

**Keevitusmaterjalid. Katsemeetodid. Osa 2:  
Kontroll-liidete ettevalmistamine terasest ühe ja  
kahe läbimiga keevitatud katsekehadele**

Welding consumables - Test methods - Part 2:  
Preparation of single-run and two-run technique test  
specimens in steel

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN ISO 15792-2:2008 sisaldab Euroopa standardi EN ISO 15792-2:2008 ingliskeelset teksti.</p> <p>Standard on kinnitatud Eesti Standardikeskuse 20.06.2008 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.</p> <p>Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 07.05.2008.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN ISO 15792-2:2008 consists of the English text of the European standard EN ISO 15792-2:2008.</p> <p>This standard is ratified with the order of Estonian Centre for Standardisation dated 20.06.2008 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.</p> <p>Date of Availability of the European standard text 07.05.2008.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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English Version

**Welding consumables - Test methods - Part 2: Preparation of  
single-run and two-run technique test specimens in steel (ISO  
15792-2:2000)**

Produits consommables pour le soudage - Méthodes  
d'essai - Partie 2: Préparation d'éprouvettes en une ou  
deux passes en acier (ISO 15792-2:2000)

Schweißzusätze - Prüfverfahren - Teil 2: Vorbereitung  
eines Prüfstücks zur Prüfung von Einlagen- und  
Lage/Gegenlage-Schweißungen an Stahl (ISO 15792-  
2:2000)

This European Standard was approved by CEN on 5 April 2008.

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COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## Foreword

The text of ISO 15792-2:2000 has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" of the International Organization for Standardization (ISO) and has been taken over as EN ISO 15792-2:2008 by Technical Committee CEN/TC 121 "Welding" 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 November 2008, and conflicting national standards shall be withdrawn at the latest by November 2008.

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### Endorsement notice

The text of ISO 15792-2:2000 has been approved by CEN as a EN ISO 15792-2:2008 without any modification.

## 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 specimens in steel

### 1 Scope

This part of ISO 15792 specifies the preparation of butt weld test pieces and specimens. The purpose is to define test methods in order to determine strength and impact strength of the welded joint when testing welding consumables with single-run and two-run technique, not suitable for electro-slag or electro-gas welding.

This part of ISO 15792 is applicable to welding consumables for arc welding of steel.

### 2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 15792. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 15792 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 4136:2000, *Fusion-welded butt joints in steel — Transverse tensile test*.

ISO 9016:2000, *Destructive tests on welds in metallic materials — Impact tests — Test specimen location, notch orientation and examination*.

ISO 13916, *Welding — Guidance on the measurement of preheating temperature, interpass temperature and preheat maintenance temperature*.

### 3 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.

### 4 Test plate material

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