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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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# Contents

	Page
Foreword .....	iv
<b>1 Scope</b> .....	<b>1</b>
<b>2 Normative references</b> .....	<b>1</b>
<b>3 Symbols and abbreviated terms</b> .....	<b>1</b>
<b>4 Principle</b> .....	<b>2</b>
<b>5 Test pieces and test specimens</b> .....	<b>2</b>
5.1 Test pieces .....	2
5.2 Test specimens .....	2
5.2.1 Dimensions .....	2
5.2.2 Marking .....	2
5.3 Heat treatment and/or ageing .....	2
5.4 Extraction of test pieces .....	3
5.4.1 General .....	3
5.4.2 Steel .....	3
5.4.3 Surface preparation .....	3
<b>6 Method of testing</b> .....	<b>6</b>
<b>7 Test report</b> .....	<b>7</b>
<b>8 Evaluation of results</b> .....	<b>7</b>
<b>Annex A (informative) Example of a test report</b> .....	<b>8</b>

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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](http://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](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, SC 5, *Testing and inspection of welds*.

This second edition cancels and replaces the first edition (ISO 9018:2003), of which it constitutes a minor revision.

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).

# 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, for determining the tensile strength and location of fractures in welded joints with transverse stressed fillet welds.

It is applicable to metallic materials with welded cruciform and lapped joints on plates, where the term *plate* — alone or in combination — refers to plates, sheets, extruded bars or other solid sections.

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

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

## 3 Symbols and abbreviated terms

The symbols used for the tensile tests are specified in [Table 1](#) and [Figures 1](#) to [5](#).

**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 ( $F_m/A_f$ )	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](#).

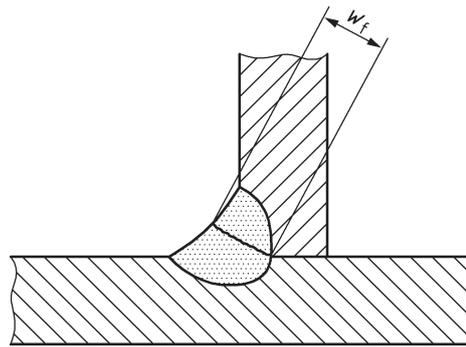


Figure 1 — Definition of width of fracture surface

## 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  $23\text{ °C} \pm 5\text{ °C}$ .

Unless otherwise stated, the general principles of ISO 6892-1 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.

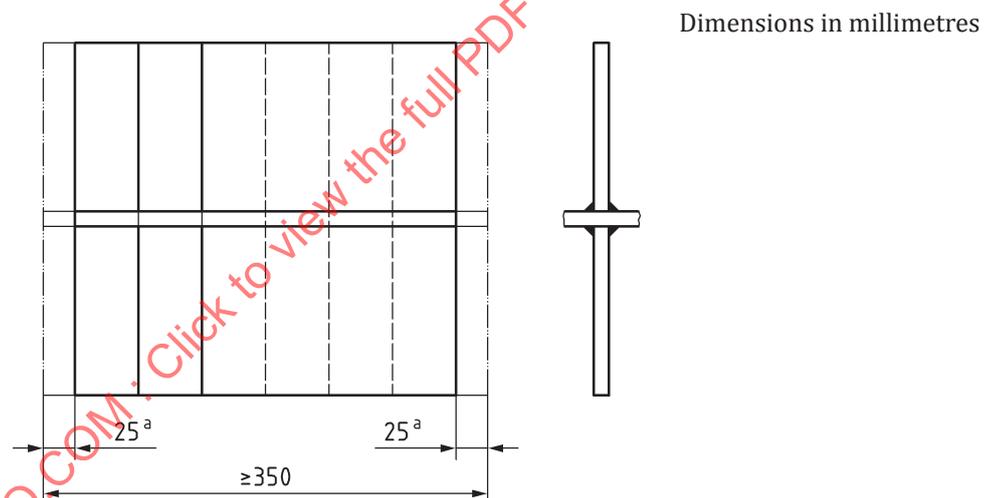
### 5.4.2 Steel

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.

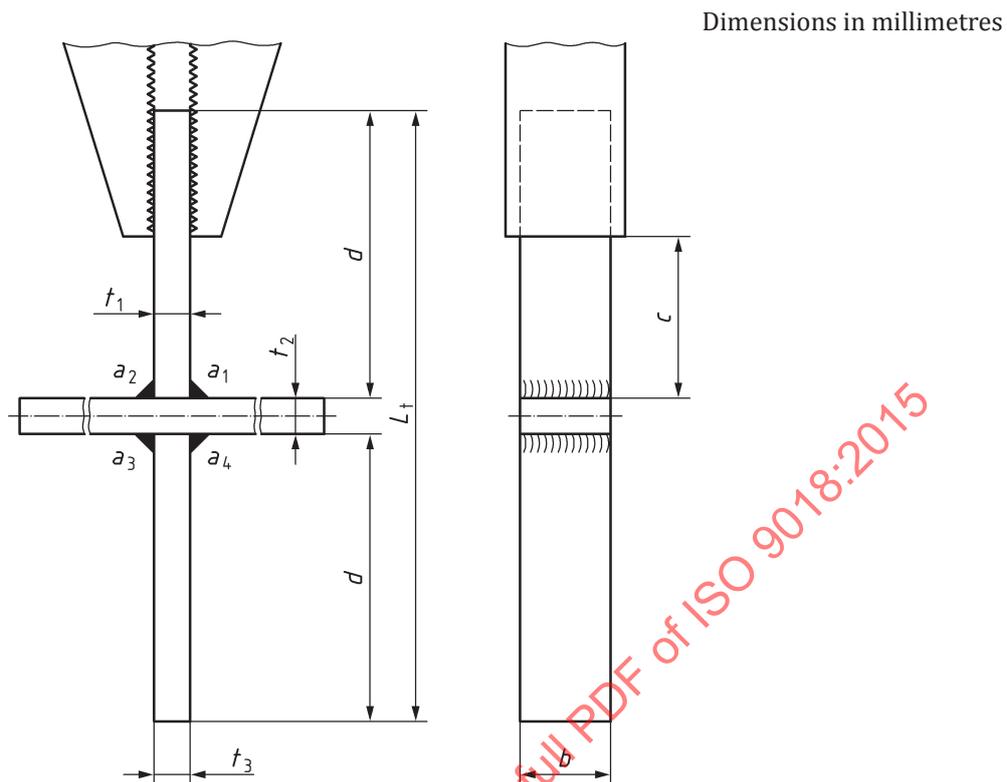
### 5.4.3 Surface preparation

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



**Key**

*t* production test: thickness of product

procedure test:  $t_1 = t_2 = t_3$

*a* procedure test:

according to requirement of application standard

or, if not given:

$$a \approx 0,5 \times t_1$$

$$a_1 \approx a_2 \approx a_3 \approx a_4$$

production test: as delivered

$$d \geq 150$$

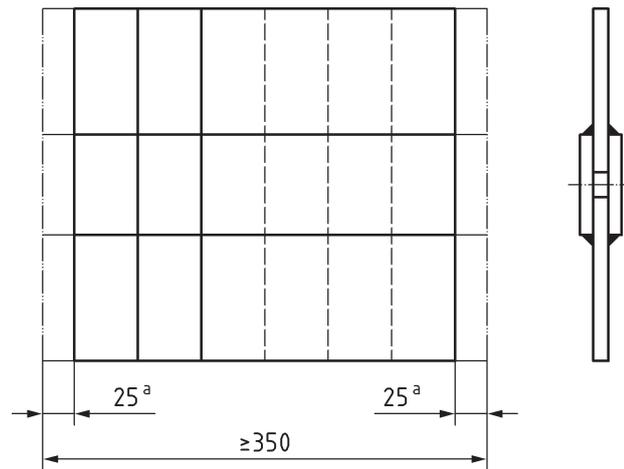
$$30 \leq b \leq 50; 3t \leq b \leq 50$$

$$c \geq 2b$$

$$L_t = 2 \times d + t_2$$

**Figure 3 — Cruciform test specimen**

Dimensions in millimetres

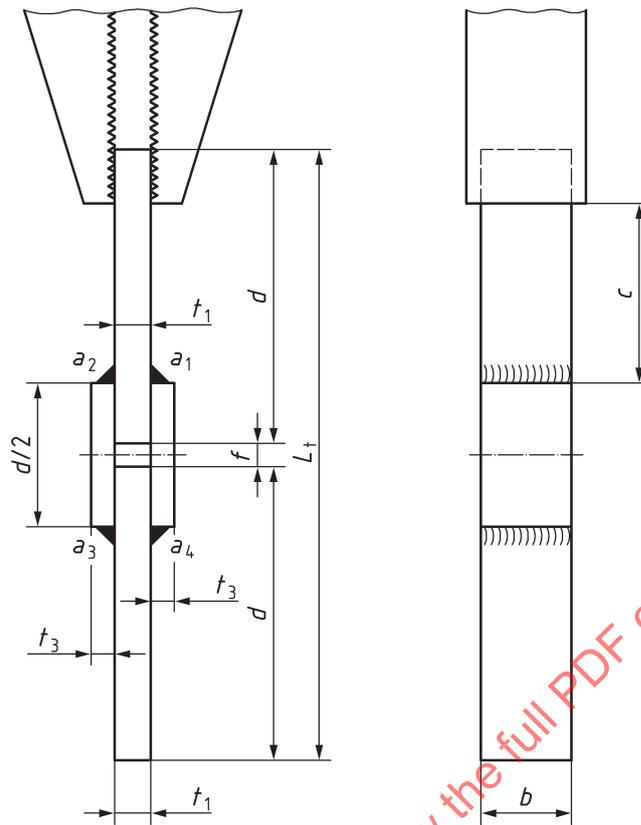


- <sup>a</sup> End pieces are to be discarded.

**Figure 4 — Location of specimen from a lapped connection**

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Dimensions in millimetres



**Key**

- $t$  production test: thickness of product  
 procedure test:  $t_1 = t_2$
- $a$  procedure test:  
 according to requirement of application standard  
 or, if not given:  
 $\alpha \approx 0,5 \times t_1$   
 $a_1 \approx a_2 \approx a_3 \approx a_4$   
 production test: as delivered

- $d \geq 150$
- $30 \leq b \leq 50; 3t \leq b \leq 50$
- $c \geq 2b$
- $L_t = 2 \times d + f$

**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 6892-1).

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

- the test 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.

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) test 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](#).

## 8 Evaluation of results

The results of the test shall be evaluated in accordance with the appropriate application standard.