Keevitusmaterjalid. Katsemeetodid. Osa 3: Keevitusmaterjalide asendiomaduste katsetamine nurkõmbluste korral

Welding consumables - Test methods - Part 3: Classification testing of positional capacity and root penetration of welding consumables in a fillet weld

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 15792-3:2008 sisaldab Euroopa standardi EN ISO 15792-3:2008 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 15792-3:2008 consists of the English text of the European standard EN ISO 15792-3:2008.
Standard on kinnitatud Eesti Standardikeskuse 20.06.2008 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.	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.
Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 07.05.2008.	Date of Availability of the European standard text 07.05.2008.
Standard on kättesaadav Eesti standardiorganisatsioonist.	The standard is available from Estonian standardisation organisation.

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Võtmesõnad: ettevalmistus, kaarkeevitus, katsekehad, kattega elektroodid, keevitus, keevitusdefektid, liitmine, lisamaterjalid, nikkel, niklisulamid, nurkõmblused, terased, testimine, visuaalne kontrollimine

EUROPEAN STANDARD

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English Version

Welding consumables - Test methods - Part 3: Classification testing of positional capacity and root penetration of welding consumables in a fillet weld (ISO 15792-3:2000 including Cor 1:2006)

Produits consommables pour le soudage - Méthodes d'essai - Partie 3: Évaluation de l'aptitude au soudage en position et de la pénétration en racine des produits consommables pour les soudures d'angle (ISO 15792-3:2000, Cor 1:2006 inclus)

Schweißzusätze - Prüfverfahren - Teil 3: Prüfung zur Einteilung der Schweißzusätze nach ihrer Eignung für Schweißpositionen und Wurzeleinbrand an Kehlnähten (ISO 15792-3:2000, enthält Cor. 1:2006)

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

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

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Foreword

The text of ISO 15792-3:2000/Cor 1:2006 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 15792-3:2008 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.

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

This document supersedes EN 1597-3:1997.

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Endorsement notice

The text of ISO 15792-3:2000/Cor 1:2006 has been approved by CEN as a EN ISO 15792-3:2008 without any modification.

Introduction

This part of ISO 15792 describes preparation and assessment of a fillet weld test piece.

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

Welding consumables — Test methods —

Part 3:
Classification testing of positional capacity and root penetration of welding consumables in a fillet weld

1 Scope

This part of ISO 15792 applies, when invoked by the classification standard, to the classification of arc welding electrodes and wires for welding carbon-manganese steels, low alloy steels, stainless steels and nickel base alloys. It describes the preparation of the test piece and the evaluation of the test results, for assessing conformance to requirements of positional usability and root penetration set forth by the classification standard for electrode or wire.

This part of ISO 15792 does not set forth the acceptance requirements.

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 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections*.

ISO 6947, *Welds — Working positions — Definition of angles of slope and rotation*.

3 General requirements

Samples of welding consumables (electrodes or wires) to be tested shall be representative of the manufacturer's products being classified. Test pieces shall be prepared and tested as described below and in the classification standard. The test results shall fulfil the requirements of the classification standard.

4 Test plate material

The plate material shall be selected from the range of materials and material thicknesses prescribed by the classification standard. The surfaces to be welded shall be free of scale, rust and other contaminants.