

DIN EN ISO 15614-1:2012-06 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys (ISO 15614-1:2004 + Amd 1:2008 + Amd 2:2012) (includes Amendments A1:2008 + A2: 2012)

| Contents | | Page |
|---|--|-------------|
| Introduction | | 5 |
| 1 | Scope | 5 |
| 2 | Normative references | 6 |
| 3 | Terms and definitions | 7 |
| 4 | Preliminary welding procedure specification (pWPS) | 7 |
| 5 | Welding procedure test | 7 |
| 6 | Test piece | 7 |
| 6.1 | General | 7 |
| 6.2 | Shape and dimensions of test pieces | 7 |
| 6.3 | Welding of test pieces | 8 |
| 7 | Examination and testing | 11 |
| 7.1 | Extent of testing | 11 |
| 7.2 | Location and taking of test specimens | 13 |
| 7.3 | Non-destructive testing | 17 |
| 7.4 | Destructive testing | 17 |
| 7.5 | Acceptance levels | 20 |
| 7.6 | Re-testing | 20 |
| 8 | Range of qualification | 21 |
| 8.1 | General | 21 |
| 8.2 | Related to the manufacturer | 21 |
| 8.3 | Related to the parent material | 21 |
| 8.4 | Common to all welding procedures | 25 |
| 8.5 | Specific to processes | 27 |
| 9 | Welding procedure qualification record (WPQR) | 28 |
| Annex A (informative) Welding Procedure Qualification Record form (WPQR) | | 29 |
| !Annex ZA (normative) Corresponding International and European Standards for which equivalents are not given in the text " | | 32 |
| #Annex ZB (informative) Relationship between this European Standard and the Essential Requirements of EU Pressure Equipment Directive (PED) 97/23/EC\$ | | 33 |
| #Annex ZC (informative) Relationship between this European Standard and the Essential Requirements EU Simple Pressure Vessels Directive (SPVD) 2009/105/EC\$ | | 34 |