

Welding and allied processes - Joint preparation - Part  
2: Submerged arc welding of steels (ISO 9692-2:2024)

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>See Eesti standard EVS-EN ISO 9692-2:2024 sisaldab Euroopa standardi EN ISO 9692-2:2024 ingliskeelset teksti.</p> <p>Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.</p> <p>Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 13.03.2024.</p> <p>Standard on kättesaadav Eesti Standardimis-ja Akrediteerimiskeskusest.</p>	<p>This Estonian standard EVS-EN ISO 9692-2:2024 consists of the English text of the European standard EN ISO 9692-2:2024.</p> <p>This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation and Accreditation.</p> <p>Date of Availability of the European standard is 13.03.2024.</p> <p>The standard is available from the Estonian Centre for Standardisation and Accreditation.</p>
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English Version

**Welding and allied processes - Joint preparation - Part 2:  
Submerged arc welding of steels (ISO 9692-2:2024)**

Soudage et techniques connexes - Préparation de joints  
- Partie 2: Soudage à l'arc sous flux en poudre des  
aciers (ISO 9692-2:2024)

Schweißen und verwandte Verfahren -  
Schweißnahtvorbereitung - Teil 2:  
Unterpulverschweißen von Stahl (ISO 9692-2:2024)

This European Standard was approved by CEN on 7 January 2024.

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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 9692-2:2024) 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 AFNOR.

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of an identical text or by endorsement, at the latest by September 2024, and conflicting national standards shall be withdrawn at the latest by September 2024.

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 9692-2:1998.

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

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, Türkiye and the United Kingdom.

## Endorsement notice

The text of ISO 9692-2:2024 has been approved by CEN as EN ISO 9692-2:2024 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 document 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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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 7, *Representation and terms*, 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).

This second edition cancels and replaces the first edition (ISO 9692-2:1998), of which it constitutes a minor revision. The changes are as follows:

- [Clause 1](#), fourth paragraph revised and moved to the Introduction;
- ISO 2553, ISO 6947 and ISO 9692-1 moved from [Clause 2](#) to the Bibliography;
- alignment in [Clause 5](#) of the note explaining the reference numbers in [Tables 1](#) and [2](#) with the corresponding text in ISO 9692-3;
- modification of the reference numbers in [Tables 1](#) and [2](#) in accordance with the latest version of ISO 2553 and reordering of the lines of the tables in ascending order of the new reference numbers.

A list of all parts in the ISO 9692 series can be found on the ISO website.

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## Introduction

This document is intended to be used alongside ISO 9692-1. It follows similar rules and the same layout. Therefore, the introduction given in ISO 9692-1 also applies.

ISO 9692-1 specifies joint preparations for other arc welding processes (see ISO 4063), which are applicable when the root is not welded by submerged arc welding.

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# Welding and allied processes — Joint preparation —

## Part 2: Submerged arc welding of steels

### 1 Scope

This document applies to types of joint preparation for submerged arc welding with one wire electrode (process 121 according to ISO 4063) on steel.

This document covers only the welding positions PA and PB according to ISO 6947. If PC is used, special preparation is necessary.

This document applies to fully penetrated welds. For partly penetrated welds, types of joint preparation, shapes and dimensions can differ from the listed proposals if they are specified in the relevant application standard or agreed by the parties concerned.

### 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 15609-1, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 1: Arc welding*

### 3 Terms and definitions

No terms and definitions are listed in this document.

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

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

### 4 Materials

Joint preparations recommended in this document are suitable for all types of weldable steel.

### 5 Types of joint preparation

The recommended types of joint preparation and dimensions are specified in [Table 1](#) and [Table 2](#).

The root gaps referred to in this document are those gaps presented after tack welding, if used.

This document gives no dimensions or type of possibly used backing materials. Root runs may also be used as backing. They may influence the quality requirements for welding (according to the relevant part of the ISO 3834 series) and the preparation as given in [Table 1](#) and [Table 2](#). They shall be part of the welding procedure specification in accordance with ISO 15609-1.