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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 32514.1-2016

**Resistance welding -- Welding current measurement for
resistance welding -- Part 1: Guidelines for measurement**

电阻焊 焊接电流的测量 第1部分：测量指南

(English Translation)

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Foreword

GB/T 32514 "resistance welding current measurement" is divided into five parts.

- Part 1. Measurement guidelines;

Part 2. welding current measuring instrument with current sensing coil;

Part 3. Current sensing coils;

- Part 4. Calibration system;

Part 5. Confirmation of welding current measurement systems.

This part is part 1 of GB/T 32514.

This part is drafted in accordance with the rules given in GB/T 1.1-2009.

This part uses the translation method equivalent to ISO 17657-1.:2005 "Measurement of Resistance Welding Soldering Current Part 1. Measurement Guide".

And the normative reference in this standard international documents are consistent with the relationship between China's documents are as follows.

GB/T 8366-2004 Mechanical and electrical requirements for solder resist welding machines (ISO 669.:2000, MOD) GB/T 32514.3-2016 Resistance welding current measurement - Part 3. Current sensing coils (ISO 17657-3.

2005, IDT)

Measurement of welding current for resistance welding - Part 4. Calibration system (ISO 17657-4.:2005, IDT) GB/T 32514.5-2016 Resistance welding current measurement - Part 5. Confirmation of welding current measurement system (ISO 17657-5.:2005, IDT) this part is made by China Electrical Equipment Industry Association.

This part of the National Welding Technology Standardization Technical Committee (SAC/TC70) centralized.

This part of the drafting unit. Chengdu Sanfang Electric Co., Ltd., Tianjin seven high-tech

Co., Ltd., Shenzhen Peng Yu Wei Technology Co., Ltd., Zhejiang Kende Electromechanical Co., Ltd., Tian Tian Miaji Trade (Shanghai) Co., Ltd., Guangzhou Songxing Electric Co., Ltd.

1 Scope

This part of GB/T 32514 specifies welding current and soldering for measuring single phase AC (50Hz or 60Hz) and DC resistance welding Time the system used to calibrate the equipment used.

This section gives basic terms for welding current measurement and basic information about the welding current measurement system, Welding current measurement system for flow coil.

2 Normative reference documents

The following documents are indispensable for the application of this document. For dated references, only the dated edition applies to this article Pieces. For undated references, the latest edition (including all modifications) applies to this document.

GB/T 32514.2-2016 Resistance welding current measurement - Part 2. Welding current measuring instrument with current sensing coil (ISO 17657-2.:2005, IDT) ISO 669 resistance welding resistance machine mechanical and electrical requirements (Resistance welding-Resistance welding equipment-mechanical and electrical requirements ISO 17657-3 resistance welding current measurement - Part 3. Current sensing coil (Resistance welding-Welding current measurement for resistance welding-Part 3. Current sensing coil) ISO 17657-4 Resistance welding current measurement - Part 4. Calibration system (Resistance welding-Welding current measurement for resistance welding-Part 4. Calibration system) ISO 17657-5 resistance welding current measurement Part 5. welding current measurement system to confirm (Resistance welding-welding current measurement for resistance welding-Part 5. Verification of welding current measuring system

3 Terms and definitions

ISO 669 and the following terms and definitions apply to this document.

Test test

Identify one or more characteristics of a given product or device by program.

Verification

By providing objective evidence of the required requirements have been met.

Calibration

Under the specified conditions, in order to determine the amount indicated by the measuring instrument or measuring system, or the magnitude represented by the physical gage or reference material, and a corresponding set of operations between the corresponding values that are reproduced by the standard.