

DIN ISO 11745:2023-04 (E)

Brazing for aerospace applications - Qualification test for brazers and brazing operators - Brazing of metallic components (ISO 11745:2022)

Contents		Page
National foreword.....		4
National Annex NA (informative) Bibliography		5
Foreword.....		6
Introduction.....		7
1	Scope	8
2	Normative references	8
3	Terms and definitions	8
4	Requirements for the brazing coordinator	10
5	Conditions required for brazer and brazing operator qualification tests	10
6	Qualification test requirements	10
6.1	Brazing processes.....	10
6.2	Material.....	11
6.3	Material thickness.....	11
6.4	Brazing position.....	11
6.5	Filler material.....	11
7	Special qualification tests	12
7.1	General requirements.....	12
7.2	Special qualification tests for brazers.....	12
7.3	Special qualification tests for brazing operators.....	12
8	Designation for qualification test	12
9	Performing the brazer and brazing operator qualification test	13
9.1	General.....	13
9.2	Theory test.....	13
9.3	Practical testing.....	13
9.3.1	General.....	13
9.3.2	Brazer.....	13
9.3.3	Brazing operator.....	14
9.3.4	Test pieces.....	14
10	Examination and testing	15
10.1	General.....	15
10.2	Visual and dimensional examination.....	16
10.3	Peel test.....	16
10.4	Radiographic examination.....	16
10.5	Metallographic examination.....	16
11	Acceptance criteria	17
11.1	General.....	17
11.2	Brazer qualification test.....	17
11.3	Brazing operator qualification test.....	17
12	Qualification test certificate	17
13	Period of validity of the qualification	17
14	Requalification test	18
Annex A (informative) Brazer qualification test record in accordance with this document		19

Annex B (informative) Brazing operator qualification test record in accordance with this document	20
Annex C (informative) Brazer qualification test certificate	21
Annex D (informative) Brazing operator qualification test certificate	22
Annex E (informative) Guidelines for the theory test	24
Bibliography	25