DIN EN 1011-8:2018-07 (E)

Welding - Recommendations for welding of metallic materials - Part 8: Welding of cast irons

Contents

Page

European foreword 4

1 Scope 6

2 Normative references 6

3 Terms and definitions 6

4 Abbreviations and symbols 7

5 Provision for quality assurance requirements 7

6 Storage, handling and identification of parent metal 7

7 Fusion welding processes 7

8 Welding consumables 8
8.1 General 8
8.2 Storage and handling 8

9 Equipment 8
9.1 General 8
9.2 Ancillary equipment 8

10 Fabrication 9

11 Weld preparation 9
11.1 Assembly for welding 9
11.2 Finishing welds and repair welds 10

12 Fabrication and inspection feasibility 10

13 Pre-heat temperature and interpass temperature 10

14 Tack welds 10

15 Temporary attachments 10

16 Run-on plates and run-off plates 10

17 Arc strikes 10

18 Weld run sequence 10

19 Heat input 10

20 Welding procedure specification (WPS) 11

21 Traceability 11

22 Elimination of distortion or inherent stresses 11

23 Inspection and testing 11

24 Quality requirements 11

25 Non-conformance and corrective actions 11

26 Distortion 11

27 Post weld heat treatment 11

28 Surface cleaning and treatment 11

Annex A (normative) Quality requirements 12

A.1 General 12
A.2 Requirements for fusion welding 12

Annex B (informative) Welding technology for cast iron castings 20

B.1 General 20
B.2 Preparation for welding 20
B.3 Backing bar 20
B.4 Heat and temperature distribution 20

Bibliography 24