ISO 18785-5:2018 (E)

Friction stir spot welding — Aluminium — Part 5: Quality and inspection requirements

Contents

Foreword

Introduction

1 Scope

2 Normative references

3 Terms and definitions

4 Quality requirements

4.1 General
4.2 Welding personnel
4.2.1 General
4.2.2 Weld setter and welding operator
4.3 Inspection and testing personnel
4.3.1 General
4.3.2 Personnel performing non-destructive testing and visual testing
4.3.3 Destructive testing personnel
4.4 Equipment
4.4.1 Suitability of equipment
4.4.2 Equipment acquisition
4.4.3 Validation tests for qualified machine welding settings
4.4.4 Equipment maintenance
4.5 Welding procedure specification (WPS)
4.6 Friction stir spot welding tool
4.6.1 Identification
4.6.2 FSSW tool inspection
4.7 Pre-weld joint preparation and fit-up
4.7.1 Joint preparation
4.7.2 Pre-weld cleaning
4.8 Thermal control
4.9 Welding
4.10 Post-weld heat treatment
4.11 Inspection and testing
4.11.1 General
4.11.2 Inspection and testing before welding
4.11.3 Inspection and testing during welding
4.11.4 Inspection and testing after welding
4.11.4.1 General
4.11.4.2 Visual testing
4.11.4.3 Penetrant testing
4.11.4.4 Radiographic testing
4.11.4.5 Ultrasonic testing
4.11.4.6 Peel and/or chisel
4.11.4.7 Tensile shear testing
4.11.4.8 Cross tension testing
4.11.4.9 Hardness testing
4.11.4.10 Other destructive tests
4.11.5 Damaged and non-conforming welds
4.11.6 Weld flash correction
4.12 Identification and traceability

Annex A (normative) Imperfections, testing and examination