

**Metallide keevitusprotseduuride spetsifitseerimine ja kvalifitseerimine. Keevitusprotseduuri spetsifitseerimine. Osa 1: Kaarkeevitus**

**Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 1: Arc welding (ISO 15609-1:2004)**

<b>EESTI STANDARDI EESSÕNA</b>	<b>NATIONAL FOREWORD</b>
See Eesti standard EVS-EN ISO 15609-1:2004 sisaldab Euroopa standardi EN ISO 15609-1:2004 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 15609-1:2004 consists of the English text of the European standard EN ISO 15609-1:2004.
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Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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**English version**

**Specification and qualification of welding procedures  
for metallic materials**

Welding procedure specification

Part 1: Arc welding

(ISO 15609-1 : 2004)

Descriptif et qualification d'un mode  
opérateur de soudage pour les maté-  
riaux métalliques – Descriptif d'un  
mode opératoire de soudage – Partie 1:  
Soudage à l'arc (ISO 15609-1 : 2004)

Anforderung und Qualifizierung von  
Schweißverfahren für metallische  
Werkstoffe – Schweißanweisung –  
Teil 1: Lichtbogenschweißen  
(ISO 15609-1 : 2004)

This European Standard was approved by CEN on 2004-01-16.

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## Foreword

This document (EN ISO 15609-1:2004) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DIN, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

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of an identical text or by endorsement, at the latest by April 2005, and conflicting national standards shall be withdrawn at the latest by April 2005.

This document supersedes EN 288-2:1992.

NOTE Normative references to International Standards are listed in annex ZA (normative).

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

## 1 Scope

This standard specifies requirements for the content of welding procedure specifications for arc welding processes.

This standard is part of a series of standards, details of this series are given in EN ISO 15607:2003, Annex A.

The variables listed in this standard are those influencing the quality of the welded joint.

## 2 Normative references

The following referenced documents are indispensable for the application 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.

EN 439, *Welding consumables – Shielding gases for arc welding and cutting.*

EN 26848, *Tungsten electrodes for inert gas shielded arc welding and for plasma cutting and welding – Codification.*

EN ISO 4063, *Welding and allied processes – Nomenclature of processes and reference numbers. (ISO 4063:1998)*

EN ISO 6947, *Welds – Working positions - Definitions of angles of slope and rotation. (ISO 6947:1993)*

EN ISO 13916, *Welding – Guidance on the measurement of preheating temperature, interpass temperature and preheat maintenance temperature. (ISO 13916:1996)*

EN ISO 15607:2003, *Specification and qualification of welding procedures for metallic materials – General rules. (ISO 15607:2003)*

CR ISO 15608, *Welding – Guidelines for a metallic material grouping system (ISO/TR 15608:2000).*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN ISO 15607:2003 apply.

## 4 Technical content of welding procedure specification (WPS)

### 4.1 General

A preliminary Welding Procedure Specification/Welding Procedure Specification (pWPS/WPS) shall provide all the necessary information required to make a weld. The information required in a pWPS/WPS is given in 4.2 to 4.5.

NOTE For some applications it may be necessary to supplement or reduce the list.

Welding procedure specifications cover a certain range of material thickness and also cover a range of parent materials and even welding consumables. Some manufacturers prefer additionally to prepare work instructions for each specific job as part of detailed production planning.

Ranges and tolerances, according to the relevant standard of the series (see EN ISO 15607) and to the manufacturer's experience, shall be specified where appropriate.