DIN EN ISO 15614-6:2007-01 (E)

Specification and qualification of welding procedures for metalli c materials - Welding procedure test - Part 6: Arc and gas welding of copper and its alloys (ISO 15614-6:2006)

Contents

Page

Foreword 3

Introduction 4

1 Scope 5

2 Normative references 5

3 Terms and definitions 6

4 Welding processes 6

5 Preliminary welding procedure specification (pWPS) 6

6 Welding procedure test 7

7 Test piece 7
7.1 General 7
7.2 Shape and dimensions of test pieces 7
7.3 Welding of test pieces 8

8 Examination and testing 11
8.1 Extent of testing 11
8.2 Location and taking of test specimens 12
8.3 Non-destructive testing 12
8.4 Destructive testing 16
8.5 Acceptance levels 17
8.6 Re-testing 17

9 Range of qualification 18
9.1 General 18
9.2 Related to the manufacturer 18
9.3 Related to the parent material 18
9.4 Common to all welding procedures 20
9.5 Specific to processes 22

10 Welding procedure qualification record (WPQR) 22

Annex A (informative) Welding Procedure Qualification Record form (WPQR) 23

Annex ZA (informative) Relationship between this International Standard and the Essential Requirements of EU Directive 97/05/IEC 26

Bibliography 27