment of European Council Directives has been removed.

Introduction

All new welding procedure qualifications are to be carried out in accordance with this part of ISO 15614 from the date of its issue.

However, this part of ISO 15614 does not invalidate previous welding procedure qualifications made to standards or specifications, provided the intent of the 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.

Also, where additional tests have to be carried out to make the qualification technically equivalent, it is only necessary to do the additional tests on a test piece which should be made in accordance with this part of ISO 15614.

Requests for official interpretations of any aspect of this part of ISO 15614 should be directed to the Secretariat of ISO/TC 44/SC 10 via the national standards body, a complete listing of which can be found at www.iso.org.

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

Part 13: Resistance butt and flash welding

1 Scope

This part of ISO 15614 specifies the tests which should be used for qualification of welding procedure specifications.

It applies to resistance butt welding and flash welding of metallic materials, e.g. with solid, tubular, flat or circular cross-section. The basic principles of this part of ISO 15614 may be applied to other resistance welding processes when this is specified in the specification.

NOTE This part of ISO 15614 is a part of a series of standards. Details of this series are given in ISO 15607:2003, Annex A.

This part of ISO 15614 defines the conditions for carrying out tests and the limits of validity of a qualified welding procedure for all practical welding operations covered by this part of ISO 15614.

The tests required to qualify the procedure for a particular component/assembly depend on the performance and quality requirements of the component/assembly and should be defined in the design specification.

The tests should be carried out in accordance with this part of ISO 15614, unless more severe tests are specified by the relevant application standard or specification, when these apply.

NOTE Specific service, material, or manufacturing conditions may require more comprehensive testing than is specified by this part of ISO 15614.

Such tests may include:

- microsections;
- fatigue or endurance tests;
- impact test;
- radiographic test;
- ultrasonic test;
- corrosion test;
- tests of components or complete welded assemblies.

This part of ISO 15614 covers the following resistance welding processes as defined in ISO 4063:

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

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.

EN 1289, *Non-destructive examination of welds — Penetrant testing of welds — Acceptance levels*

EN 1291, *Non-destructive examination of welds — Magnetic particle testing of welds — Acceptance levels*

EN 1418, *Welding personnel — Approval testing of welding operators for fusion welding and resistance weld setters for fully mechanized and automatic welding of metallic materials*

EN 1711, *Non-destructive examination of welds — Eddy current examination of welds by complex plane analysis*

EN 1712, *Non-destructive examination of welds — Ultrasonic examination of welded joints — Acceptance levels*

EN 1713, *Non-destructive examination of welds — Ultrasonic examination — Characterization of indications in welds*

ISO 4063, *Welding and allied processes — Nomenclature of processes and reference numbers*

ISO 4136¹⁾, *Destructive tests on welds in metallic materials — Transverse tensile test*

ISO 5173²⁾, *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 9015-1³⁾, *Destructive tests on welds in metallic materials — Hardness testing — Part 1: Hardness test on arc welded joints*

ISO 9015-2⁴⁾, *Destructive tests on welds in metallic materials — Hardness testing — Part 2: Microhardness testing of welded joints*

EN 10002-1, *Metallic materials — Tensile testing — Part 1: Method of test at ambient temperature*

ISO 14271, *Vickers hardness testing of resistance spot, projection and seam welds (low load and microhardness)*

ISO 15607:2003, *Specification and qualification of welding procedures for metallic materials — General rules*

ISO/TR 15608:2000, *Welding — Guidelines for a metallic materials grouping system*

1) Standard equivalent to EN 895.

2) Standard equivalent to EN 910.

3) Standard equivalent to EN 1043-1.

4) Standard equivalent to EN 1043-2.

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

ISO 15620:2000, *Welding — Friction welding of metallic materials*

ISO 17637⁵⁾, *Non-destructive testing of welds — Visual testing of fusion-welded joints*

ISO 17638⁶⁾, *Non-destructive testing of welds — Magnetic particle testing*

ISO 17639⁷⁾, *Destructive tests on welds in metallic materials — Macroscopic and microscopic examination of welds*

ISO 17640⁸⁾, *Non-destructive examination of welds — Ultrasonic examination of welded joints*

ISO 20482, *Metallic materials — Sheet and strip — Erichsen cupping test*

3 Terms and definitions

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

4 Preliminary welding procedure specification (pWPS)

The preliminary welding procedure specification shall be prepared in accordance with ISO 15609-5. It shall specify all relevant parameters and requirements.

5 Welding procedure test

The manufacturing and testing of components and/or test pieces representing the type of welding used in production shall be in accordance with Clauses 6 and 7.

The resistance-weld setter, who undertakes the welding procedure test satisfactorily in accordance to this part of ISO 14614, shall be qualified for the appropriate range of qualification given in EN 1418.

6 Test piece and test specimen

6.1 General

The welded assembly, to which the welding process will relate in production, shall be represented by actual components or by manufacturing a standardized test piece, according to 6.2.

Test specimens shall be cut from actual components; the test pieces are welded separately according to 6.2. In some cases, e.g. small solid bars or small tubes, the work piece will be tested directly.

5) Standard equivalent to EN 970.

6) Standard equivalent to EN 12903.

7) Standard equivalent to EN 1321.

8) Standard equivalent to EN 1714.