

Table of contents

European Foreword	6
1 Scope	7
2 Normative references	8
3 Terms, definitions and abbreviated terms	11
3.1 Terms from other standards.....	11
3.2 Terms specific to the present standard	11
3.3 Abbreviated terms.....	15
3.4 Conventions.....	16
3.5 Nomenclature	16
3.5.1 Formal verbs	16
4 Principles	18
4.1 General.....	18
4.2 Classification of weld safety classes	20
4.2.1 Overview.....	20
4.2.2 Safety Class 1.....	20
4.2.3 Safety Class 2.....	20
4.2.4 Safety Class 3.....	20
4.3 Weld sensitivity levels.....	20
4.4 Tailoring of the weld acceptance criteria	20
5 Welding design	21
5.1 Design of Welded Connections.....	21
5.2 Acceptable joints design	21
6 Welding and inspection personnel	22
6.1 Welding supervisor	22
6.2 Qualification and certification of welders and welding operators	22
6.2.1 Validity limits for operator qualification	22
6.2.2 Manual arc welding	23
6.2.3 Mechanised fusion and resistance welding	23
6.2.4 Mechanised friction stir welding.....	23

6.3	Qualification and certification of welding inspectors	23
6.4	Clothing requirements.....	23
7	Equipment and facilities	25
7.1	Qualification of the welding equipment.....	25
7.1.1	General requirements	25
7.1.2	Specific requirements.....	25
7.2	Maintenance and repair of the welding equipment.....	26
7.3	Materials and consumables	26
7.3.1	Base materials	26
7.3.2	Filler materials.....	27
7.3.3	Shielding and backing gas	27
7.3.4	Tooling and fixtures.....	28
8	Welding procedure specification (WPS).....	29
8.1	Requirements applicable to all processes	29
8.1.1	General.....	29
8.1.2	Drawings.....	29
8.1.3	Welding process	29
8.1.4	Weld preparation.....	29
8.1.5	Cleanliness prior to welding	30
8.1.6	Tack welds.....	30
8.1.7	Backing and shielding gas.....	30
9	Weld inspection	31
9.1	Non-destructive techniques	31
9.1.1	General.....	31
9.1.2	Visual and dimensional examination	31
9.1.3	Penetrant inspection	34
9.1.4	Radiographic testing	34
9.1.5	Ultrasonic inspection.....	34
9.1.6	X-ray tomography inspection (CT scan).....	35
9.2	Destructive testing	35
9.2.1	Metallographic measurement.....	35
9.2.2	Hardness measurement.....	36
9.2.3	Tensile test	36
9.2.4	Other tests	36
10	Weld acceptance criteria.....	37
10.1	General.....	37

10.2	Outer features for fusion welds	37
10.3	Inner features for fusion welds	43
10.4	Features for friction stir welds	46
11	Welding process verification.....	48
11.1	Weld Samples	48
11.1.1	General.....	48
11.1.2	Safety Classes 1 and 2: assessment of weld samples	48
11.1.3	Safety Class 3: assessment of weld samples	49
11.2	Verification acceptance criteria	49
11.3	Delta verification	49
11.3.1	General.....	49
11.3.2	Safety Classes 1 and 2: delta verification.....	50
11.3.3	Safety Class 3: delta verification	50
11.4	Re-weld, in process correction.....	50
11.5	Repair welding.....	51
11.6	Documentation	51
12	Flight hardware production	53
12.1	Documentation	53
12.2	Requirements for flight hardware welding	53
12.2.1	General.....	53
12.2.2	Drawings.....	54
12.2.3	Extent of testing to support flight hardware production	54
13	Quality assurance.....	56
13.1	Maintenance of WPS.....	56
13.2	Quality control.....	56
13.2.1	Reference samples	56
13.2.2	Documentation of weld parameters.....	57
13.2.3	Anomalies and nonconformances occurring during the welding process	57
13.2.4	Inspection and test methods	57
Annex A	(normative) Welding Procedure Specification (WPS) - DRD	58
A.1.1	Requirement identification and source document.....	58
A.1.2	Purpose and objective.....	58
A.2	Expected response	58
A.2.1	Scope and content	58
A.2.2	Special remarks	67

Annex B (normative) Welding Verification Test Plan (WVTP) - DRD	68
B.1 DRD identification.....	68
B.1.1 Purpose and scope	68
B.2 Expected response.....	68
B.2.1 Scope and content.....	68
B.2.2 Special remarks	69
Annex C (informative) Inner defect calculation	70
Bibliography.....	71

Figures

Figure 4-1 Flow chart showing the steps required to produce a verified weld process and flight hardware.....	19
Figure 9-1: Discoloration of the inside of austenitic stainless steel tubes.....	33

Tables

Table 7-1: Acceptable gas purity levels	27
Table 7-2: Recommended shielding gases for welding.....	27
Table 9-1: Colour acceptance criteria for titanium fusion welds	32
Table 9-2: Examples of weld discoloration for titanium fusion welds (for information only).....	33
Table 10-1: Outer features for fusion welds	38
Table 10-2: Inner Features for Fusion Welds.....	43
Table 10-3: Features for friction stir welds	46
Table 11-1: Minimum acceptable amount of testing for manual arc welding	49
Table 11-2: Minimum acceptable amount of testing for all mechanised welding processes class 1 and 2 welds.....	49
Table 11-3: Minimum acceptable amount of testing for class 1 and 2 welds (all processes)	50
Table 12-1: Dew point conditions for welding	54
Table 12-2: Tests to be performed on parts performed during production of flight hardware	55