DIN EN ISO 15614-12:2022-02 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 12: Spot, seam and projection welding (ISO 15614-12:2021)

Contents

Page

European foreword ... **3**

Foreword ... **4**

Introduction ... **5**

1 Scope ... **6**

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 and test specimens for destructive testing ... 7
6.2.1 General ... 7
6.2.2 Macrosection ... 7
6.3 Welding of components, test pieces or test specimens ... 8

7 Examination and testing ... **8**
7.1 Extent of testing ... 8
7.2 Location and cutting of test specimens ... 9
7.3 Visual testing ... 10
7.4 Re-testing ... 10

8 Range of qualification ... **10**
8.1 General ... 10
8.2 Related to the manufacturer ... 10
8.3 Related to the material ... 10
8.4 Common to all welding procedures ... 11
8.4.1 Welding process ... 11
8.4.2 Type of current ... 11
8.4.3 Welding cycle ... 11
8.4.4 Pre-/Postweld heat treatment ... 11
8.4.5 Type of weld equipment ... 11
8.4.6 Welding electrodes ... 11

9 Welding procedure qualification record form (WPQR) ... **11**

Bibliography ... **12**