

**KEEVITAMINE JA KÜLGNEVAD PROTSESSID.
KEEVITUSASENDID**

**Welding and allied processes - Welding positions (ISO
6947:2011)**

EESTI STANDARDI EESSÕNA**NATIONAL FOREWORD**

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English Version

**Welding and allied processes - Welding positions (ISO
6947:2011)**

Soudage et techniques connexes - Positions de soudage
(ISO 6947:2011)

Schweißen und verwandte Prozesse - Schweißpositionen
(ISO 6947:2011)

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

Management Centre: Avenue Marnix 17, B-1000 Brussels

Foreword

This document (EN ISO 6947:2011) 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of an identical text or by endorsement, at the latest by November 2011, and conflicting national standards shall be withdrawn at the latest by November 2011.

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Endorsement notice

The text of ISO 6947:2011 has been approved by CEN as a EN ISO 6947:2011 without any modification.

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Introduction

This International Standard provides positions for standard discrete test piece orientation PA, PB, H-L045, etc. that have been specified in this International Standard since the first edition (ISO 6947:1980).

In this revision, positions are defined for production welding. These positions are flat, horizontal, vertical, and overhead. Unlike testing positions, these positions are contiguous.

The direction of welding is an essential parameter for determining the welding position, e.g. up or down.

The welding position is not dependent on the geometrical arrangement of the joint, e.g. butt or fillet joint, or that of the semi-finished product. Welds of all types and in all directions are covered.

The main positions have been given symbols which can easily be used for designation purposes; these symbols were chosen independently of possible meaningful abbreviations, i.e. they are not derived from any particular language.

The relationship between testing positions and production welding positions is specified elsewhere, e.g. in ISO 9606^[1] or ISO 15614^[2].

Welding and allied processes — Welding positions

1 Scope

This International Standard defines welding positions for testing and production, for butt and fillet welds, in all product forms.

Annex A gives examples of the limits of the slope of a weld axis and the rotation of the weld face about the weld axis for welding positions in production welds.

Annex B provides a comparison of International, European and US designations.

2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

2.1

welding position

position of a weld in space, which is defined relative to the slope of the axis and rotation of the face of the weld relative to the horizontal plane

2.2

main welding position

welding position, designated PA, PB, PC, PD, PE, PF or PG

NOTE For PA, PB, PC, PD and PE, see Figure 1.

2.3

slope

S

angle of the axis of the weld relative to the main welding position

2.4

rotation

R

angle of the face of the weld relative to the main welding position

2.5

inclined angle

L

angle of the axis of the pipe

3 Welding positions

3.1 Main welding positions

The main welding positions are illustrated in Figure 1 with examples of their application for butt and fillet welds in Figure 2.