

ISO 15620:2019 (E)

Welding — Friction welding of metallic materials

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	Welding knowledge
4.1	Process
4.1.1	General
4.1.2	Direct drive rotational friction welding
4.1.3	Stored energy (inertia) friction welding
4.1.4	Further processes
4.1.5	Friction welding arrangements
4.2	Materials and material combinations
4.3	Friction welding machines
4.3.1	General
4.3.2	Features
5	Quality requirements
5.1	General
5.2	Pre-welding requirements
5.2.1	Condition of raw materials
5.2.2	Preparation of the components to be welded
5.2.3	Component holding
5.3	Post-welding treatment
5.4	Quality assurance
6	Welding procedure specification (WPS)
6.1	General
6.2	Information related to the manufacturer
6.3	Information related to the material
6.4	Welding parameters
6.5	Joint
6.6	Optional devices
7	Welding procedure approval
7.1	Principles
7.2	Welding procedure tests
7.2.1	Application
7.2.2	Preliminary welding procedure specification (pWPS)
7.2.3	Number of test weldments
7.2.4	Specification for test specimens
7.2.4.1	Solid sections — Specimens from bar to bar weldments for bend test
7.2.4.2	Hollow sections
7.2.4.2.1	Specimens from tube to tube weldments for bend test
7.2.4.2.2	Specimens from tube to bar weldments and tube to plate weldments for bend test
7.2.5	Test procedures
7.2.5.1	Bend test
7.2.5.2	Alternative tests
7.2.6	Acceptance criteria

7.3	Welding procedure approval record (WPQR)
7.4	Previous experience
7.5	Circumstances mandating requalification
7.6	Machine-specific nature of a WPS
7.7	Requalification procedure requirements
8	Welding personnel
8.1	Friction welding machine operator
8.2	Friction welding machine setter
8.3	Welding coordination personnel (supervisor)
Annex A	(informative) Relationship of welding parameters
A.1	Welding parameters for direct drive rotational friction welding
A.1.1	General
A.1.2	Friction phase
A.1.3	Deceleration phase
A.1.4	Forge phase
A.2	Welding parameters for stored energy (inertia) friction welding
A.2.1	General
A.2.2	Energy
A.2.3	Axial force
Annex B	(informative) Additional processes based on friction
B.1	Radial friction welding
B.2	Friction stud welding
B.3	Friction surfacing
B.4	Friction taper plug welding
B.5	Friction taper stitch welding
B.6	Friction stir welding
B.7	Friction seam welding
B.8	Friction lap seam welding (the Luc process)
B.9	Friction plunge welding
B.10	Third body friction welding
B.11	Friction co-extrusion cladding
B.12	Friction hydro-pillar processing
B.13	Friction brazing
B.14	Linear friction welding
B.15	Orbital friction welding
B.16	Overlap friction welding
B.17	Friction mash seam welding
B.18	Friction element welding
Annex C	(informative) Material combinations weldable by friction welding
Annex D	(informative) Guidelines for quality assurance
Annex E	(informative) Examination and test
E.1	Non-destructive testing
E.1.1	General
E.1.2	Visual examination
E.1.3	Dimension check
E.1.4	Dye penetration test
E.1.5	Magnetic particle test
E.1.6	Eddy current test
E.1.7	Ultrasonic test
E.2	Destructive testing
E.2.1	General
E.2.2	Tensile test
E.2.3	Impact test
E.2.4	Metallographic examination
E.3	Proof testing
Annex F	(informative) Manufacturer's friction welding procedure specification (WPS)

Annex G (informative) Characteristics of friction welded components

**Annex H (informative) Welding procedure approval record form (WPQR) Welding procedure approval —
Test certificate**

Page count: 40