

ISO 15614-7:2007-06 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 7: Overlay welding

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	2
4	Preliminary welding procedure specification (pWPS)	2
4.1	Overlay welding	2
4.2	Hardfacing	2
4.3	Building-up	3
4.4	Buttering	3
5	Welding procedure test	3
6	Test piece	3
6.1	Shape and dimensions of test pieces	3
6.2	Welding of test pieces	5
7	Examination and testing	6
7.1	Extent of testing	6
7.2	Non-destructive testing (NDT)	6
7.3	Location and taking of test specimens	6
7.4	Destructive testing	8
7.5	Acceptance criteria	10
7.6	Retesting	11
8	Range of qualification	11
8.1	General	11
8.2	Qualification related to the manufacturer	11
8.3	Qualification related to the material	12
8.4	Qualification related to the filler material/overlay	13
8.5	Common to welding procedures	14
8.6	Specific to welding processes	15
9	Welding procedure qualification record (WPQR)	17
Annex A (informative)	Welding procedure qualification record form (WPQR)	18
Bibliography		21