
**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*



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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 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.

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Introduction

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

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