

# ISO 17642-2 :2005-03 (E)

Destructive tests on welds in metallic materials - Cold cracking tests for weldments - Arc welding processes - Part 2: Self-restraint tests

---

## Contents

	page
<b>Foreword.....</b>	<b>v</b>
<b>1 Scope .....</b>	<b>1</b>
<b>2 Normative references .....</b>	<b>1</b>
<b>3 Terms and definitions .....</b>	<b>1</b>
<b>4 Designation and symbols .....</b>	<b>2</b>
<b>5 Principle.....</b>	<b>2</b>
<b>5.1 General.....</b>	<b>2</b>
<b>5.2 Qualitative evaluation.....</b>	<b>2</b>
<b>5.3 Quantitative evaluation .....</b>	<b>2</b>
<b>6 Test.....</b>	<b>3</b>
<b>6.1 CTS-test .....</b>	<b>3</b>
<b>6.1.1 Dimensions of the test pieces .....</b>	<b>3</b>
<b>6.1.2 Preparation of the test pieces .....</b>	<b>3</b>
<b>6.1.3 Anchor welds .....</b>	<b>4</b>
<b>6.1.4 Test welds.....</b>	<b>5</b>
<b>6.1.5 Test results.....</b>	<b>7</b>
<b>6.2 TEKKEN-test (Y-groove) and Lehigh test (U-groove) .....</b>	<b>9</b>
<b>6.2.1 General.....</b>	<b>9</b>
<b>6.2.2 Dimensions of the test pieces .....</b>	<b>9</b>
<b>6.2.3 Preparation of the test pieces .....</b>	<b>10</b>
<b>6.2.4 Anchor welds .....</b>	<b>10</b>
<b>6.2.5 Test welds.....</b>	<b>10</b>
<b>6.2.6 Test results.....</b>	<b>13</b>
<b>7 Test report (CTS, Y and U groove).....</b>	<b>16</b>
<b>Annex A (informative) Test report for CTS test.....</b>	<b>17</b>
<b>Annex B (informative) Test report for Y- or U-joint (TEKKEN) weld cracking test .....</b>	<b>18</b>
<b>Annex ZA (normative) Normative references to International publications with their relevant European publication .....</b>	<b>19</b>