INTERNATIONAL STANDARD

ISO 18278-1

Third edition
2022-05

Resistance welding — Weldability —

Part 1: General requirements for the evaluation of weldability for resistance spot, seam and projection welding of metallic materials

Soudage par résistance — Soudabilité —

Partie 1: Exigences générales pour l'évaluation de la soudabilité pour le soudage par résistance par points, à la molette et par bossages des matériaux métalliques

Reference number
ISO 18278-1:2022(E)

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Published in Switzerland

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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).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

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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 third edition cancels and replaces the second edition (ISO 18278-1:2015) and the first edition of ISO 14327:2004, which have been technically revised.

The main changes are as follows:

— the concept of weldability lobe was added to this document.

A list of all parts in the ISO 18278 series can be found on the ISO website.

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.

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Resistance welding — Weldability —

Part 1: General requirements for the evaluation of weldability for resistance spot, seam and projection welding of metallic materials

1 Scope

This document specifies procedures for assessing the generic weldability for resistance spot, seam and projection welding of uncoated and coated metals.

The purpose of the tests described in this document are to

a) compare the metallurgical weldability of different metals,

b) assess the weldability of differing component designs, e.g. dimensional configuration, stack-up, projection geometry, etc.,

c) investigate the effect of changes in welding parameters such as welding current, weld time, electrode force or complex welding schedules including pulse welding, current stepping etc. on weldability, and/or

d) compare the performance of resistance welding equipment.

Precise details of the test procedure to be used depend on which aspect of items a) to d) will be evaluated relative to the welding result obtained.

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 669, *Resistance welding — Resistance welding equipment — Mechanical and electrical requirements*

ISO 693, *Dimensions of seam welding wheel blanks*

ISO 5182, *Resistance welding — Materials for electrodes and ancillary equipment*

ISO 5821, *Resistance welding — Spot welding electrode caps*

ISO 8167, *Resistance welding — Embossed projection welding — Projections for resistance welding*

ISO 14270, *Resistance welding — Destructive testing of welds — Specimen dimensions and procedure for mechanized peel testing resistance spot, seam and embossed projection welds*

ISO 14271, *Resistance welding — Vickers hardness testing (low-force and microhardness) of resistance spot, projection, and seam welds*

ISO 14272, *Resistance welding — Destructive testing of welds — Specimen dimensions and procedure for cross tension testing of resistance spot and embossed projection welds*

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ISO 14273, *Resistance welding — Destructive testing of welds — Specimen dimensions and procedure for tensile shear testing resistance spot and embossed projection welds*

ISO 15609-5, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 5: Resistance welding*

ISO 15614-12, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 12: Spot, seam and projection welding*

ISO 16432, *Resistance welding — Procedure for projection welding of uncoated and coated low carbon steels using embossed projection(s)*

ISO 17657-2, *Resistance welding — Welding current measurement for resistance welding — Part 2: Welding current meter with current sensing coil*

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

ISO/TR 581, *Weldability — Metallic materials — General principles*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 17677-1, ISO 669, ISO/TR 581 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at https://www.electropedia.org/

3.1
weldability
<resistance welding> capacity of the component to be welded under the imposed fabrication conditions into a specific suitability designed structure and to perform satisfactorily in the intended service

3.2
welding current range
welding current domain allowing the production of spot welds without expulsion and of a diameter equal to or more than a pre-determined value under constant machine settings

3.3
weldability lobe
welding current domain allowing the production of spot welds without splash and of a diameter equal to or more than a pre-determined value, using varied values of either welding time or electrode force

Note 1 to entry: In the case of resistance seam welding, welding speed (m/min) is used instead of weld time.

Note 2 to entry: To meet the above requirements, the weldability lobes can be a two-dimensional plot (see Figure 1) or a three-dimensional plot indicating the inter relationship between weld time (welding speed in the case of seam welding), welding current and electrode force:

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