

DIN EN ISO 25239-5:2012-03 (E)

Friction stir welding - Aluminium - Part 5: Quality and inspection requirements (ISO 25239-5:2011)

Contents		Page
Foreword		3
Introduction		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	6
4	Quality requirements	6
4.1	General	6
4.2	Welding personnel	6
4.3	Inspection and testing personnel	6
4.4	Equipment	6
4.5	Welding procedure specification	7
4.6	Friction stir welding tool	8
4.7	Preweld joint preparation and fit-up	8
4.8	Preheating and interpass temperature control	8
4.9	Tack welds	8
4.10	Welding	8
4.11	Postweld heat treatment	8
4.12	Inspection and testing	8
4.13	Identification and traceability	10
Annex A (normative) Imperfections, testing and examination, acceptance levels, and ISO 6520-1 reference number		11
Bibliography		13