

DIN EN ISO 15614-2:2025-12 (E)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 2: Arc welding of aluminium and its alloys (ISO 15614-2:2025)

| Contents | | Page |
|-------------------|--|-------------|
| Foreword..... | | v |
| Introduction..... | | vi |
| 1 | Scope | 1 |
| 2 | Normative references | 1 |
| 3 | Terms and definitions | 2 |
| 4 | Preliminary welding procedure specification | 3 |
| 5 | Welding procedure test | 3 |
| 6 | Test piece | 3 |
| 6.1 | General..... | 3 |
| 6.2 | Shape and dimensions of test pieces..... | 3 |
| 6.2.1 | General..... | 3 |
| 6.2.2 | Butt joint in plate with full penetration..... | 3 |
| 6.2.3 | Butt joint in pipe with full penetration..... | 4 |
| 6.2.4 | T-joint..... | 5 |
| 6.2.5 | Branch connection and fillet weld on pipe..... | 5 |
| 6.3 | Welding of test pieces..... | 6 |
| 7 | Examination and testing | 6 |
| 7.1 | Extent of testing..... | 6 |
| 7.2 | Non-destructive testing..... | 7 |
| 7.3 | Location of destructive test specimens..... | 7 |
| 7.4 | Destructive testing..... | 11 |
| 7.4.1 | General..... | 11 |
| 7.4.2 | Transverse tensile test..... | 11 |
| 7.4.3 | Bend test..... | 12 |
| 7.4.4 | Fracture test..... | 13 |
| 7.4.5 | Macroscopic or microscopic examination..... | 13 |
| 7.5 | Acceptance levels..... | 13 |
| 7.6 | Re-testing..... | 14 |
| 7.6.1 | General..... | 14 |
| 7.6.2 | Related to NDT..... | 14 |
| 7.6.3 | Related to destructive testing..... | 14 |
| 8 | Range of qualification | 14 |
| 8.1 | General..... | 14 |
| 8.2 | Related to the manufacturer..... | 14 |
| 8.3 | Related to the parent material..... | 15 |
| 8.3.1 | Parent material grouping..... | 15 |
| 8.3.2 | Parent material thickness and pipe diameter..... | 16 |
| 8.3.3 | Angle of branch connection..... | 18 |
| 8.4 | Common to all welding procedures..... | 18 |
| 8.4.1 | Welding process..... | 18 |
| 8.4.2 | Welding positions..... | 18 |
| 8.4.3 | Type of joint..... | 18 |
| 8.4.4 | Filler metal..... | 20 |
| 8.4.5 | Type of current..... | 20 |
| 8.4.6 | Arc energy or heat input..... | 20 |
| 8.4.7 | Preheat temperature..... | 20 |

| | | |
|----------|---|-----------|
| 8.4.8 | Interpass temperature..... | 20 |
| 8.4.9 | Post-weld heat treatment or ageing | 20 |
| 8.5 | Specific to processes..... | 20 |
| 8.5.1 | Process 131 | 20 |
| 8.5.2 | Processes 141 and 142..... | 21 |
| 8.5.3 | Process 15 | 21 |
| 9 | Welding procedure qualification record (WPQR)..... | 21 |
| | Annex A (informative) Example welding procedure qualification record (WPQR) form | 22 |
| | Bibliography..... | 26 |