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# Modstandssvejsning – Prøvning af svejsninger – Udrivnings- og mejselprøvning af modstandspunkt- og projektionssvejsninger

Resistance welding – Testing of welds – Peel and chisel testing of resistance spot and projection welds (ISO 10447:2022)

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NORME EUROPÉENNE

# EUROPÄISCHE NORM

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English Version

# Resistance welding - Testing of welds - Peel and chisel testing of resistance spot and projection welds (ISO 10447:2022)

Soudage par résistance - Essais des soudures - Essais de pelage et de déboutonnage au burin appliqués aux soudures par résistance par points et par bossages (ISO 10447:2022)

Widerstandsschweißen - Prüfung von Schweißverbindungen - Schäl- und Meißelprüfung von Widerstandspunkt- und Buckelschweißverbindungen (ISO 10447:2022)

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# European foreword

This document (EN ISO 10447:2022) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 “Welding and allied processes” the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2023, and conflicting national standards shall be withdrawn at the latest by June 2023.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 10447:2015.

Any feedback and questions on this document should be directed to the users’ national standards body/ national committee. A complete listing of these bodies can be found on the CEN website.

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Fourth edition
2022-11

# Resistance welding — Testing of welds — Peel and chisel testing of resistance spot and projection welds

*Soudage par résistance — Essais des soudures — Essais de pelage et de déboutonnage au burin appliqués aux soudures par résistance par points et par bossages*

Reference number
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# Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 6, *Resistance welding and allied mechanical joining*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 10447:2015), which has been technically revised.

The main changes are as follows:

— the terms and definition given in ISO 17677-1 apply.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html. Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: https://committee.iso.org/sites/tc44/home/interpretation.html.


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# Resistance welding — Testing of welds — Peel and chisel testing of resistance spot and projection welds

## 1 Scope

This document specifies the procedures and recommended tooling to be used for peel and chisel testing of resistance spot and embossed projection welds. This document applies to welds made in two or more sheets in the thickness range of 0,5 mm to 3,0 mm.

The aim of these tests is to determine:

— weld size and failure mode when welds are destructively tested;

— verification of welds by non-destructive chisel tests.

NOTE The preferred method of peel testing seam welds (mechanized peel testing) is covered in ISO 14270.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 17677-1, *Resistance welding — Vocabulary — Part 1: Spot, projection and seam welding*

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