

**SLOVENSKI STANDARD  
SIST EN ISO 14271:2018**

**01-marec-2018**

**Nadomešča:**

**SIST EN ISO 14271:2011**

**SIST EN ISO 14271:2011/AC:2012**

---

**Uporovno varjenje - Preskušanje trdote po Vickersu (majhna obremenitev in mikro trdota) na uporovnih točkovnih, bradavičnih in kolutnih zvarih (ISO 14271:2017)**

Resistance welding - Vickers hardness testing (low-force and microhardness) of resistance spot, projection, and seam welds (ISO 14271:2017)

**iTeh STANDARD PREVIEW**

Widerstandsschweißen - Vickers-Härteprüfung (Kleinkraft- und Mikrohärtebereich) von Widerstandspunkt-, Buckel- und Rollennahtschweißverbindungen (ISO 14271:2017)

[SIST EN ISO 14271:2018](#)

Soudage par résistance - Essais de dureté Vickers (force réduite et microdureté) sur soudures par résistance par points, par bossages et à la molette (ISO 14271:2017)

**Ta slovenski standard je istoveten z: EN ISO 14271:2017**

---

**ICS:**

25.160.40      Varjeni spoji in vari      Welded joints and welds

**SIST EN ISO 14271:2018**

**en,fr,de**

**iTeh STANDARD PREVIEW  
(standards.iteh.ai)**

SIST EN ISO 14271:2018

<https://standards.iteh.ai/catalog/standards/sist/31216067-4f9a-457d-8f62-d095c3330e64/sist-en-iso-14271-2018>

**EUROPEAN STANDARD**  
**NORME EUROPÉENNE**  
**EUROPÄISCHE NORM**

**EN ISO 14271**

September 2017

ICS 25.160.40

Supersedes EN ISO 14271:2011

English Version

**Resistance welding - Vickers hardness testing (low-force and microhardness) of resistance spot, projection, and seam welds (ISO 14271:2017)**

Soudage par résistance - Essais de dureté Vickers (force réduite et microdureté) sur soudures par résistance par points, par bossages et à la molette (ISO 14271:2017)

Widerstandsschweißen - Vickers-Härteprüfung (Kleinkraft- und Mikrohärtebereich) von Widerstandspunkt-, Buckel- und Rollennahtschweißverbindungen (ISO 14271:2017)

This European Standard was approved by CEN on 26 September 2017.

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-CENELEC Management Centre or to any CEN member.

**The STANDARD PREVIEW  
(standards itch.ai)**

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-CENELEC Management Centre has the same status as the official versions.

[SIST EN ISO 14271:2018](#)

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

**Contents**

	Page
<b>European foreword.....</b>	<b>3</b>

**iTeh STANDARD PREVIEW  
(standards.iteh.ai)**

SIST EN ISO 14271:2018  
<https://standards.iteh.ai/catalog/standards/sist/31216067-4f9a-457d-8f62-d095c3330e64/sist-en-iso-14271-2018>

## European foreword

This document (EN ISO 14271:2017) has been prepared by Technical Committee ISO/TC IIW "International Institute of Welding" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" 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 March 2018, and conflicting national standards shall be withdrawn at the latest by March 2018.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 14271:2011.

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, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

**iTeh STANDARD PREVIEW**  
Endorsement notice  
**(standards.iteh.ai)**

The text of ISO 14271:2017 has been approved by CEN as EN ISO 14271:2017 without any modification.

SIST EN ISO 14271:2018  
<https://standards.iteh.ai/catalog/standards/sist/31216067-4f9a-457d-8f62-d095c3330e64/sist-en-iso-14271-2018>

**iTeh STANDARD PREVIEW  
(standards.iteh.ai)**

SIST EN ISO 14271:2018

<https://standards.iteh.ai/catalog/standards/sist/31216067-4f9a-457d-8f62-d095c3330e64/sist-en-iso-14271-2018>

INTERNATIONAL  
STANDARD

ISO  
14271

Third edition  
2017-08

---

---

---

**Resistance welding — Vickers  
hardness testing (low-force and  
microhardness) of resistance spot,  
projection, and seam welds**

*Soudage par résistance — Essais de dureté Vickers (force réduite et  
microdureté) sur soudures par résistance par points, par bossages et*

**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

[SIST EN ISO 14271:2018](#)

[https://standards.iteh.ai/catalog/standards/sist/31216067-4f9a-457d-8f62-  
d095c3330e64/sist-en-iso-14271-2018](https://standards.iteh.ai/catalog/standards/sist/31216067-4f9a-457d-8f62-d095c3330e64/sist-en-iso-14271-2018)



Reference number  
ISO 14271:2017(E)

© ISO 2017

## iTeh STANDARD PREVIEW (standards.iteh.ai)

SIST EN ISO 14271:2018

<https://standards.iteh.ai/catalog/standards/sist/31216067-4f9a-457d-8f62-d095c3330e64/sist-en-iso-14271-2018>



### COPYRIGHT PROTECTED DOCUMENT

© ISO 2017, Published in Switzerland

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Ch. de Blandonnet 8 • CP 401  
CH-1214 Vernier, Geneva, Switzerland  
Tel. +41 22 749 01 11  
Fax +41 22 749 09 47  
copyright@iso.org  
www.iso.org

## Contents

	Page
<b>Foreword</b>	<b>iv</b>
<b>1 Scope</b>	<b>1</b>
<b>2 Normative references</b>	<b>1</b>
<b>3 Terms and definitions</b>	<b>1</b>
<b>4 Applied forces for testing resistance welds</b>	<b>2</b>
<b>5 Test pieces and testing locations</b>	<b>2</b>
5.1 Test pieces	2
5.2 Testing locations	2
<b>6 Test equipment</b>	<b>2</b>
<b>7 Hardness test locations and procedure</b>	<b>5</b>
7.1 Choice of test	5
7.2 Positions of hardness indentations	5
7.3 Testing procedure	6
7.4 Determination of hardness values	6
<b>8 Test report</b>	<b>7</b>
<b>Bibliography</b>	<b>8</b>

**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

SIST EN ISO 14271:2018  
<https://standards.iteh.ai/catalog/standards/sist/31216067-4f9a-457d-8f62-d095c3330e64/sist-en-iso-14271-2018>