

ISO 15614-9:2025-11 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 9: Underwater hyperbaric wet welding

Contents

Page

Foreword.....	v
Introduction.....	vi
1 Scope.....	1
2 Normative references.....	1
3 Terms and definitions.....	2
4 Qualification of welding procedure specifications.....	3
4.1 General.....	3
4.2 Related to the parent material.....	4
4.2.1 Parent material grouping.....	4
4.3 Welding procedure qualification record (WPQR).....	5
4.4 Welding procedure specification (WPS).....	5
5 Classification of Welds.....	5
5.1 Definitions of weld quality levels.....	5
5.2 Selection of the weld quality level.....	6
6 Welding variables and range of qualification.....	6
7 Depth limitations.....	7
8 Welding procedure test.....	8
9 Test piece.....	8
9.1 General.....	8
9.2 Shape and dimensions of test pieces.....	8
9.3 Welding of test pieces.....	12
10 Testing and examination.....	13
10.1 General.....	13
10.2 Tensile shear tests for fillet welds.....	13
10.3 Type and extent of testing.....	13
10.4 Weld quality Levels A, B and Z.....	13
10.5 Location of test specimens.....	17
10.6 Non-destructive testing.....	25
10.7 Destructive testing.....	25
10.7.1 Transverse tensile test.....	25
10.7.2 Fillet weld shear-strength test.....	25
10.7.3 All-weld metal tensile test.....	26
10.7.4 Bend test.....	26
10.7.5 Macroscopic examination.....	27
10.7.6 Hardness testing.....	27
10.7.7 Impact testing.....	27
10.7.8 Fillet weld fracture test.....	28
10.8 Type and extent of testing for project specific test pieces.....	28
11 Acceptance requirements for test pieces.....	28
12 Re-testing.....	34
12.1 General.....	34
12.2 Hardness testing.....	34
12.3 Impact testing.....	34

13	Range of qualification	34
13.1	General.....	34
13.2	Range of qualification for welding positions.....	34
Annex A	(informative) Different phases in welding procedure qualification	36
Annex B	(informative) Branch connections	37
Annex C	(informative) Example welding procedure qualification record (WPQR)	38
Bibliography	42