ISO 15614-12:2021-10 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 12: Spot, seam and projection welding

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Terms and definitions 2

4 Preliminary welding procedure specification (pWPS) 2

5 Welding procedure test 2

6 Test piece 2
6.1 General 2
6.2 Shape and dimensions of test pieces and test specimens for destructive testing 2
6.2.1 General 2
6.2.2 Macrosection 2
6.3 Welding of components, test pieces or test specimens 3

7 Examination and testing 3
7.1 Extent of testing 3
7.2 Location and cutting of test specimens 4
7.3 Visual testing 5
7.4 Re-testing 5

8 Range of qualification 5
8.1 General 5
8.2 Related to the manufacturer 5
8.3 Related to the material 5
8.4 Common to all welding procedures 6
8.4.1 Welding process 6
8.4.2 Type of current 6
8.4.3 Welding cycle 6
8.4.4 Pre-/Postweld heat treatment 6
8.4.5 Type of weld equipment 6
8.4.6 Welding electrodes 6

9 Welding procedure qualification record form (WPQR) 6

Bibliography 7