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(JWES/JSA)

**Specimen dimensions and procedure  
for cross tension testing of spot and  
projection welded joints**

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In the event of any doubts arising as to the contents,  
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## Foreword

This Japanese Industrial Standard has been revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee as the result of proposal for revision of Japanese Industrial Standard submitted by The Japan Welding Engineering Society (JWES)/Japanese Standards Association (JSA) with a draft being attached, based on the provision of Article 12, paragraph (1) of the Industrial Standardization Act applied mutatis mutandis pursuant to the provision of Article 16 of the said Act. This edition replaces the previous edition (**JIS Z 3137 : 1999**), which has been technically revised.

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# Specimen dimensions and procedure for cross tension testing of spot and projection welded joints

## Introduction

This Japanese Industrial Standard has been prepared based on **ISO 14272 : 2016**, Edition 2, with some modifications of the technical contents in order to allow for the use of specimen dimensions and configurations conventionally used in Japan.

The vertical lines on both sides and dotted underlines indicate changes from the corresponding International Standard. A list of modifications with the explanations is given in Annex JA.

## 1 Scope

This Standard specifies the shape/dimensions of specimens of spot and projection welded joints in any metallic material with a sheet thickness of 0.5 mm to 5 mm and a nugget diameter of up to  $7\sqrt{t}$  ( $t$ : sheet thickness), and the cross tension testing method for each specimen.

NOTE: The International Standard corresponding to this Standard and the symbol of degree of correspondence are as follows.

*ISO 14272 : 2016 Resistance welding—Destructive testing of welds—Specimen dimensions and procedure for cross tension testing of resistance spot and embossed projection welds (MOD)*

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21-1**.

## 2 Normative references

Part or all of the provisions of the following standards, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

JIS Z 2241 *Metallic materials — Tensile testing — Method of test at room temperature*  
JIS Z 3001-1 *Welding and allied processes — Vocabulary — Part 1: General*  
JIS Z 3001-6 *Welding and allied processes — Vocabulary — Part 6: Resistance welding*

## 3 Terms and definitions

For the purpose of this Standard, the following term and definition, and those given in **JIS Z 3001-1** and **JIS Z 3001-6** apply.