



SLOVENSKI STANDARD SIST EN ISO 18592:2010

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Uporovno varjenje - Porušitveno preskušanje zvarnih spojev - Metoda preskušanja trdnosti večtočkovno varjenih vzorcev (ISO 18592:2009)

Resistance welding - Destructive testing of welds - Method for the fatigue testing of multi-spot-welded specimens (ISO 18592:2009)

Widerstandsschweißen - Zerstörende Prüfung von Schweißverbindungen - Verfahren zur Schwingfestigkeitsprüfung von geschweißten Mehrpunktproben (ISO 18592:2009)

Soudage par résistance - Essais destructifs des soudures - Méthode d'essai de fatigue des échantillons soudés par points multiples (ISO 18592:2009)

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Ta slovenski standard je istoveten z: EN ISO 18592:2009

ICS:

25.160.40 Varjeni spoji in vari Welded joints

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EUROPEAN STANDARD

EN ISO 18592

NORME EUROPÉENNE

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December 2009

ICS 25.160.40

English Version

Resistance welding - Destructive testing of welds - Method for the fatigue testing of multi-spot-welded specimens (ISO 18592:2009)

Soudage par résistance - Essais destructifs des soudures -
Méthode d'essai de fatigue des échantillons soudés par
points multiples (ISO 18592:2009)

Widerstandsschweißen - Zerstörende Prüfung von
Schweißverbindungen - Verfahren zur
Schwingfestigkeitsprüfung von geschweißten
Mehrpunktproben (ISO 18592:2009)

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Contents

Page

Foreword.....3

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Foreword

This document (EN ISO 18592:2009) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" 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of an identical text or by endorsement, at the latest by June 2010, and conflicting national standards shall be withdrawn at the latest by June 2010.

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INTERNATIONAL STANDARD

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Resistance welding — Destructive testing of welds — Method for the fatigue testing of multi-spot-welded specimens

*Soudage par résistance — Essais destructifs des soudures — Méthode
d'essai de fatigue des échantillons soudés par points multiples*

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Contents

Page

Foreword	iv
Introduction.....	v
1 Scope	1
2 Normative references	2
3 Terms and definitions	3
4 Symbols and abbreviated terms	5
5 Specimens	7
5.1 General	7
5.2 Selection of suitable specimens	8
5.3 Specimen fabrication	10
5.4 Specimen geometry	11
6 Requirements for testing machine	21
7 Specimen grips and alignment	22
7.1 General	22
7.2 Shear and peel loading	23
8 Test procedure	24
8.1 General	24
8.2 Mounting the H-specimens	24
8.3 Clamping procedure for the H-specimens	24
8.4 Fatigue test	24
8.5 Test termination	25
9 Test report	27
9.1 Basic information	27
9.2 Presentation of fatigue test results	28
Annex A (informative) Calibration specimen for verifying the load distribution in H-specimens	30
Annex B (informative) Hydraulic grips for the fatigue testing of H-specimens	31
Annex C (informative) Grip for the fatigue testing of H-specimens	32
Annex D (informative) Flow chart — Data acquisition	33
Bibliography	36

ISO 18592:2009(E)

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.

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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 18592 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 6, *Resistance welding and allied mechanical joining*.

Requests for official interpretations of any aspect of this International Standard should be directed to the Secretariat of ISO/TC 44/SC 6 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

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Introduction

This International Standard has been prepared because welding engineers (and most design engineers) are not familiar with fatigue testing and the influence of factors such as load type (e.g. shear load, peel load), and failure criteria.

Tests are used to investigate the existence of specific properties and their qualitative and quantitative evaluation. Fatigue tests, in general, are used to investigate the behaviour of structures and components subjected to cyclic loads. For welded components, fatigue tests are used to determine the influence of different parameters such as joining methods, pitch, material thickness and material combinations type of load (e.g. shear load, peel load), overlap, location of weld on flange, edge distance, loading condition (e.g. quasi-static, cyclic, load ratio R), and the combination of environment and corrosion on the fatigue behaviour (life) of spot welds and/or specimens subjected to various types of loads. Fatigue tests should, if their results are to be used for design purposes, as far as possible, take into consideration such boundary conditions as encountered in a real life environment. This applies to load types, load amplitudes, and load ratios as well as load distributions and failure criteria (Reference [7]).

The test specimen selected for the fatigue test should simulate, as closely as possible, the loads and the boundary conditions as they are encountered in service. Furthermore, the failure criterion used should conform to the application in hand. Although the type of primary load is identical in some specimens, e.g. shear load in flat multi-spot specimens, shear H-specimens, KS-2 specimens, and double disc specimens, the results of fatigue tests differ significantly because of the secondary load types resulting from varying degrees of local deformation due to the differences in the local stiffness in the area of the joints. The local deformation, responsible for the magnitude of the peel component, for example, is a function of the local stiffness, increasing with a decrease in stiffness.

SIST EN ISO 18592:2010

This International Standard offers a framework within which the different specimens, described herein, can be modified such that design specifics and production constraints, e.g. flange width and overlap, weld nugget size, pitch, bending radius, and sub-standard welds, can be given due consideration. This helps towards enhancing the significance of the results very appreciably.

Note that if welds could be subjected to identical amplitudes of shear and peel loads, their lives would differ by a factor of approximately 10^4 (References [8] to [11]). This explains the necessity to use different specimens for the simulation of different load types.

Conformance tests on *real* components serve the verification of design calculations and are necessary for the qualification of structures. It is therefore necessary to maintain their number at an absolute minimum.

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Resistance welding — Destructive testing of welds — Method for the fatigue testing of multi-spot-welded specimens

1 Scope

This International Standard specifies test specimens and procedures for performing constant load amplitude fatigue tests on multi-spot-welded and multi-axial specimens in the thickness range from 0,5 mm to 5 mm at room temperature and a relative humidity of max. 80 %. The applicability of this International Standard to larger thicknesses can be limited by mechanical properties such as yield strength and formability of the specimen material. The thickness range for advanced high strength steels (AHSS) is generally below 3,0 mm. Greater thicknesses apply for aluminium alloys, for example.

Depending on the specimen used, it is possible from the results to evaluate the fatigue behaviour of:

- a) spot welds subjected to defined uniform load distribution;
- b) spot welds subjected to defined non-uniform load distribution;
- c) spot welds subjected to different defined combinations of shear-, peel- and normal-tension loads; and
- d) the tested specimen.

SIST EN ISO 18592:2010

Multi-spot specimens with which the different load distributions can be realized are:

- 1) defined uniform load distribution:
 - i) H-specimens for shear- and peel-loading, (welds subjected to uniform shear or peel loading transverse to the joint line),
 - ii) single- and double-hat specimens subjected to four-point bending (spot welds subjected to uniform shear load in the direction of the row of welds),
 - iii) double-disc specimen under torsion (spot welds subjected to uniform shear load),
 - iv) double-disc specimen under tensile load (spot welds subjected to uniform peel load),
 - v) double-disc specimen under combined torsion and tensile loading,
 - vi) flat multi-spot specimens using defined grips;
- 2) defined non-uniform load distribution:
 - i) H-specimens with modified grips,
 - ii) modified H-specimens with standard grips,
 - iii) modified H-specimens with modified grips,