

DIN ISO 17657-4:2006-02 (E)

Resistance welding - Welding current measurement for resistance welding - Part 4: Calibration system (ISO 17657-4:2005)

Contents		Page
Foreword		2
Introduction		3
1	Scope	4
2	Normative references	4
3	Terms and definitions	4
4	Construction of calibration system	5
4.1	Reference welding current measuring system	5
4.2	Test set-up	5
4.3	Basic feature for calibration of welding current measuring system	5
4.4	Basic feature for calibration of current sensor	7
4.5	Basic feature for calibration of welding current meter without sensor	8
5	Physical environment and operating conditions	9
6	Calibration requirements	9
6.1	Reference welding current measuring system	9
6.2	Reference current sensor	9
6.3	Data acquisition device	10
6.4	Test stage and power sources	10
7	Test report	10
7.1	Test report for calibration of welding current measuring systems	10
7.2	Test report for calibration of current sensors	11
7.3	Test report for calibration of welding current meters without sensors	11
8	Test procedure	12
8.1	General	12
8.2	Calibration of welding current measuring system	12
8.3	Calibration of current sensor	13
8.4	Calibration of welding current meter without sensor	13
8.5	Special calibration cases	13
Annex A (informative) Measuring set-up		15
Annex B (informative) Items to be recorded or filed as reference documentation for calibration		20
Annex C (informative) Examples of the test report in accordance with this part of ISO 17657		22