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Popis in kvalifikacija varilnih postopkov za kovinske materiale - Preskus varilnega postopka - 13. del: Sočelno uporovno in obžigalno varjenje (ISO 15614-13:2023)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 13: Upset (resistance butt) and flash welding (ISO 15614-13:2023)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 13: Pressstumpf- und Abbrennstumpfschweißen (ISO 15614-13:2023)

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 15614-13:2023)

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**Specification and qualification of welding procedures for
metallic materials - Welding procedure test - Part 13:
Upset (resistance butt) and flash welding (ISO 15614-
13:2023)**

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 15614-13:2023)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 13: Pressstumpf- und Abbrennstumpfschweißen (ISO 15614-13:2023)

This European Standard was approved by CEN on 7 July 2023.

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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.

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CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

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European foreword

This document (EN ISO 15614-13:2023) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" 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 May 2024, and conflicting national standards shall be withdrawn at the latest by May 2024.

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 15614-13:2021.

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INTERNATIONAL
STANDARD

ISO
15614-13

Fourth edition
2023-11

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

**Part 13:
Upset (resistance butt) 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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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 6, *Resistance welding and allied mechanical joining*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 15614-13:2021), which has been technically revised.

The main changes are as follows:

- petal test changed to bend test and bend test changed to three-point bend test;
- scope aligned with ISO 15614-1;
- [Clauses 2, 3, 7 and 8](#) updated;
- clause numbering revised;
- [Annex A](#) and Annex B combined into a new [Annex A](#).
- [Table 1](#) modified;
- Clause 9 aligned with ISO 15614-1;

A list of all parts in the ISO 15614 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html. Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.