

DIN EN ISO 13585:2024-09 (E)

Brazing - Qualification testing of brazers and brazing operators (ISO 13585:2021)

Contents	Page
European foreword	3
Annex ZA (informative) Relationship between this European Standard and the essential requirements of EU Directive 2014/68/EU aimed to be covered	4
Foreword	6
1 Scope	7
2 Normative references	7
3 Terms and definitions	8
4 Symbols and abbreviated terms	9
5 Essential variables and range of qualification	10
5.1 General	10
5.2 Brazing process	11
5.3 Brazer qualification	11
5.3.1 Product type	11
5.3.2 Type of joint	11
5.3.3 Parent material group(s)	11
5.3.4 Filler metals and brazing filler application	12
5.3.5 Dimensions	12
5.3.6 Filler metal flow direction	13
5.4 Brazing operator qualification	13
5.4.1 Type of equipment	13
5.4.2 Filler metals and brazing filler application	13
6 Examination and testing	13
6.1 Supervision	13
6.2 Brazing conditions	14
6.3 Test piece	14
6.4 Assessment of work pieces	14
6.5 Extent of testing	14
6.6 Visual testing	14
6.7 Non-destructive testing	15
6.8 Destructive testing	15
6.9 Additional examination and testing	15
7 Acceptance requirements for test pieces	15
8 Re-tests	15
9 Period of validity	16
9.1 Initial qualification	16
9.2 Prolongation	16
10 Certificate	16
11 Designation	17
Annex A (informative) Quality requirements for brazing	18
Annex B (informative) Brazer qualification test certificate	19
Annex C (informative) Brazing operator qualification test certificate	21
Annex D (informative) Other non-essential variables	22
Annex E (normative) Material grouping system	23
Annex F (informative) Examples of test pieces	25
Bibliography	27