

**Specification and qualification of welding
procedures for metallic materials -
Qualification based on previous welding
experience**

Specification and qualification of welding procedures
for metallic materials - Qualification based on
previous welding experience

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN ISO 15611:2004 sisaldab Euroopa standardi EN ISO 15611:2003 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 18.05.2004 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN ISO 15611:2004 consists of the English text of the European standard EN ISO 15611:2003.</p> <p>This document is endorsed on 18.05.2004 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

<p>Käsitlusala: This European Standard gives the necessary information to explain the requirements referenced in EN Iso 15607 about the qualification of welding procedures based on previous welding experience.</p>	<p>Scope: This European Standard gives the necessary information to explain the requirements referenced in EN Iso 15607 about the qualification of welding procedures based on previous welding experience.</p>
----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

ICS 25.160.10

Võtmesõnad: arc, experiences, instructions, materials, metal welding, metallic materials, metals, qualifications, quality assurance, specification (approval), specifications, submerged arc welding, testing, testing conditions, welding, welding engineering, welding processes

English version

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

Qualification based on previous welding experience
(ISO 15611 : 2003)

Descriptif et qualification d'un mode
opérateur de soudage pour les
matériaux métalliques – Qualification
sur la base de l'expérience en sou-
dage (ISO 15611 : 2003)

Anforderung und Qualifizierung von
Schweißverfahren für metallische
Werkstoffe – Qualifizierung aufgrund
vorliegender schweißtechnischer
Erfahrung (ISO 15611 : 2003)

This European Standard was approved by CEN on 2003-05-07.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

The European Standards exist 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 Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, the Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland, and the United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Management Centre: rue de Stassart 36, B-1050 Brussels

Contents

	Page
Foreword	3
Introduction	3
1 Scope	4
2 Normative references	4
3 Terms and definitions	5
4 Preliminary welding procedure specifications (pWPS)	5
5 Qualification of the welding procedure	5
6 Existing previous welding experience	5
7 Range of qualification	6
8 Validity	6
9 Welding Procedure Qualification Record (WPQR)	6
Bibliography	6

Foreword

This document (EN ISO 15611:2003) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

This European Standard EN ISO 15611:2003 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 2004, and conflicting national standards shall be withdrawn at the latest by April 2004.

This document supersedes EN 288-6:1994.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association.

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

Introduction

In EN ISO 15607, one of the methods of welding procedure qualification is by relating to previous welding experience.

Many manufacturers have considerable experience in fabricating welded structures. Welded components and structures may have been supplied to end users/clients for a variety of applications and have performed satisfactorily over a period of time in service. If this experience is traceable and documented this standard provides a route to welding procedure qualification based on this experience.

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

1 Scope

This European Standard gives the necessary information to explain the requirements referenced in EN ISO 15607 about the qualification of welding procedures based on previous welding experience.

In addition it gives the range of qualification and the validity.

The use of this European Standard may be restricted by an application standard or a specification.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text, and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

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

prEN ISO 15609-1, *Specification and approval of welding procedures for metallic materials - Welding procedure specification - Part 1: Arc welding (ISO/DIS 15609-1:2000)*.

EN ISO 15609-2, *Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 2: Gas welding (ISO 15609-2:2001)*.

prEN ISO 15609-3, *Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 3: Electron beam welding (ISO/DIS 15609-3:2000)*.

prEN ISO 15609-4, *Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 4: Laser beam welding (ISO/DIS 15609-4:2000)*.

prEN ISO 15609-5, *Specification and approval of welding procedures for metallic materials - Welding procedure specification - Part 5: Resistance welding (ISO/DIS 15609-5:2000)*.

EN ISO 15614-1, *Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys (ISO 15614-1:2003)*.

prEN ISO 15614-2, *Specification and approval of welding procedures for metallic materials - Welding procedure tests - Part 2: Arc welding of aluminium and its alloys (ISO/DIS 15614-2:2000)*.

prEN ISO 15614-3, *Specification and qualification of welding procedures for metallic materials - Welding procedure tests - Part 3: Welding procedure tests for the arc welding of cast iron (was submitted to CEN Enquiry as prEN 288-12)*.

prEN ISO 15614-4, *Specification and qualification of welding procedures for metallic materials - Welding procedure tests - Part 4: Finishing welding of aluminium castings (was submitted to CEN Enquiry as prEN 288-13)*.

prEN ISO 15614-5, *Specification and approval of welding procedures for metallic materials - Welding procedure tests - Part 5: Arc welding of titanium, zirconium and their alloys (ISO/DIS 15614-5:2000)*.

prEN ISO 15614-6, *Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 6: Arc welding of copper and copper alloys*.

EN ISO 15614-8, *Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 8: Welding of tubes to tube-plate joints (ISO 15614-8:2002)*.