

STN	Bodové odporové a výstupkové zváranie. Mechanické skúšky zvarov. Rozmery vzoriek a postup na rázovú skúšku šmykom a krížovú skúšku ťahom (ISO 14323: 2015).	STN EN ISO 14323 05 1109
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Resistance welding - Destructive testing of welds - Specimen dimensions and procedure for impact tensile shear test and cross-tension testing of resistance spot and embossed projection welds (ISO 14323:2015)

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 07/15

Obsahuje: EN ISO 14323:2015, ISO 14323:2015

Oznámením tejto normy sa ruší
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Úrad pre normalizáciu, metrológiu a skúšobníctvo SR, 2015
Podľa zákona č. 264/1999 Z. z. v znení neskorších predpisov sa môžu slovenské technické normy
rozmnožovať a rozširovať iba so súhlasom Úradu pre normalizáciu, metrológiu a skúšobníctvo SR.

EUROPEAN STANDARD

EN ISO 14323

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2015

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Supersedes EN ISO 14323:2006

English Version

Resistance welding - Destructive testing of welds - Specimen dimensions and procedure for impact tensile shear test and cross-tension testing of resistance spot and embossed projection welds (ISO 14323:2015)

Soudage par résistance - Essais destructifs des soudures - Dimensions des éprouvettes et mode opératoire pour les essais de cisaillement par choc et les essais de traction par choc sur éprouvettes en croix des soudures par résistance par points et par bossage (ISO 14323:2015)

Widerstandsschweißen - Zerstörende Prüfung von Schweißverbindungen - Probenabmessungen und Durchführung des Schlagscherzugversuchs und des Schlagkopfbzugversuchs von Widerstandspunkt- und Buckelschweißungen mit geprägten Buckeln (ISO 14323:2015)

This European Standard was approved by CEN on 29 November 2014.

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

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Foreword

This document (EN ISO 14323:2015) has been prepared by 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 September 2015, and conflicting national standards shall be withdrawn at the latest by September 2015.

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

This document supersedes EN ISO 14323:2006.

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, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 14323:2015 has been approved by CEN as EN ISO 14323:2015 without any modification.

**Resistance welding — Destructive
testing of welds — Specimen
dimensions and procedure for
impact tensile shear test and cross-
tension testing of resistance spot and
embossed projection welds**

*Soudage par résistance — Essais destructifs des soudures —
Dimensions des éprouvettes et mode opératoire pour les essais de
cisaillement par choc et les essais de traction par choc sur éprouvettes
en croix des soudures par résistance par points et par bossage*





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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 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).

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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/IIW, *International Institute of Welding*, Commission III.

This second edition cancels and replaces the first edition (ISO 14323:2006), which has been technically revised.

Requests for official interpretations of any aspect of this International Standard should be directed to the ISO Central Secretariat, who will forward them to the IIW Secretariat for an official response.

Introduction

This edition of ISO 14323 no longer includes figures showing failure types and modes for tensile shear and cross tension testing in accordance with ISO 14329:2003.

ISO 14323 was revised to align it with ISO 17677-1.

Resistance welding — Destructive testing of welds — Specimen dimensions and procedure for impact tensile shear test and cross-tension testing of resistance spot and embossed projection welds

1 Scope

This International Standard specifies specimen dimensions and testing procedures for impact tensile shear and cross-tension testing of resistance spot and embossed projection welds in overlapping sheets, in any metallic material of thickness 0,5 mm to 4 mm.

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 14272, *Specimen dimensions and procedure for cross tension testing resistance spot and embossed projection welds*

ISO 17677-1, *Resistance welding — Vocabulary — Part 1: Spot, projection and seam welding*

koniec náhľadu – text ďalej pokračuje v platenej verzii STN