ISO 24394:2023-09 (E)

Welding for aerospace applications - Qualification test for wel ders and welding operators - Fusion welding of metallic components

Contents

Page

Foreword v

Introduction vi

1 Scope 1

2 Normative references 1

3 Terms and definitions 1

4 Qualification test requirements 3
4.1 General 3
4.1.1 Specific to the welder qualification test 3
4.1.2 Specific to the welding operator qualification test 3
4.2 Welding processes 4
4.3 Welding positions 5
4.4 Product types or semi-finished products applicable to welder qualification tests 5
4.5 Material groups 9
4.6 Material thickness 10
4.6.1 Butt weld material thickness 10
4.6.2 Fillet weld material thickness 10
4.6.3 Casting repair material thickness 10
4.7 Special qualification tests 10
4.7.1 General requirements 10
4.7.2 Special qualification tests for welders 10
4.7.3 Special qualification tests for welding operators 11
4.8 Designation for qualification test 11
4.8.1 Welder qualification test 11
4.8.2 Welding operator qualification test 12

5 Conditions required for welder and welding operator qualification tests 12
5.1 Physical requirements for welder and welding operator 12
5.2 Person responsible for welder and welding operator qualification tests 13

6 Performing the welder and welding operator qualification test 13
6.1 Practical qualification test 13
6.1.1 General requirements 13
6.1.2 Specific requirements for the welder qualification test 13
6.2 Theory test 14

7 Test pieces 14

8 Examination and testing 18
8.1 General 18
8.2 Visual inspection and dimensional examination 19
8.3 Surface imperfection detection 19
8.4 Radiographic examination 19
8.5 Metallographic examinations 19
8.6 Bend test 20
8.7 Fracture surface examination 20

9 Acceptance criteria 20

10 Qualification test certificate and documentation 20

11 Period of validity of the qualification 21

12 Requalification test 21

Annex A (normative) Test piece acceptance criteria 22

Annex B (normative) Welder or welding operator qualification test record 27

Annex C (informative) Welder qualification test certificate 28

Annex D (informative) Welding operator qualification test certificate 29

Annex E (informative) Guidelines for the theory test 31

Bibliography 34