

**Friction stir welding - Aluminium - Part 4: Specification
and qualification of welding procedures (ISO 25239-
4:2011)**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

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English Version

**Friction stir welding - Aluminium - Part 4: Specification and
qualification of welding procedures (ISO 25239-4:2011)**

Soudage par friction-malaxage - Aluminium - Partie 4:
Descriptif et qualification des modes opératoires de
soudage (ISO 25239-4:2011)

Rührreibschweißen - Aluminium - Teil 4: Anforderung und
Qualifizierung von Schweißverfahren (ISO 25239-4:2011)

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Foreword

This document (EN ISO 25239-4:2011) has been prepared by the International Institute of Welding 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of an identical text or by endorsement, at the latest by June 2012, and conflicting national standards shall be withdrawn at the latest by June 2012.

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 25239-4:2011 has been approved by CEN as a EN ISO 25239-4:2011 without any modification.

Contents

Page

Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Symbols and abbreviated terms	2
5 Development and qualification of welding procedures	2
5.1 General	2
5.2 Technical content of a pWPS	3
6 Qualification based on a welding procedure test	5
6.1 General	5
6.2 Test pieces	5
6.3 Examination and testing of test pieces	7
6.4 Range of qualification	13
6.5 Welding procedure qualification record	13
7 Qualification based on pre-production welding test	13
7.1 General	13
7.2 Test pieces	14
7.3 Examination and testing of test pieces	14
7.4 Range of qualification	14
7.5 Welding procedure qualification record	14
Annex A (informative) Preliminary welding procedure specification	15
Annex B (informative) Non-destructive testing	16
Annex C (informative) Hammer S-bend test of lap welds	17
Annex D (informative) Welding procedure qualification record form	19
Bibliography	22

Introduction

Welding processes are widely used in the fabrication of engineered structures. During the second half of the twentieth century, fusion welding processes, wherein fusion is obtained by the melting of parent material and usually a filler metal, dominated the welding of large structures. Then, in 1991, Wayne Thomas at TWI invented friction stir welding (FSW), which is carried out entirely in the solid phase (no melting).

The increasing use of FSW has created the need for this International Standard in order to ensure that welding is carried out in the most effective way and that appropriate control is exercised over all aspects of the operation. This International Standard focuses on the FSW of aluminium because, at the time of publication, the majority of commercial applications for FSW involved aluminium. Examples include railway carriages, consumer products, food processing equipment, aerospace structures, and marine vessels.

To parts of this International Standard are listed in the foreword.

Part 1 defines terms specific to FSW.

Part 2 specifies design requirements for FSW joints in aluminium.

Part 3 specifies requirements for the qualification of an operator for the FSW of aluminium.

Part 4 specifies requirements for the specification and qualification of welding procedures for the FSW of aluminium. A welding procedure specification (WPS) is needed to provide a basis for planning welding operations and for quality control during welding. Welding is considered a special process in the terminology of standards for quality systems. Standards for quality systems usually require that special processes be carried out in accordance with written procedure specifications. Metallurgical deviations constitute a special problem. Because non-destructive testing of the mechanical properties is impossible at the present level of technology, this has resulted in the establishment of a set of rules for qualification of the welding procedure prior to the release of the WPS to actual production. This part of ISO 25239 defines these rules.

Part 5 specifies a method for determining the capability of a manufacturer to use the FSW process for the production of aluminium products of the specified quality. It defines specific quality requirements, but does not assign those requirements to any specific product group. To be effective, welded structures should be free from serious problems in production and in service. To achieve that goal, it is necessary to provide controls from the design phase through material selection, fabrication, and inspection. For example, poor design can create serious and costly difficulties in the workshop, on site, or in service. Incorrect material selection can result in welding problems, such as cracking. Welding procedures have to be correctly formulated and qualified to avoid imperfections. To ensure the fabrication of a quality product, management should understand the sources of potential trouble and introduce appropriate quality and inspection procedures. Supervision should be implemented to ensure that the specified quality is achieved.

The International Organization for Standardization (ISO) draws attention to the fact that it is claimed that compliance with this document may involve the use of patents concerning friction stir welding given in Clauses 5 to 7.

ISO takes no position concerning the evidence, validity and scope of this patent right.

The following holder of this patent right has assured ISO that it is willing to negotiate licenses under reasonable and non-discriminatory terms and conditions with applicants throughout the world. In this respect, the statement of the holder of this patent right is registered with ISO. Further information may be obtained from:

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Friction stir welding — Aluminium

Part 4: Specification and qualification of welding procedures

1 Scope

This part of ISO 25239 specifies the requirements for the specification and qualification of welding procedures for the friction stir welding (FSW) of aluminium. In this part of ISO 25239, the term “aluminium” refers to aluminium and its alloys.

This part of ISO 25239 does not apply to friction stir spot welding.

NOTE Service requirements, materials or manufacturing conditions can require more comprehensive testing than is specified in this part of ISO 25239.

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 209, *Aluminium and aluminium alloys — Chemical composition*

ISO 857-1, *Welding and allied processes — Vocabulary — Part 1: Metal welding processes*

ISO 2107, *Aluminium and aluminium alloys — Wrought products — Temper designations*

ISO 3134 (all parts), *Light metals and their alloys — Terms and definitions*

ISO 4136, *Destructive tests on welds in metallic materials — Transverse tensile test*

ISO 5173, *Destructive tests on welds in metallic materials — Bend tests*

ISO 6520-1, *Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 1: Fusion welding*

ISO 9017, *Destructive tests on welds in metallic materials — Fracture test*

ISO 10042, *Welding — Arc-welded joints in aluminium and its alloys — Quality levels for imperfections*

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

ISO 14175, *Welding consumables — Gases and gas mixtures for fusion welding and allied processes*

ISO 15607:2003, *Specification and qualification of welding procedures for metallic materials — General rules*

ISO 15613, *Specification and qualification of welding procedures for metallic materials — Qualification based on pre-production welding test*

ISO 15614-2, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 2: Arc welding of aluminium and its alloys*

ISO 17637, *Non-destructive testing of welds — Visual testing of fusion-welded joints*

ISO 17639, *Destructive tests on welds in metallic materials — Macroscopic and microscopic examination of welds*

ISO/TR 17671-1, *Welding — Recommendations for welding of metallic materials — Part 1: General guidance for arc welding*

ISO 25239-1, *Friction stir welding — Aluminium — Part 1: Vocabulary*

ISO 25239-5:2011, *Friction stir welding — Aluminium — Part 5: Quality and inspection requirements*

ISO 80000-1:2009, *Quantities and units — Part 1: General*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 209, ISO 857-1, ISO 3134, ISO 6520-1, ISO 10042, ISO 15607, ISO 15613, ISO 15614-2, ISO/TR 17671-1, and ISO 25239-1 apply.

4 Symbols and abbreviated terms

For the purposes of qualification of welding procedures, the abbreviations listed in ISO 15607:2003, Table 1, apply.

5 Development and qualification of welding procedures

5.1 General

Qualification of welding procedures shall be performed prior to production welding.

The manufacturer shall prepare a preliminary welding procedure specification (pWPS) and shall ensure that it is applicable for production using experience from previous production jobs and the general fund of knowledge of welding technology.

A pWPS shall be used as the basis for the establishment of a welding procedure qualification record (WPQR). The pWPS shall be tested in accordance with one of the methods listed in Clause 6 (welding procedure test) or Clause 7 (pre-production welding test). Clause 6 shall be used when the production part or joint geometry is accurately represented by a standardized test piece or pieces, as shown in 6.2. Clause 7 shall be used when the production part or joint geometry is not accurately represented by the standardized test pieces, as shown in 6.2. The information required in a pWPS is given in 5.2.

NOTE For some applications, it can be necessary to supplement or reduce the list.

A welding procedure specification (WPS) covers a certain range of parent material thicknesses as well as a range of aluminium alloys.

Ranges and tolerances in accordance with the relevant International Standard (see Clause 2) and the manufacturer's experience shall be specified when appropriate.

An example of a pWPS form is shown in Annex A.