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**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

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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 documents 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*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 15614-13:2012), which has been technically revised.

The main changes are as follows:

- petal test was changed to bend test and bend test was changed to three-point bend test;
- [Clauses 2](#) and [3](#) have been updated;
- [Clauses 7](#) and [8](#) have been updated;
- [Table 1](#) has been modified.

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](http://www.iso.org/members.html).

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