

<b>STN</b>	<b>Odporové zváranie Elektródy na bodové zváranie Elektródové čiapočky (ISO 5821: 2025)</b>	<b>STN EN ISO 5821</b>  05 2669
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Resistance welding - Spot welding electrodes - Female electrode caps (ISO 5821:2025)

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. 11/25

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English Version

## Resistance welding - Spot welding electrodes - Female electrode caps (ISO 5821:2025)

Soudage par résistance - Électrodes pour soudage par points - Embouts amovibles femelles d'électrodes (ISO 5821:2025)

Widerstandsschweißen - Punktschweiß-Elektroden - Elektronenkappen mit Innenkegel (ISO 5821:2025)

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**EN ISO 5821:2025 (E)**

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## **European foreword**

This document (EN ISO 5821:2025) 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 AFNOR.

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of an identical text or by endorsement, at the latest by December 2025, and conflicting national standards shall be withdrawn at the latest by December 2025.

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## **Endorsement notice**

The text of ISO 5821:2025 has been approved by CEN as EN ISO 5821:2025 without any modification.



# International Standard

**ISO 5821**

## **Resistance welding — Spot welding electrodes — Female electrode caps**

*Soudage par résistance — Électrodes pour soudage par points —  
Embouts amovibles femelles d'électrodes*

**Third edition  
2025-06**

## ISO 5821:2025(en)



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**ISO 5821:2025(en)****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 5821:2009), which has been technically revised.

The main changes are as follows:

- [Clause 4](#), [Tables 1](#) and [2](#) revised, and Tables 2 and 3 renumbered;
- [Clause 6](#), examples updated to new values in [Tables 1](#) and [2](#) more examples added for clarification;
- [Clause 7](#), labelling on the packages, and marking on each electrode cap surface;
- [Figure 1](#), updated drawings with correct proportions;
- [Figure 2](#), added to know the variety of the water-cooling hole bottom profiles;
- [Annex A](#), revised and made informative;
- [Annex B](#), added to show the comparative table of electrode tip shape names in some countries.

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>.

# Resistance welding — Spot welding electrodes — Female electrode caps

## 1 Scope

This document specifies the dimensions and tolerances of female electrode caps for resistance spot welding of metallic materials.

Taper dimensions and tolerances of the electrode caps follow the values specified in ISO 1089.

NOTE Electrode caps with locking tapers are addressed in ISO 20168. Male electrode caps are specified in ISO 5830.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1089, *Resistance welding equipment — Electrode taper fits for spot welding equipment — Dimensions*

ISO 5182, *Resistance welding — Materials for electrodes and ancillary equipment*

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

**koniec náhľadu – text ďalej pokračuje v platenej verzii STN**