

**SLOVENSKI STANDARD**  
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**Lasersko varjeni specialni spoji - Tehnični dobavni pogoji**

Laser welded tailored blanks - Technical delivery conditions

Laserstrahlgeschweißte Tailored Blanks aus Stahlfeinblech - Technische Lieferbedingungen

Flans raboutés laser - Conditions techniques de livraison

**Ta slovenski standard je istoveten z: prEN 10359**

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25.160.40	Varjeni spoji in vari	Welded joints
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## Laser welded tailored blanks - Technical delivery conditions

Flans rabotés laser - Conditions techniques de livraison

Laserstrahlgeschweißte Tailored Blanks aus Stahlfeinblech  
- Technische Lieferbedingungen

This draft European Standard is submitted to ECISS/COCOR before submission to CEN members for formal vote. It has been drawn up by the Technical Committee ECISS/TC 109.

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

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## Foreword

This document (prEN 10359:2014) has been prepared by Technical Committee ECISS/TC 109 “Coated and uncoated flat products to be used for cold forming”, the secretariat of which is held by AFNOR.

This document is currently submitted to the COCOR Vote.

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## 1 Scope

This technical delivery condition describes the requirements for laser welded tailored blanks made of alloyed and unalloyed steels, of uniform or different steel grades and with or without metallic and/or organic coatings, having uniform or different sheet thickness. It applies only to the (Tailored Blanks) as-supplied condition of tailored blanks.

After the welding process, tailored blanks are further processed to pressed parts by forming operations under the responsibility of the processor. In the design of the component due consideration must be given to the fact that the weld seam is less formable in comparison to the base material.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2768-1, *General tolerances; Tolerances for linear and angular dimensions without individual tolerance indications*.

EN 10131, *Cold rolled uncoated low carbon and high yield strength steel flat products for cold forming; tolerances on dimensions and shape*.

EN 10143, *Continuously hot-dip metal coated steel sheets and strip; tolerances on dimensions and shape*.

## 3 Terms and definitions

For the purposes of this document, the following term and definition applies:

### 3.1

#### tailored blanks

laser welded metal sheets of uniform and/or different thickness and/or uniform or different steel grades, both with and without surface coating.

## 4 Requirements

As far as the properties of the components are concerned, the general rules of engineering apply. The suitability of tailored blanks for the processes of the customer is guaranteed in case of appropriate execution of the welding seam, suitable positioning of weld seam in the part to be formed and appropriate lay out of sheet thicknesses and steel grades under taking into consideration the requirements of known further processing steps. The criteria laid down in table 1 have proved to be a practical basis for ordering. Additional specific deviations are admissible and have to be agreed upon at the time of ordering.

## 5 Tolerances on dimensions and shape

Regarding tolerances on dimensions and shape the agreements of EN 10131 and EN 10143 shall apply for cold rolled and surface coated wide coils, cut to length sheets and slit coils, which are used for the manufacturing tailored blanks.

The relevant tolerance classes for width, flatness and thickness have to be agreed upon between producer of tailored blank and steel producer.

For the general tolerances regarding lengths, angles, coaxiality and symmetry, the precision class c according to ISO 2768-1 shall apply.

If not all edges of the blank were cut, the definition of the dimension has to be according to EN 10143 and EN 10131 also.

Specific requirement and other beyond that valid special customer agreement have to be agreed upon between producer of tailored blank / steel producer and customer.

## **6 Destructive testing of weld joints**

### **6.1 Cup test**

Destructive testing of weld joints with cup test is considered as best practice procedure.

The evaluation of weld quality is done according to the pictures in Table 2.

Frequency of the cup test is minimum once a run.

### **6.2 Cross section**

Samples must be taken minimum 5 mm from both ends of welds. For measurements Table 3 apply.

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Table 1 — Requirements

Dimensions, surface			
Criterion	Figures	Assessment	Frequency
Shape inspection (Tolerance)	–	Tolerances for linear and angular dimensions without individual tolerance indications according ISO 2768 part 1 / class c, EN 10143, EN 10131 or customer specification	
Shape inspection (Method of measurement)	–	Master sample (Initial sample): Reference points have to be agreed with the customer. Production: measuring of the influential dimensions.	Initial parts or master sample for PSW <sup>a</sup> Production sample each run
Flatness of the entire blank	Fig. 1	Deviation h guaranteed acc. to EN 10131 and 10143. Furthermore the “process ability” criterion shall apply. Tighter specification should be agreed between customer and supplier.	Initial parts or master sample for PSW <sup>a</sup> . Production samples each run. Visual.
Burr of the entire laser welded blank	–	Customer specification.	Production samples each run. Visual.
Surface quality of laser welded blanks	–	According to relevant technical delivery conditions for flat products.	Production samples each run. Visual.
Oiling of tailored blanks	–	The entire blank must be free from corrosion products. Oil type and amount of oil at time of steel strip production acc. to customer specification. More than 1.5 g/m <sup>2</sup> is not state of the art due to process ability	Initial parts or master sample for PSW <sup>a</sup> . Visual each run.
Offset of sheets	Fig.13	maximal Offset $\pm 1,5$ mm	Initial parts or master sample for PSW <sup>a</sup> . Production sample one each run.
Requirements on weld seam			
Criterion	Figures	Assessment	Frequency
Cracks / Pores / Inclusions / Craters / Lack of fusion	–	Pores, Inclusions: Maximum size of imperfection $\leq 0.3 \times t_2$ Pore nests: $f \leq 0.7$ %. No cracks, craters or lack of fusion are allowed. $f$ = surface of pores measured over a length of 100 mm along the weld (parallel cross section)	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.
Hardness in the area of the weld and HAZ	–	Hardness depends on the defined steel grades.	Initial parts or master sample for PSW (If required).
<sup>a</sup> PSW = Part Submission Warrant			



Table 1 (continued)

Criterion	Figures	Assessment	Frequency
Spatter	–	Scale and smoke residues as well as welding spatter must not negatively affect the processability nor the downstream processes	Initial parts or master sample for PSW. Production samples each run.
Burning of zinc coating (total)	–	The maximum width of the entire zinc-free zone is 3 mm for $t_1 \leq 2$ mm, and $1 + t_1$ for $t > 2$ mm	Customer specification
Undercut (Definition: un-fused edge that reduces the carrying cross section)	Fig. 2	$t_2 \leq 1$ mm: $h \leq 0.1$ mm; $t_2 > 1$ mm: $h \leq 0.1 \times t_2$	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.
Excess weld metal	Fig. 3	$t_2 \leq 1$ mm: $h \leq 0.1$ mm; $t_2 > 1$ mm: $h \leq 0.1 \times t_2$	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.
Excessive root penetration	Fig. 4	$t_2 \leq 1$ mm: $h \leq 0.1$ mm, $t_2 > 1$ mm: $h \leq 0.1 \times t_2$	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.
Upper weld concavity	Fig. 5	$t_2 \leq 1$ mm: $h \leq 0.1$ mm, $t_2 > 1$ mm: $h \leq 0.1 \times t_2$	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.
Root concavity	Fig. 6	$t_2 \leq 1$ mm: $h \leq 0.1$ mm, $t_2 > 1$ mm: $h \leq 0.1 \times t_2$	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.
Weld sagging	Fig. 7	$t_2 \leq 1$ mm: $h \leq 0.1$ mm, $t_2 > 1$ mm: $h \leq 0.1 \times t_2$	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.
Mismatch	Fig. 8 and 9	negative mismatch: $t_2 \leq 1$ mm: $h \leq 0.1$ mm, $t_2 > 1$ mm: $h \leq 0.1 \times t_2$  positive mismatch: $t_2 \leq 1$ mm: $h \leq 0.2$ mm, $t_2 > 1$ mm: $h \leq 0.2 \times t_2$  Furthermore the processability criterion shall apply.	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.
Weld cross section	Fig. 10	The remaining cross section due to weld defects (Undercut, Root concavity, Upper weld concavity, negative mismatch) should not be smaller than : $t_2 \leq 1$ mm: $g \geq 0.80 \times t_2$ $t_2 > 1$ mm: $g \geq 0.80 \times t_2$	
Beginning/end of weld	Fig. 12	At the beginning and end of the weld areas with a max. length of 2 mm each may occur where the laser beam is without effect. Furthermore the „processability“ criterion shall apply.	Production sample each run. Visual
Lack of penetration	Fig. 11	Lack of penetration is not allowed	Checked by on-line-systems. Additional minimum one destructive test (cross section) once a year.

Table 1 (continued)

Testing			
Criterion	Figures	Assessment	Frequency
Testing of weld seam (non-destructive)	Fig. 12	Each tailored blank is tested with appropriate and assured test procedures (online). Additional visual inspection is possible. Up to max. 5 mm at the beginning and end of the weld cannot be monitored by state-of-the-art online test procedures.	100% by online- system
Weld seam testing (mechanical and technological) for the series delivery	Table 2	Using assured test procedures with appropriate testing frequency (offline), e.g. the cup test	Once per run
Process assurance by traceability		Traceability from stack label back to the batch number of steel sheet or coil.	
Packaging			
Criterion	Figures	Assessment	Frequency
Packaging		As specified by the customer and complying with "stacking deviation" and "stacking height deflection" as defined below.	Each stack Visual
Stack deviation	Fig. 14	$h \leq 5.0$ mm provided that the palette has been designed adequately	Each stack
Stack height deflection (deflection of tailored blank on top)	Fig. 15 and 16	The height deviation $h$ of the dimpled blanks in the Stack shall be less than $\pm 30$ mm compared to the undimpled blank whenever it is technically feasible with regard to blank geometry and design of palette, Furthermore the "processability" criterion shall apply.	Each stack Visual
$t_1$ = Thickness of thicker sheet $t_2$ = Thickness of thinner sheet $h$ = Deviation in mm $f$ = Porosity projection fraction			