DIN EN ISO 14373:2007-09 (E)

Resistance welding - Procedure for spot welding of uncoated and coated low carbon steels (ISO 14373:2006)

Contents

Page

5.1 5.2 8.1 8.2 8.3 9.1 9.2 9.3 9.4 10 10.1 10.2 10.3 10.4 10.5 11 Cooling of electrodes 10

Edge conditions, form of component, and weld spacing 8

Electrodes 8

Dimensions 8

Surface conditions 8

Steel grades 7

Material 7

Terms and definitions 5

Form 7

Symbols and abbreviated terms 7

Normative references 5

Foreword 3

Scope 4

Materials 8

Weld assessment 11

Weldability tests 11

Frequency of testing 11

General 11

Production tests 11

Weld quality requirements 12

Weld shear strength 12

Weld diameter 12

Weld fracture mode 12

Weld penetration and indentation 12

Weld appearance 13

Multi-weld arrays 13

Annex A (informative) Recommendations for spot welding equipment 15

Annex B (informative) Typical spot welding conditions 16

Annex C (informative) Partial list of steel types applicable to this International Standard 18

Bibliography 19