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**Destructive tests on welds in metallic  
materials — Tensile test on cruciform and  
lapped joints**

*Essais destructifs des soudures sur matériaux métalliques — Essai de  
traction des assemblages en croix et à recouvrement*

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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.

ISO 9018 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 5, *Testing and inspection of welds*.

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## Introduction

Requests for official interpretations of any aspect of this standard should be directed to the Secretariat of ISO/TC 44/SC 5 via your national standards body, a complete listing which can be found at [www.iso.org](http://www.iso.org)

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# Destructive tests on welds in metallic materials — Tensile test on cruciform and lapped joints

## 1 Scope

This International Standard specifies the sizes of test pieces and test specimens and the procedure for carrying out tensile tests in order to determine the tensile strength and the location of fracture of welded joints with transverse stressed fillet welds.

This International Standard applies to metallic materials with welded cruciform and lapped joints on plates<sup>1)</sup>.

Information concerning evaluation of test results is not included in this International Standard.

## 2 Normative references

The following referenced documents are indispensable for the application 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 6892, *Metallic materials — Tensile testing at ambient temperature*

## 3 Symbols and abbreviated terms

The symbols used for the tensile tests are specified in Table 1 and Figures 1 to 5.

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1) The term “plate”, alone or in combination, is used to mean “plate”, “sheet”, “extruded bar” and other solid sections.

Table 1 — Symbols and abbreviated terms

Symbol	Designation	Unit
$a, a_1, a_2, a_3, a_4$	Fillet weld throat thickness	mm
$A_f$	Fracture area ( $w_f \times b$ )	mm <sup>2</sup>
$b$	Width of the test specimen equal to the length of fracture surface	mm
$c$	Free length between section to be tested and grips of testing device	mm
$d$	Length of test plates used	mm
$f$	Gap width for lapped specimens	mm
$F_m$	Maximum load sustained by the test specimen during testing	N
$L_t$	Total length of the test specimen	mm
$R_m$	Tensile strength ( $F_m/A_t$ )	MPa
$t_1, t_2, t_3$	Thicknesses of the materials used to prepare test pieces and test specimens	mm
$w_f$	Width of the fracture surface <sup>a</sup>	mm

<sup>a</sup> See Figure 1.

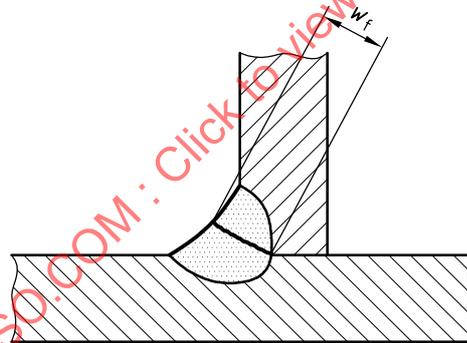


Figure 1 — Definition of width of fracture surface

#### 4 Principle

An increasing tensile load is continuously applied to a test specimen taken from a welded joint until rupture occurs.

Unless otherwise specified, the test shall be carried out at 23 °C ± 5 °C.

Unless otherwise stated, the general principles of ISO 6892 apply.

## 5 Test pieces and test specimens

### 5.1 Test pieces

The test pieces shall be prepared and welded in accordance with the relevant application standard and Figures 2 and 4. Linear misalignment and angular distortion of the test pieces should be kept to a minimum and recorded on the test report.

### 5.2 Test specimens

#### 5.2.1 Dimensions

The dimensions of the test specimens shall be in accordance with Figures 3 and 5. The weld axis shall remain perpendicular to the longitudinal direction of the specimen.

#### 5.2.2 Marking

Each test specimen shall be marked to identify its exact location in the test piece. If required by the relevant application standard, the direction of working (e.g. rolling or extrusion) shall be marked.

### 5.3 Heat treatment and/or ageing

No heat treatment shall be applied to the welded joint or to the test specimen unless it is specified or permitted by the relevant application standard dealing with the welded joint to be tested. Details of any heat treatment shall be recorded in the test report; see Annex A for an example of a test report. If natural ageing of aluminium alloys takes place, the time between welding and testing shall be recorded.

### 5.4 Extraction of test pieces

#### 5.4.1 General

The mechanical or thermal processes used to extract the test specimen shall not change the properties of the test specimen in any way.

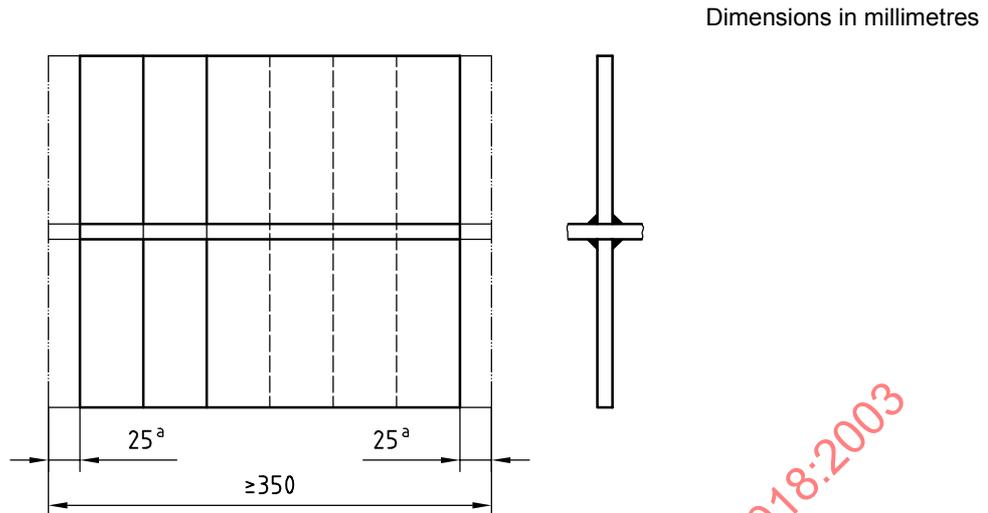
#### 5.4.2 Steel

Sawing or milling shall be used.

If thermal cutting or other cutting methods that could affect the cut surface are used to cut the test specimen from the test piece, the cuts shall be at least 8 mm from the edge surface of the test specimen.

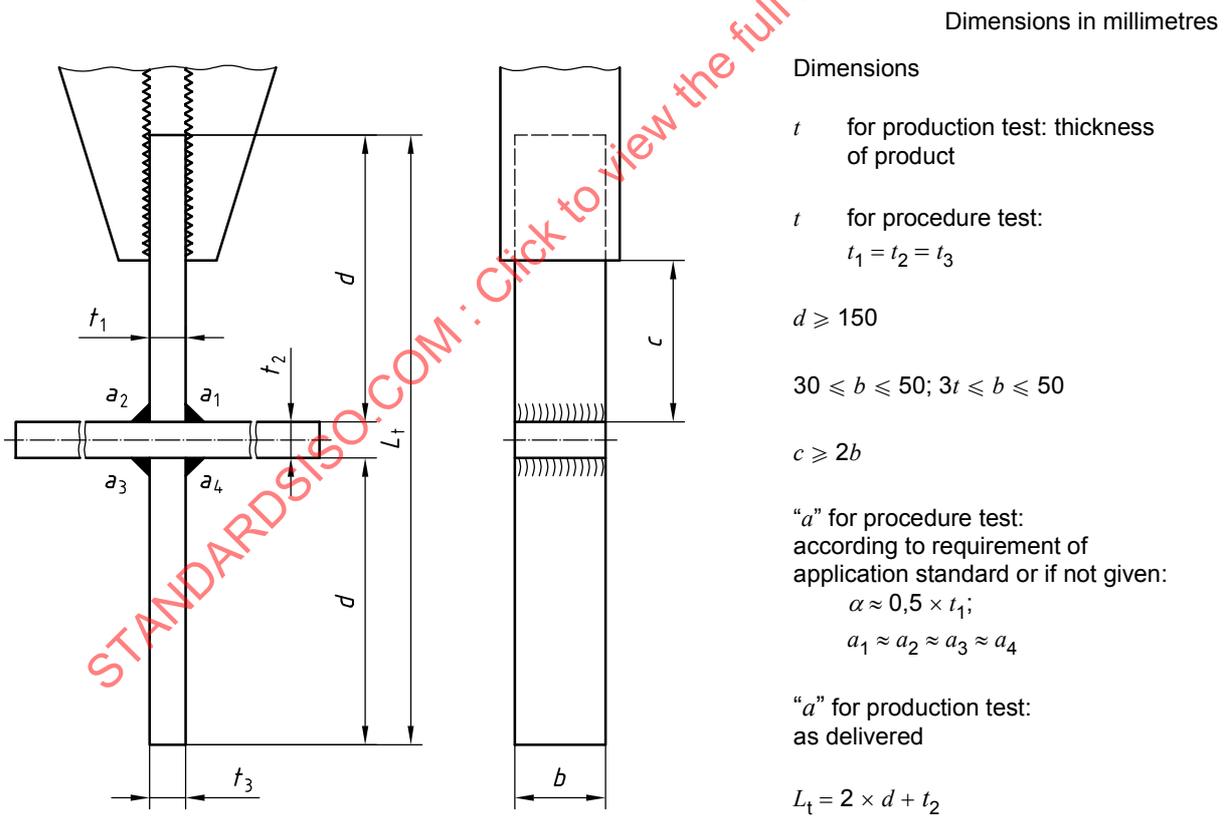
#### 5.4.3 Surface preparation

The final stages of preparation shall be obtained by machining or grinding, suitable precautions being taken to avoid superficial strain hardening or excessive heating of the material. The surfaces shall be free from scratches or notches transverse to the test specimen direction in the free length to be tested, except for undercut which shall not be removed unless required by the relevant application standard.



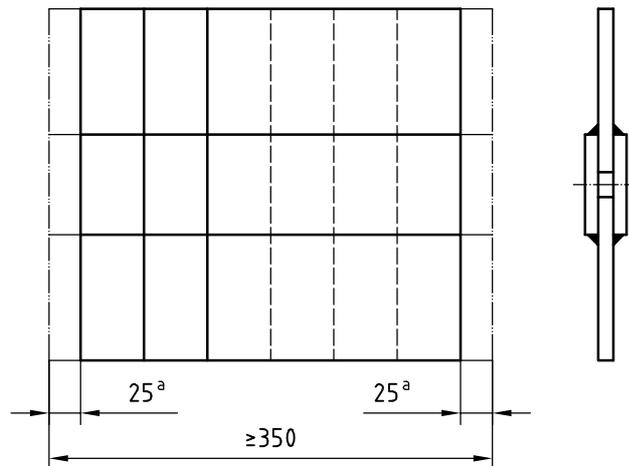
<sup>a</sup> End pieces are to be discarded.

**Figure 2 — Location of specimen from a cruciform connection**



**Figure 3 — Cruciform test specimen**

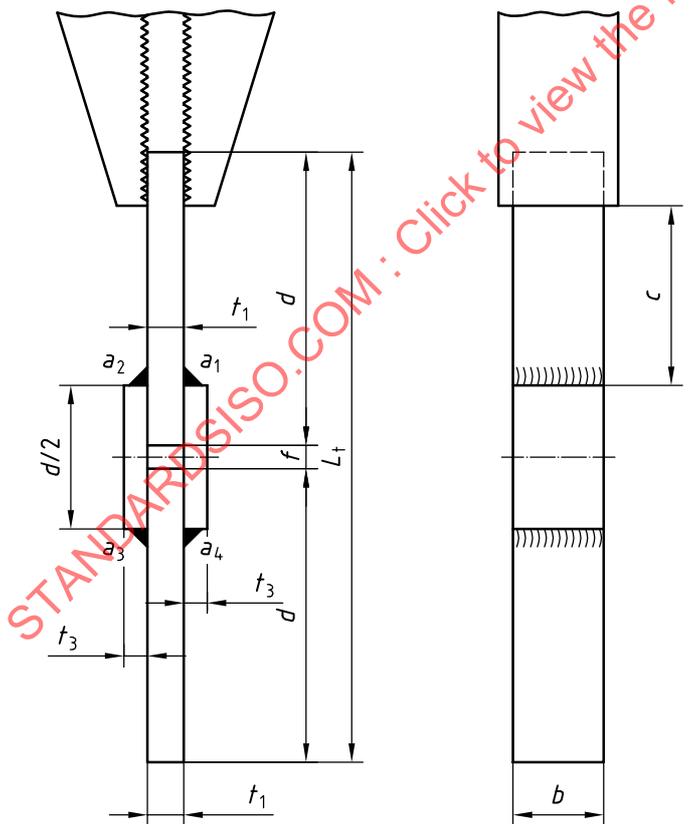
Dimensions in millimetres



<sup>a</sup> End pieces are to be discarded.

Figure 4 — Location of specimen from a lapped connection

Dimensions in millimetres



Dimensions

$t$  for production test: thickness of product

$t$  for procedure test:  
 $t_1 = t_2$

$d \geq 150$

$30 \leq b \leq 50$ ;  $3t \leq b \leq 50$

$c \geq 2b$

“ $a$ ” for procedure test:  
according to requirement of application standard or if not given:  
 $a \approx 0,5 \times t_1$ ;  
 $a_1 \approx a_2 \approx a_3 \approx a_4$

“ $a$ ” for production test: as delivered

$L_t = 2 \times d + f$

Figure 5 — Lapped test specimen

## 6 Method of testing

Prior to testing, the dimensions of the test piece shall be measured and recorded.

The test specimen shall be loaded gradually and continuously in a direction perpendicular to the weld axis until rupture occurs. The speed of loading shall be as uniform as possible; testing shall be progressive and without abrupt changes (see ISO 6892).

After testing, the following shall be measured and/or the result/information recorded (see Clause 7):

- the testing temperature,  $T$ ;
- the fracture surfaces shall be examined and the existence of any imperfections, including their type, size and amount shall be recorded. If fish eyes are present, their location shall be recorded. Only the central regions of fish eyes shall be considered as imperfections;
- the average width of the fracture surface  $w_f$  (see Figure 1) shall be determined by measuring at several points across the fracture at a spacing of approximately  $3 \times a$  and dividing by the total number of measurements;
- the tensile strength,  $R_m$ , calculated as the ratio of the maximum load,  $F_m$ , sustained by the test specimen during testing and the fracture area,  $A_f$ , expressed in MPa.

NOTE If the plate delaminates, the test should be considered as being void.

## 7 Test report

The test report shall include the following information:

- a) reference to this International Standard, i.e. ISO 9018;
- b) date of testing;
- c) details concerning the examiner or test body;
- d) dimensions of the test specimens before fracture ( $a_1, a_2, a_3, a_4, t_1, t_2, t_3, b$ );
- e) amount of misalignment and angular distortion;
- f) location of the fracture;
- g) location, type, size and amount of any imperfections (see Clause 6 regarding fish eyes);
- h) average width of the fracture surface,  $w_f$ ;
- i) tensile strength,  $R_m$ ;
- j) load per unit length,  $F_m/b$ ;
- k) testing temperature, if it is outside the temperature range  $23 \text{ °C} \pm 5 \text{ °C}$ ;
- l) details of any heat treatment in accordance with the relevant application standard (see also 5.3).

An example of a typical test report is given in Annex A.