

DIN EN ISO 15609-2:2019-12 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 2: Gas welding (ISO 15609 -2:2019)

Contents		Page
European foreword	3
Foreword	4
Introduction	5
1	Scope	6
2	Normative references	6
3	Terms and definitions	6
4	Technical content of Welding Procedure Specification (WPS)	6
4.1	General	6
4.2	Information related to the manufacturer	7
4.3	Information related to the parent material	7
4.3.1	Parent material type	7
4.3.2	Material dimensions	7
4.4	Information common to all welding procedures	7
4.4.1	Welding process	7
4.4.2	Joint design	7
4.4.3	Welding position	7
4.4.4	Joint preparation	7
4.4.5	Welding technique	7
4.4.6	Back gouging	8
4.4.7	Backing	8
4.4.8	Welding consumables	8
4.4.9	Flame parameters	8
4.4.10	Mechanized and automatic welding	8
4.4.11	Pre-heat temperature	8
4.4.12	Interpass temperature	8
4.4.13	Pre-heat maintenance temperature	8
4.4.14	Post-weld heat-treatment	9
Annex A (informative)	Welding Procedure Specification (WPS)	10
Bibliography	11