

DIN EN ISO 11970:2026-04 (E)

Specification and qualification of welding procedures for production welding of steel and nickel-base castings (ISO 11970:2025)

Contents

	Page
Foreword.....	iv
Introduction.....	v
1 Scope.....	1
2 Normative references.....	1
3 Terms, definitions and symbols.....	2
3.1 Terms and definitions.....	2
4 Preliminary welding procedure specification (pWPS).....	2
5 Welding procedure qualification.....	2
6 Test piece.....	2
6.1 General.....	2
6.2 Shape and dimensions of test piece.....	2
6.3 Welding of the test piece.....	3
7 Examination and testing.....	4
7.1 Extent of testing.....	4
7.2 Location and cutting of test specimens.....	5
7.3 Non-destructive testing.....	5
7.4 Destructive test.....	6
7.4.1 Transverse (to weld groove) tensile test.....	6
7.4.2 Macro examination.....	6
7.4.3 Micro examination.....	6
7.4.4 Impact test.....	6
7.4.5 Hardness test.....	7
7.5 Qualification and retesting.....	7
7.6 Welder qualification.....	8
8 Range of qualification.....	8
8.1 General.....	8
8.2 Related to the manufacturer.....	8
8.3 Related to the material.....	8
8.3.1 Parent metal — Grouping system for cast steel grades.....	8
8.3.2 Parent metal thickness.....	9
8.4 Common to all welding procedures.....	9
8.4.1 Welding process.....	9
8.4.2 Welding positions.....	10
8.4.3 Type of joint.....	10
8.4.4 Filler metal.....	10
8.4.5 Type of current.....	10
8.4.6 Heat input.....	11
8.4.7 Preheat temperature.....	11
8.4.8 Interpass temperature.....	11
8.4.9 Post-weld heat treatment.....	11
8.5 Specific to process.....	11
9 Welding procedure qualification record (WPQR).....	12
Annex A (informative) Record form (WPQR) welding procedure qualification — Test certificate.....	13
Annex B (normative) Details of weld testing.....	14
Bibliography.....	17