



SLOVENSKI STANDARD
oSIST prEN ISO 15614-13:2011
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Popis in kvalifikacija varilnih postopkov za kovinske materiale - Preskus varilnega postopka - 13. del: Uporovno sočelno in obžigalno varjenje (ISO/DIS 15614-13:2010)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 13: Resistance butt (upset) and flash welding (ISO/DIS 15614-13:2010)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 13: Pressstumpf- und Abbrennstumpfschweißen (ISO/DIS 15614-13:2010)

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 (ISO/DIS 15614-13:2010)

Ta slovenski standard je istoveten z: prEN ISO 15614-13

ICS:

25.160.10 Varilni postopki in varjenje Welding processes

oSIST prEN ISO 15614-13:2011

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English Version

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 13: Resistance butt (upset) and flash welding (ISO/DIS 15614-13:2010)

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 (ISO/DIS 15614-13:2010)

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This draft European Standard is submitted to CEN members for parallel enquiry. It has been drawn up by the Technical Committee CEN/TC 121.

If this draft becomes a European Standard, 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.

This draft European Standard was established by CEN 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-CENELEC Management Centre has the same status as the official versions.

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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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

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Foreword

This document (prEN ISO 15614-13:2010) 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 document is currently submitted to the parallel Enquiry.

This document will supersede EN ISO 15614-13:2005.

Endorsement notice

The text of ISO/DIS 15614-13:2010 has been approved by CEN as a prEN ISO 15614-13:2010 without any modification.

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DRAFT INTERNATIONAL STANDARD ISO/DIS 15614-13

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

Part 13:

Resistance butt (upset) 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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[Revision of first edition (ISO 15614-13:2005)]

ICS 25.160.10

SIST EN ISO 15614-13:2012

ISO/CEN PARALLEL PROCESSING

This draft has been developed within the International Organization for Standardization (ISO), and processed under the **ISO-lead** mode of collaboration as defined in the Vienna Agreement.

This draft is hereby submitted to the ISO member bodies and to the CEN member bodies for a parallel five-month enquiry.

Should this draft be accepted, a final draft, established on the basis of comments received, will be submitted to a parallel two-month approval vote in ISO and formal vote in CEN.

To expedite distribution, this document is circulated as received from the committee secretariat. ISO Central Secretariat work of editing and text composition will be undertaken at publication stage.

Pour accélérer la distribution, le présent document est distribué tel qu'il est parvenu du secrétariat du comité. Le travail de rédaction et de composition de texte sera effectué au Secrétariat central de l'ISO au stade de publication.

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ISO/DIS 15614-13

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ISO/DIS 15614-13**Foreword**

This second edition cancels and replaces the first edition (2005), which has been technically revised.

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

This second edition cancels and replaces the first edition (ISO 15614-13:2005) which has been technically revised.

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: Upset (resistance butt) and flash welding*

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.

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