

DIN EN ISO 17779:2026-02 (E)

Brazing - Specification and qualification of brazing procedures for metallic materials (ISO 17779:2021)

Contents	Page
Foreword.....	iv
Introduction.....	v
1 Scope.....	1
2 Normative references.....	1
3 Terms and definitions.....	2
4 Preliminary brazing procedure specification (pBPS).....	3
5 Brazing procedure test.....	3
6 Test piece.....	3
6.1 General.....	3
6.2 Shape and dimensions of test pieces.....	3
6.3 Brazing of test pieces.....	4
7 Examination and testing.....	4
7.1 Extent of testing.....	4
7.2 Test specimens.....	5
7.3 Non-destructive testing.....	5
7.4 Destructive testing.....	5
7.4.1 General.....	5
7.4.2 Bend testing.....	5
7.4.3 Peel testing.....	5
7.4.4 Shear testing.....	5
7.4.5 Transverse tensile testing.....	6
7.5 Acceptance levels.....	6
7.6 Re-testing.....	6
8 Essential variables and range of qualification.....	6
8.1 General.....	6
8.2 Brazing process.....	6
8.3 Product type.....	6
8.4 Type of joint.....	7
8.5 Branch connection.....	7
8.6 Parent material group(s).....	7
8.7 Filler metals, flux and brazing filler application.....	8
8.8 Dimensions.....	8
8.9 Filler metal flow direction.....	8
8.10 Post braze heat treatment.....	9
8.11 Related to the manufacturer.....	9
9 Brazing procedure qualification record (BPQR).....	9
10 Brazing procedure specification (BPS).....	9
Annex A (informative) Quality requirements for brazing.....	11
Annex B (informative) Brazing procedure specification (BPS).....	12
Annex C (informative) Examples of test pieces.....	13
Annex D (informative) Brazing procedure qualification record (BPQR).....	15
Annex E (normative) Material grouping system.....	16