DIN EN 16602-70-39:2019-02 (E)

Space product assurance - Welding of metallic materials for flight hardware; English version EN 16602-70-39:2018

Table of contents

European Foreword 6

1 Scope 7

2 Normative references 8

3 Terms, definitions and abbreviated terms 11

3.1 Terms from other standards 11

3.2 Terms specific to the present standard 11

3.3 Abbreviated terms 15

3.4 Conventions 16

3.5 Nomenclature 16

3.5.1 Formal verbs 16

4 Principles 18

4.1 General 18

4.2 Classification of weld safety classes 20

4.2.1 Overview 20

4.2.2 Safety Class 1 20

4.2.3 Safety Class 2 20

4.2.4 Safety Class 3 20

4.3 Weld sensitivity levels 20

4.4 Tailoring of the weld acceptance criteria 20

5 Welding design 21

5.1 Design of Welded Connections 21

5.2 Acceptable joints design 21

6 Welding and inspection personnel 22

6.1 Welding supervisor 22

6.2 Qualification and certification of welders and welding operators 22

6.2.1 Validity limits for operator qualification 22

6.2.2 Manual arc welding 23

6.2.3 Mechanised fusion and resistance welding 23

6.2.4 Mechanised friction stir welding 23

6.3 Qualification and certification of welding inspectors 23
6.4 Clothing requirements 23

7 Equipment and facilities 25

7.1 Qualification of the welding equipment 25
7.1.1 General requirements 25
7.1.2 Specific requirements 25
7.2 Maintenance and repair of the welding equipment 26
7.3 Materials and consumables 26
7.3.1 Base materials 26
7.3.2 Filler materials 27
7.3.3 Shielding and backing gas 27
7.3.4 Tooling and fixtures 28

8 Welding procedure specification (WPS) 29

8.1 Requirements applicable to all processes 29
8.1.1 General 29
8.1.2 Drawings 29
8.1.3 Welding process 29
8.1.4 Weld preparation 29
8.1.5 Cleanliness prior to welding 30
8.1.6 Tack welds 30
8.1.7 Backing and shielding gas 30

9 Weld inspection 31

9.1 Non-destructive techniques 31
9.1.1 General 31
9.1.2 Visual and dimensional examination 31
9.1.3 Penetrant inspection 34
9.1.4 Radiographic testing 34
9.1.5 Ultrasonic inspection 34
9.1.6 X-ray tomography inspection (CT scan) 35
9.2 Destructive testing 35
9.2.1 Metallographic measurement 35
9.2.2 Hardness measurement 36
9.2.3 Tensile test 36
9.2.4 Other tests 36

10 Weld acceptance criteria 37

10.1 General 37

10.2 Outer features for fusion welds 37
10.3 Inner features for fusion welds 43
10.4 Features for friction stir welds 46

11 Welding process verification 48
11.1 Weld Samples 48
11.1.1 General 48
11.1.2 Safety Classes 1 and 2: assessment of weld samples 48
11.1.3 Safety Class 3: assessment of weld samples 49
11.2 Verification acceptance criteria 49
11.3 Delta verification 49
11.3.1 General 49
11.3.2 Safety Classes 1 and 2: delta verification 50
11.3.3 Safety Class 3: delta verification 50
11.4 Re-weld, in process correction 50
11.5 Repair welding 51
11.6 Documentation 51

12 Flight hardware production 53
12.1 Documentation 53
12.2 Requirements for flight hardware welding 53
12.2.1 General 53
12.2.2 Drawings 54
12.2.3 Extent of testing to support flight hardware production 54

13 Quality assurance 56
13.1 Maintenance of WPS 56
13.2 Quality control 56
13.2.1 Reference samples 56
13.2.2 Documentation of weld parameters 57
13.2.3 Anomalies and nonconformances occurring during the welding process 57
13.2.4 Inspection and test methods 57

Annex A (normative) Welding Procedure Specification (WPS) - DRD 58
A.1.1 Requirement identification and source document 58
A.1.2 Purpose and objective 58
A.2 Expected response 58
A.2.1 Scope and content 58
A.2.2 Special remarks 67

Annex B (normative) Welding Verification Test Plan (WVTP) - DRD.....68
B.1 DRD identification.....68
B.1.1 Purpose and scope.....68
B.2 Expected response.....68
B.2.1 Scope and content.....68
B.2.2 Special remarks.....69
Annex C (informative) Inner defect calculation.....70
Bibliography.....71

Figures

Figure 4-1 Flow chart showing the steps required to produce a verified weld process and flight hardware.....19
Figure 9-1: Discoloration of the inside of austenitic stainless steel tubes.....33

Tables

Table 7-1: Acceptable gas purity levels.....27
Table 7-2: Recommended shielding gases for welding.....27
Table 9-1: Colour acceptance criteria for titanium fusion welds.....32
Table 9-2: Examples of weld discoloration for titanium fusion welds (for information only).....33
Table 10-1: Outer features for fusion welds.....38
Table 10-2: Inner Features for Fusion Welds.....43
Table 10-3: Features for friction stir welds.....46
Table 11-1: Minimum acceptable amount of testing for manual arc welding.....49
Table 11-2: Minimum acceptable amount of testing for all mechanised welding processes class 1 and 2 welds.....49
Table 11-3: Minimum acceptable amount of testing for class 1 and 2 welds (all processes).....50
Table 12-1: Dew point conditions for welding.....54
Table 12-2: Tests to be performed on parts performed during production of flight hardware.....55