

**Welding - Test for shop primers in relation
to welding and allied processes - Part 2:
Welding properties of shop primers**

Welding - Test for shop primers in relation to welding
and allied processes - Part 2: Welding properties of
shop primers

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 17652-2:2003 sisaldab Euroopa standardi EN ISO 17652-2:2003 ingliskeelset teksti. Käesolev dokument on jõustatud 14.08.2003 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN ISO 17652-2:2003 consists of the English text of the European standard EN ISO 17652-2:2003. This document is endorsed on 14.08.2003 with the notification being published in the official publication of the Estonian national standardisation organisation. The standard is available from Estonian standardisation organisation.
--	---

Käsitlusala: This part of this European Standard describes tests for assessing the influence of shop primers on the weldability. The following tests are detailed: a) Rating test This screening test provides a method of assessing the relative weldability of a shop primer of a specified thickness by making a standard weld and subsequently evaluating the severity of the resulting porosity. Rating tests are suitable for declaration by suppliers of the influence of particular shop primers and similar purposes; b) Weldability test	Scope: This part of this European Standard describes tests for assessing the influence of shop primers on the weldability. The following tests are detailed: a) Rating test This screening test provides a method of assessing the relative weldability of a shop primer of a specified thickness by making a standard weld and subsequently evaluating the severity of the resulting porosity. Rating tests are suitable for declaration by suppliers of the influence of particular shop primers and similar purposes; b) Weldability test
---	---

ICS 25.160.10

Võtmesõnad: co, materials, materials testing, metallic materials, metals, porosity, properties, quality assurance, specification (approval), specifications, steel welding, test specimens, testing, weldability, welded joints, welding, welding engineering, welding processes

English version

Welding

Test for shop primers in relation to welding and allied processes

**Part 2: Welding properties of shop primers
(ISO 17652-2 : 2003)**

Soudage – Essai sur peintures primaires en relation avec le soudage et les techniques connexes – Partie 2: Propriétés relatives au soudage des peintures primaires
(ISO 17652-2 : 2003)

Schweißen – Prüfung von Fertigungsbeschichtungen für das Schweißen und für verwandte Prozesse – Teil 2: Schweißeigenschaften von Fertigungsbeschichtungen
(ISO 17652-2 : 2003)

This European Standard was approved by CEN on 2003-01-02.

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
1 Scope	4
2 Normative references	4
3 Terms and definitions.....	5
4 Rating test.....	5
4.1 Principle	5
4.2 Preparation of test piece	5
4.3 Procedure	5
4.3.1 Welding	5
4.3.2 Breaking of the test weld	7
4.4 Examination and determination of porosity.....	7
4.5 Test report	8
5 Weldability test.....	8
5.1 Principle	8
5.2 Preparation of test piece	8
5.3 Procedure	9
5.3.1 General	9
5.3.2 Tack welding	9
5.3.3 Welding	10
5.4 Weld evaluation.....	10
5.4.1 Visual examination.....	10
5.4.2 Internal examination	11
5.5 Test report	11
Annex A (informative) Example of a test report for rating test of weld properties of shop primers.....	13
Annex ZA (informative) Corresponding International and European Standards for which equivalents are not given in the text.....	14

Foreword

This document (EN ISO 17652-2:2003) 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 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by November 2003, and conflicting national standards shall be withdrawn at the latest by November 2003.

EN ISO 17652 consists of the following parts, under the general title: *Welding – Test for shop primers in relation to welding and allied processes*:

- *Part 1: General requirements*
- *Part 2: Welding properties of shop primers*
- *Part 3: Thermal cutting*
- *Part 4: Emission of fumes and gases*

Annexes A and ZA are informative.

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.

1 Scope

This part of this European Standard describes tests for assessing the influence of shop primers on the weldability. The following tests are detailed:

a) Rating test

This screening test provides a method of assessing the relative weldability of a shop primer of a specified thickness by making a standard weld and subsequently evaluating the severity of the resulting porosity. Rating tests are suitable for declaration by suppliers of the influence of particular shop primers and similar purposes;

b) Weldability test

This test describes a method for evaluating the weldability of welding consumables and shop primer combinations, using various arc welding processes. A standard size fillet is produced that enables comparison to be made. An overall assessment of the quality of the resultant weld is made. Weldability tests may be more closely related to actual conditions during production.

For precaution for protection of health, safety and environment during testing, see EN ISO 17652-1.

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

EN 440, *Welding consumables - Wire electrodes and deposits for gas shielded metal arc welding of non alloy and fine grain steels - Classification.*

EN 10025:1990, *Hot rolled products of non-alloy structural steels — Technical delivery conditions.*

EN 10238, *Automatically blast-cleaned and automatically prefabricated primed structural steel products.*

EN 10278, *Dimensions and tolerances of bright steel products.*

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 2808, *Paints and varnishes - Determination of film thickness (ISO 2808:1999).*

EN ISO 8501-1:2001, *Preparation of steel substrates before application of paints and related products - Visual assessment of surface cleanliness - Part 1: Rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal of previous coatings (ISO 8501-1:1988).*

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

EN ISO 17652-1:2003, *Welding - Test for shop primers in relation to welding and allied processes - Part 1: General requirements (ISO 17652-1:2003).*