

SLOVENSKI STANDARD

SIST EN ISO 16432:2007

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Resistance welding - Procedure for projection welding of uncoated and coated low carbon steels using embossed projection(s) (ISO 16432:2006)

Widerstandsschweißen - Verfahren zum Buckelschweißen von niedriglegierten Stählen mit oder ohne metallischem Überzug (ISO 16432:2006)

Soudage par résistance - Mode opératoire de soudage par bossage(s) embouti(s) des aciers a bas carbone revetus et non revetus (ISO 16432:2006)

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Ta slovenski standard je istoveten z: **EN ISO 16432:2007**

ICS:

25.160.10 Varilni postopki in varjenje Welding processes

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English Version

Resistance welding - Procedure for projection welding of
uncoated and coated low carbon steels using embossed
projection(s) (ISO 16432:2006)

Soudage par résistance - Mode opératoire de soudage par
bossage(s) embouti(s) des aciers à bas carbone revêtus et
non revêtus (ISO 16432:2006)

Widerstandsschweißen - Verfahren zum Buckelschweißen
von niedriglegierten Stählen mit oder ohne metallischem
Überzug (ISO 16432:2006)

This European Standard was approved by CEN on 19 May 2007.

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 CEN Management Centre 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 CEN Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, 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.

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

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

Foreword

The text of ISO 16432:2006 has been prepared by IIW, International Institute of Welding, and has been taken over as EN ISO 16432:2007 by 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 December 2007, and conflicting national standards shall be withdrawn at the latest by December 2007.

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, 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 16432:2006 has been approved by CEN as a EN ISO 16432:2007 without any modification.

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**Resistance welding — Procedure for
projection welding of uncoated and
coated low carbon steels using
embossed projection(s)**

*Soudage par résistance — Procédure pour le soudage par bossage(s)
embouti(s) des aciers à bas carbone revêtus et non revêtus*

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Reference number
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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 16432 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

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.

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Resistance welding — Procedure for projection welding of uncoated and coated low carbon steels using embossed projection(s)

1 Scope

This International Standard specifies requirements for embossed-resistance-projection welding in the fabrication of assemblies of uncoated and metallic coated low carbon steel comprising two thicknesses of metal, where the maximum single sheet thickness of components to be welded is within the range 0,4 mm to 3 mm for the following materials:

- uncoated steels;
- hot-dip zinc or iron-zinc alloy (galvannealed) coated steel;
- electrolytic zinc, zinc-iron, or zinc-nickel coated steel;
- aluminium coated steel;
- zinc-aluminium coated steel.

Organic-coated or primer-coated steels are not covered by this International Standard. Guidelines for appropriate welding equipment and projection welding conditions for various coated steels are given in Annexes A to C. These are for guidance only and may need to be adapted to suit the specified service conditions of the fabrication, prevailing production conditions, type of welding equipment, mechanical and electrical characteristics of the welding machine, electrode configuration, and material. These requirements shall be taken from the relevant welding procedure specification for the application or procedure, where these exist.

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 5182:1991, *Welding — Materials for resistance welding electrodes and ancillary equipment*

ISO 8167, *Projections for resistance welding*

ISO 10447, *Welding — Peel and chisel testing of resistance spot, projection and seam welds*

ISO 14270, *Specimen dimensions and procedure for mechanized peel testing resistance spot, seam and embossed projection welds*

ISO 14272, *Specimen dimensions and procedure for cross tension testing resistance spot and embossed projection welds*