DIN EN ISO 14373:2024-04 (E)

Resistance welding - Procedure for spot welding of uncoated and coated low-carbon steels (ISO 14373:2024)

Contents

Page

European foreword ... **3**

Foreword ... **4**

Introduction ... **5**

1 Scope ... **6**

2 Normative references ... **6**

3 Terms and definitions ... **6**

4 Symbols ... **7**

5 Materials ... **7**
5.1 Form ... 7
5.2 Coatings ... 7

6 Surface conditions ... **7**

7 Edge conditions, form of component and weld pitch ... **7**

8 Electrodes ... **8**
8.1 Materials ... 8
8.2 Dimensions ... 8
8.3 Cooling of electrodes ... 9

9 Weld assessment ... **9**
9.1 General ... 9
9.2 Weldability testing ... 10
9.3 Production testing ... 10
9.4 Frequency of testing ... 10

10 Weld quality requirements ... **10**
10.1 Weld diameter ... 10
10.2 Failure description of welds ... 11
10.3 Weld strength ... 11
10.4 Visual examination ... 12
10.4.1 Surface condition ... 12
10.4.2 Distortion ... 12

11 Multi-weld arrays ... **13**

Annex A (informative) **Recommendations for spot-welding equipment** ... **14**

Annex B (informative) **Typical spot-welding conditions** ... **15**

Annex C (informative) **Partial list of steel types applicable to this document** ... **17**

Bibliography ... **19**