



# SLOVENSKI STANDARD SIST EN ISO 14373:2024

01-junij-2024

Nadomešča:  
SIST EN ISO 14373:2015

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**Uporovno varjenje - Postopek točkovnega varjenja neprevlečenih in prevlečenih maloogljčnih jekel (ISO 14373:2024)**

Resistance welding - Procedure for spot welding of uncoated and coated low carbon steels (ISO 14373:2024)

Widerstandsschweißen - Verfahren zum Punktschweißen von niedriglegierten Stählen mit oder ohne metallischem Überzug (ISO 14373:2024)

Soudage par résistance - Mode opératoire pour le soudage par points des aciers à bas carbone revêtus et non revêtus (ISO 14373:2024)

**Ta slovenski standard je istoveten z: EN ISO 14373:2024**

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**ICS:**

25.160.10      Varilni postopki in varjenje      Welding processes

**SIST EN ISO 14373:2024**

**en,fr,de**



EUROPEAN STANDARD

EN ISO 14373

NORME EUROPÉENNE

EUROPÄISCHE NORM

January 2024

ICS 25.160.10

Supersedes EN ISO 14373:2015

English Version

## Resistance welding - Procedure for spot welding of uncoated and coated low carbon steels (ISO 14373:2024)

Soudage par résistance - Mode opératoire pour le soudage par points des aciers à bas carbone revêtus et non revêtus (ISO 14373:2024)

Widerstandsschweißen - Verfahren zum Punktschweißen von niedriglegierten Stählen mit oder ohne metallischem Überzug (ISO 14373:2024)

This European Standard was approved by CEN on 29 December 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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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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

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## European foreword

This document (EN ISO 14373:2024) 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 July 2024, and conflicting national standards shall be withdrawn at the latest by July 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.

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The text of ISO 14373:2024 has been approved by CEN as EN ISO 14373:2024 without any modification.

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**International  
Standard**

**ISO 14373**

**Resistance welding — Procedure  
for spot welding of uncoated and  
coated low-carbon steels**

*Soudage par résistance — Mode opératoire pour le soudage par  
points des aciers à bas carbone revêtus et non revêtus*

**Third edition  
2024-01**

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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](http://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 third edition cancels and replaces the second edition (ISO 14373:2015), which has been technically revised.

The main changes are as follows:

- figures showing failure types and modes for tensile shear and cross tension testing removed;
- new coating types added;
- cross-tension strength (CTS) values added;
- tensile shear strength (TSS) formula removed;
- tolerance for distortions reduced.

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](http://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>.