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Welding consumables - Test methods - Part 2:  
Preparation of single-run and two-run technique test  
pieces and specimens in steel (ISO 15792-2:2020)

## EESTI STANDARDI EESSÕNA

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See Eesti standard EVS-EN ISO 15792-2:2020 sisaldab Euroopa standardi EN ISO 15792-2:2020 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 15792-2:2020 consists of the English text of the European standard EN ISO 15792-2:2020.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 16.09.2020.	Date of Availability of the European standard is 16.09.2020.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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ICS 25.160.20

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EUROPEAN STANDARD

EN ISO 15792-2

NORME EUROPÉENNE

EUROPÄISCHE NORM

September 2020

ICS 25.160.20

Supersedes EN ISO 15792-2:2008

English Version

**Welding consumables - Test methods - Part 2: Preparation  
of single-run and two-run technique test pieces and  
specimens in steel (ISO 15792-2:2020)**

Produits consommables pour le soudage - Méthodes  
d'essai - Partie 2: Préparation de pièces d'essai et  
d'éprouvettes en une ou deux passes en acier (ISO  
15792-2:2020)

Schweißzusätze Prüfverfahren - Teil 2: Vorbereitung  
von Prüfstücken und Proben zur Prüfung von Einlagen-  
und Lage/Gegenlage-Schweißungen an Stahl (ISO  
15792 2:2020)

This European Standard was approved by CEN on 29 August 2020.

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This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

## European foreword

This document (EN ISO 15792-2:2020) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by March 2021, and conflicting national standards shall be withdrawn at the latest by March 2021.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 15792-2:2008.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

## Endorsement notice

The text of ISO 15792-2:2020 has been approved by CEN as EN ISO 15792-2:2020 without any modification.

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

This second edition cancels and replaces the first edition (ISO 15792-2:2000), which has been technically revised.

The main changes compared to the previous edition are as follows:

- the title and scope of this document have been changed;
- Clause 10 and Clause 11 have been deleted consequently;
- a new type 2.6 has been added to [Table 1](#) reflecting usage in the USA;
- in [Table 1](#), the angles in column 3, preparation, have been revised to show the bevel angle with a footnote giving tolerances for 2.1, 2.4 and 2.5;
- in [Figure 1 b](#)), effective weld length has been added;
- [Figure 2](#) has been revised and split into [Figure 2a](#) and [Figure 2b](#) with titles showing restrictions for use.

## Introduction

Consumables for both submerged arc welding and metal arc welding with tubular cored electrodes can be suitable for welding by the single- or two-run technique and the methods for testing and classification are specified. When a welding consumable is offered for use by these techniques, it should be noted that all-weld metal test pieces may not be required by the consumable classification standard.

Test conditions prescribed and results required should not be considered to be requirements or expectations for a procedure qualification.

# Welding consumables — Test methods —

## Part 2:

# Preparation of single-run and two-run technique test pieces and specimens in steel

## 1 Scope

This document specifies the preparation of butt weld test pieces and specimens.

The test pieces and specimens are used to determine the strength and impact properties of welded joints when testing welding consumables with single-run and two-run techniques.

This document is applicable to welding consumables for arc welding of steel.

This document is not suitable for electro-slag or electro-gas welding.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 4136:2012, *Destructive tests on welds in metallic materials — Transverse tensile test*

ISO 5178, *Destructive tests on welds in metallic materials — Longitudinal tensile test on weld metal in fusion welded joints*

ISO 9016:2012, *Destructive tests on welds in metallic materials — Impact tests — Test specimen location, notch orientation and examination*

## 3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

## 4 General requirements

Welding consumables to be tested shall be representative of the manufacturer's products to be classified or tested. Test pieces shall be prepared as described below.

## 5 Test plate material

The material to be used shall be in accordance with the appropriate consumable classification standard.