

**Keevitusmaterjalid. Katsemeetodid. Osa 3:
Keevitusmaterjalide asendiomaduste katsetamine
nurkõmbluste korral (ISO 15792-3:2011)**

Welding consumables - Test methods - Part 3: Classification testing of positional capacity and root penetration of welding consumables in a fillet weld (ISO 15792-3:2011)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 15792-3:2011 sisaldab Euroopa standardi EN ISO 15792-3:2011 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 31.05.2011 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 15.05.2011.

Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN ISO 15792-3:2011 consists of the English text of the European standard EN ISO 15792-3:2011.

This standard is ratified with the order of Estonian Centre for Standardisation dated 31.05.2011 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.

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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 15792-3:2011)**

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-
3:2011)

This European Standard was approved by CEN on 14 May 2011.

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This European Standard exists 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 CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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Foreword

This document (EN ISO 15792-3:2011) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with 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 2011, and conflicting national standards shall be withdrawn at the latest by November 2011.

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.

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Endorsement notice

The text of ISO 15792-3:2011 has been approved by CEN as a EN ISO 15792-3:2011 without any modification.

Introduction

This part of ISO 15792 specifies the preparation and assessment of fillet weld test pieces.

The test conditions specified 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 specifies the preparation and assessment of fillet weld test pieces for conformity assessment of positional usability and root penetration requirements for consumables classification standards for welding non-alloy and fine grain steels, low alloy steels, stainless steels, and nickel base alloys.

This part of ISO 15792 does not specify acceptance requirements.

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.

ISO 6947, *Welding and allied processes — Welding positions*

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 specified in Clauses 5 and 6, as well as 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 specified in the classification standard. The surfaces to be welded shall be free of scale, rust, and other contaminants.

5 Preparation of the test piece

5.1 Before assembly, the web piece of the assembly shall have one edge of the web flat and square throughout its length so that, when the web is set on the flange, which shall be straight and smooth, there will be intimate contact along the entire length of the joint. The web and flange shall be assembled as shown in Figure 1. Both ends of the joint shall be secured by tack welds to maintain intimate contact along the length of the joint and to maintain the 90° angle between the web and flange. The web and flange dimensions shall be in accordance with those given in the electrode classification standard.