ISO 11745:2010-07 (E)

Brazing for aerospace applications - Qualification test for brazers and brazing operators - Brazing of metallic components

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Terms and definitions 1

4 Requirements for the brazing coordinator 2

5 Conditions required for brazer and brazing operator qualification tests 3

6 Qualification test requirements 3
6.1 Brazing processes 3
6.2 Material 3
6.3 Material thickness 4
6.4 Brazing position 4
6.5 Filler material 4

7 Special qualification tests 4
7.1 General requirements 4
7.2 Special qualification tests for brazers 5
7.3 Special qualification tests for brazing operators 5

8 Designation for qualification test 5

9 Performing the brazer and brazing operator qualification test 6
9.1 General 6
9.2 Theory test 6
9.3 Practical testing 6

10 Examination and testing 8
10.1 General 8
10.2 Visual and dimensional examination 8
10.3 Peel test 9
10.4 Radiographic examination 9
10.5 Metallographic examination 9

11 Acceptance criteria 9
11.1 General 9
11.2 Brazer qualification test 9
11.3 Brazing operator qualification test 9

12 Qualification test certificate 10

13 Period of validity of the qualification 10

14 Requalification test 10

Annex A (informative) Brazer qualification test record according to this International Standard 11

Annex B (informative) Brazing operator qualification test record according to this International Standard 12

Annex C (informative) Brazer qualification test certificate 13

Annex D (informative) Brazing operator qualification test certificate 14

Annex E (informative) Guidelines for the theory test 16

Bibliography 17