DIN EN ISO 14270:2016-11 (E)

Resistance welding - Destructive testing of welds - Specimen dimensions and procedure for mechanized peel testing resistance spot, seam and embossed projection welds (ISO 14270:2016)

Contents

Page

European foreword ... **3**

Foreword ... **4**

Introduction ... **5**

1 Scope ... **6**

2 Normative references ... **6**

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

4 Test pieces and specimens ... **7**

5 Preparation of mechanized peel test specimens ... **10**
5.1 General ... 10
5.2 Bending procedure of weld test specimens after welding ... 10
5.3 Bending procedure of test specimens before welding — Alternative procedure ... 10
5.4 Dimensions and accuracy ... 13

6 Peel testing procedure and test equipment ... **14**

7 Re-test ... **15**

8 Test report ... **15**

Annex A (normative) **Measurement of seam weld size** ... **16**

Annex B (informative) **Influence of spot weld position on test results** ... **17**

Annex C (informative) **Examples of bending tools** ... **18**

Annex D (informative) **Determination of the bending centre position with press brake systems** ... **20**

Bibliography ... **21**