



SLOVENSKI STANDARD SIST EN ISO 14323:2006

01-oktober-2006

Resistance spot welding and projection welds - Destructive testing of welds - Specimen dimensions and procedure for impact shear test and cross-tension testing (ISO 14323:2006)

Resistance spot welding and projection welds - Destructive testing of welds - Specimen dimensions and procedure for impact shear test and cross-tension testing (ISO 14323:2006)

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Widerstandspunkt- und Buckelschweißen - Zerstörende Prüfung von Schweißverbindungen - Probenabmessungen und Durchführung des Schlagscherzugversuchs und des Schlagkopfzugversuchs (ISO 14323:2006)

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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 (ISO 14323:2006)

Ta slovenski standard je istoveten z: EN ISO 14323:2006

ICS:

25.160.40 Varjeni spoji in vari Welded joints

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 14323

May 2006

ICS 25.160.40

English Version

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

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EN ISO 14323:2006 (E)**Foreword**

This document (EN ISO 14323:2006) has been prepared by Technical Committee IIW "International Institute of Welding" 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of an identical text or by endorsement, at the latest by November 2006, and conflicting national standards shall be withdrawn at the latest by November 2006.

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

Endorsement notice

The text of ISO 14323:2006 has been approved by CEN as EN ISO 14323:2006 without any modifications.

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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**

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*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

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 IIV Secretariat for an official response.

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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*

[SIST EN ISO 14323:2006](http://standards.iteh.ai/catalog/standards/sist/14323-2006)

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

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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