

STN	Odporové zvarovanie. Deštruktívne skúšanie zvarov. Rozmery skúšobných vzoriek a postup na skúšanie pevnosti v šmyku odporových bodových a lisovaných výstupkových zvarov (ISO 14273: 2016).	STN EN ISO 14273
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Resistance welding - Destructive testing of welds - Specimen dimensions and procedure for tensile shear testing resistance spot and embossed projection welds (ISO 14273:2016)

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. 08/16

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EUROPEAN STANDARD

EN ISO 14273

NORME EUROPÉENNE

EUROPÄISCHE NORM

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Supersedes EN ISO 14273:2001

English Version

Resistance welding - Destructive testing of welds -
Specimen dimensions and procedure for tensile shear
testing resistance spot and embossed projection welds
(ISO 14273:2016)

Soudage par résistance - Essais destructifs des
soudures - Dimensions des éprouvettes et mode
opérateur pour l'essai de traction-cisaillement des
soudures par résistance par points et par bossages
(ISO 14273:2016)

Widerstandsschweißen - Zerstörende Prüfung von
Schweißverbindungen - Probenmaße und Verfahren
für die Scherzugprüfung an Widerstandspunkt-,
Rollennaht- und Buckelschweißungen mit geprägten
Buckeln (ISO 14273:2016)

This European Standard was approved by CEN on 13 December 2015.

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

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

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European foreword

This document (EN ISO 14273:2016) 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of an identical text or by endorsement, at the latest by September 2016, and conflicting national standards shall be withdrawn at the latest by September 2016.

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 14273:2001.

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 14273:2016 has been approved by CEN as EN ISO 14273:2016 without any modification.

**Resistance welding — Destructive
testing of welds — Specimen
dimensions and procedure for tensile
shear testing resistance spot and
embossed projection welds**

*Soudage par résistance — Essais destructifs des soudures —
Dimensions des éprouvettes et mode opératoire pour l'essai de
traction-cisaillement des soudures par résistance par points et par
bossages*





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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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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 14273:2000), 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 14273 no longer includes figures showing failure types and modes for tensile shear and cross tension testing in accordance with ISO 14329.

ISO 14273 has been revised to align it with ISO 17677-1.

Resistance welding — Destructive testing of welds — Specimen dimensions and procedure for tensile shear testing resistance spot and embossed projection welds

1 Scope

This International Standard specifies specimen dimensions and a testing procedure for tensile shear testing of spot and embossed projection welds, in overlapping sheets, in any metallic material of thickness 0,5 mm to 10 mm, where the welds have a maximum diameter of $7\sqrt{t}$ (where t is the sheet thickness in mm).

The object of tensile shear testing is to determine the tensile shear force that the test specimen can sustain.

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 7500-1, *Metallic materials — Verification of static uniaxial testing machines — Part 1: Tension/compression testing machines — Verification and calibration of the force-measuring system*

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

koniec náhľadu – text ďalej pokračuje v platenej verzii STN