

DIN EN ISO 13585:2024-09 (E)

Brazing - Qualification testing of brazers and brazing operators (ISO 13585:2021)

Contents	Page
European foreword	3
Annex ZA (informative) Relationship between this European Standard and the essential requirements of EU Directive 2014/68/EU aimed to be covered	4
Foreword.....	6
1 Scope	7
2 Normative references	7
3 Terms and definitions	8
4 Symbols and abbreviated terms.....	9
5 Essential variables and range of qualification	10
5.1 General.....	10
5.2 Brazing process.....	11
5.3 Brazer qualification	11
5.3.1 Product type.....	11
5.3.2 Type of joint.....	11
5.3.3 Parent material group(s).....	11
5.3.4 Filler metals and brazing filler application	12
5.3.5 Dimensions.....	12
5.3.6 Filler metal flow direction.....	13
5.4 Brazing operator qualification.....	13
5.4.1 Type of equipment.....	13
5.4.2 Filler metals and brazing filler application	13
6 Examination and testing	13
6.1 Supervision.....	13
6.2 Brazing conditions	14
6.3 Test piece	14
6.4 Assessment of work pieces.....	14
6.5 Extent of testing.....	14
6.6 Visual testing.....	14
6.7 Non-destructive testing.....	15
6.8 Destructive testing.....	15
6.9 Additional examination and testing.....	15
7 Acceptance requirements for test pieces	15
8 Re-tests.....	15
9 Period of validity	16
9.1 Initial qualification.....	16
9.2 Prolongation.....	16
10 Certificate.....	16
11 Designation.....	17
Annex A (informative) Quality requirements for brazing	18
Annex B (informative) Brazer qualification test certificate.....	19
Annex C (informative) Brazing operator qualification test certificate	21
Annex D (informative) Other non-essential variables	22
Annex E (normative) Material grouping system.....	23
Annex F (informative) Examples of test pieces.....	25
Bibliography.....	27