

DIN EN 10359:2023-07 (E)

Laser welded tailored blanks - Technical delivery conditions

Contents		Page
European foreword		3
1	Scope	4
2	Normative references	4
3	Terms and definitions	4
4	Requirements	5
5	Tolerances on dimensions, shape and packaging	5
6	Destructive testing of weld joints	5
6.1	Cup test	5
6.2	Cross section	5
6.3	Heat treatment for hot stamped blanks	5
6.4	Tensile testing for hot stamped blanks	5
6.5	Hardness test for hot stamped blanks	6
6.6	Tensile and hardness quality inspection interval for hot stamped LWB	6
6.7	Cross section measurement method	14
Annex A (normative) Tensile test failure assessment		17
A.1	Case 1	17
A.2	Case 2	17
A.3	Case 3	18
A.4	Case 4	18
Annex B (normative) Hardness assessment criteria for hot stamped LWB		19
B.1	Methodology	19
B.2	Determination of hardness	19
B.3	Requirement for minimum hardness of the weld seam	21
B.4	Requirement for maximum hardness of the weld seam for steel hardness > 400 HV	24
B.5	requirement for maximum hardness of the weld seam for steel hardness 400 HV	26
Bibliography		28