

ISO 15614-8:2016-03 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 8: Welding of tubes to tube-plate joints

Contents		Page
Foreword		v
Introduction		vii
1	Scope	1
2	Normative references	1
3	Terms and definitions	2
4	Symbols and abbreviated terms	2
5	Preliminary welding procedure specification (pWPS)	3
5.1	General	3
5.2	Parameters for all welding process	3
5.3	Parameters for particular welding processes	4
6	Qualification of welding procedure	5
7	Welding of test pieces	5
7.1	General	5
7.2	Type of test piece	5
7.2.1	Joint preparation and joint construction	5
7.2.2	Tube ends welded on triangular pitch	5
7.2.3	Tube ends welded on square pitch	6
8	Examination and testing	7
8.1	Performance	7
8.1.1	General	7
8.1.2	Visual testing	7
8.1.3	Penetrant testing	8
8.1.4	Radiographic testing	8
8.1.5	Macroscopic examination	8
8.1.6	Hardness test	8
8.1.7	Push-out or pull-out test	8
8.2	Acceptance levels	9
8.2.1	General	9
8.2.2	Visual testing	9
8.2.3	Penetrant testing	9
8.2.4	Radiographic testing	9
8.2.5	Macroscopic examination	10
8.2.6	Hardness values	10
8.2.7	Push-out or pull-out load	10
8.3	Re-test	10
9	Range of qualification	11
9.1	General	11
9.2	Related to the manufacturer	11
9.3	Related to the material	11
9.3.1	Parent metal	11
9.3.2	Tube-plate and tube dimensions	11

9.3.3	Tube pitch	11
9.4	Common to all welding procedures	11
9.4.1	Welding process	11
9.4.2	Welding position of tube-plate	11
9.4.3	Type of joint	11
9.4.4	Filler metal, classification	12
9.4.5	Filler metal, dimensions	12
9.4.6	Type of current	12
9.4.7	Arc energy (heat input)	12
9.4.8	Pre-heat temperature	12
9.4.9	Interpass temperature	12
9.4.10	Post-weld heat treatment	12
9.4.11	Shielding gas	12
10	Welding procedure qualification record form (WPQR)	12
Annex A (informative) Welding procedure qualification record form for tube to tube-plate joints (WPQR)		14
Bibliography		18