

DIN EN ISO 18785-4:2021-03 (E)

Friction stir spot welding - Aluminium - Part 4: Specification and qualification of welding procedures (ISO 18785-4:2018)

| Contents | | Page |
|-------------------------|---|-------------|
| European foreword | | 4 |
| Foreword | | 5 |
| Introduction | | 6 |
| 1 | Scope | 8 |
| 2 | Normative references | 8 |
| 3 | Terms and definitions | 8 |
| 4 | Development and qualification of welding procedures | 9 |
| 4.1 | General | 9 |
| 4.2 | Technical content of a pWPS | 9 |
| 4.2.1 | Manufacturer information | 9 |
| 4.2.2 | Composition of parent material | 9 |
| 4.2.3 | Dimensions of material | 9 |
| 4.2.4 | Welding method | 9 |
| 4.2.5 | Machine specifications | 10 |
| 4.2.6 | Tool identification | 10 |
| 4.2.7 | Clamping processes and conditions | 10 |
| 4.2.8 | Joint design | 10 |
| 4.2.9 | Joint preparation and cleaning methods | 10 |
| 4.2.10 | Welding technique | 10 |
| 4.2.11 | Post-weld processing | 10 |
| 5 | Qualification based on a welding procedure test | 11 |
| 5.1 | General | 11 |
| 5.2 | Standardized test piece | 11 |
| 5.3 | Welding of components, subscale test components or test specimens | 11 |
| 6 | Examination and testing | 11 |
| 6.1 | Visual testing | 11 |
| 6.1.1 | General | 11 |
| 6.1.2 | Re-testing | 11 |
| 6.2 | Destructive testing | 11 |
| 6.2.1 | General | 11 |
| 6.2.2 | Re-testing | 11 |
| 6.3 | Macrosection | 12 |
| 6.4 | Range of qualification | 12 |
| 6.4.1 | General | 12 |
| 6.4.2 | Related to the manufacturer | 12 |
| 6.4.3 | Related to the material | 12 |
| 6.4.4 | Common to all welding procedures | 12 |
| 6.4.5 | Other variables | 13 |
| 7 | Qualification based on pre-production welding test | 13 |
| 7.1 | General | 13 |
| 7.2 | Test pieces | 13 |
| 7.3 | Examination and testing of test pieces | 13 |

| | | |
|------------|---|-----------|
| 7.4 | Range of qualification | 13 |
| 7.5 | Welding procedure qualification record | 13 |
| | Annex A (informative) Example format for a welding procedure specification | 14 |
| | Annex B (informative) Additional variables to be considered in WPS's for FSSW variants | 15 |
| | Annex C (informative) Example welding procedure qualification record forms | 16 |
| | Bibliography | 19 |