

ISO 15614-14:2013-06 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 14: Laser-arc hybrid welding of steels, nickel and nickel alloys

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	2
4	Preliminary welding procedure specification	2
5	Welding procedure test	3
6	Test piece	3
6.1	General	3
6.2	Shape and dimensions of test pieces	3
6.3	Welding of test pieces	4
7	Examination and testing	8
7.1	Extent of examination and testing	8
7.2	Location and taking of test specimens	9
7.3	Non-destructive testing	14
7.4	Destructive testing	14
7.5	Quality levels	16
7.6	Re-testing	17
8	Range of qualification	17
8.1	General	17
8.2	Related to the manufacturer	17
8.3	Related to the parent material	17
8.4	Related to welding process	21
8.5	Related to welding position	21
8.6	Related to type of joint or weld	21
8.7	Related to number of layers	21
8.8	Related to filler material	21
8.9	Related to type of current	21
8.10	Related to preheating and interpass temperature	21
8.11	Related to post-weld heat treatment	21
8.12	Nominal heat input	22
8.13	Duration of validity	22
9	Welding procedure qualification record (WPQR)	22
Annex A (informative)	Welding procedure qualification record template (WPQR)	23
Bibliography		24