

**Welding and allied processes - Joint preparation -
Part 2: Submerged arc welding of steels
(ISO 9692-2:1998)**

EESTI STANDARDI EESSÕNA**NATIONAL FOREWORD**

See Eesti standard EVS-EN ISO 9692-2:1999 sisaldab Euroopa standardi EN ISO 9692-2:1998+AC:1999 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 9692-2:1999 consists of the English text of the European standard EN ISO 9692-2:1998+AC:1999.
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ICS 25.160.40

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English version

Welding and allied processes – Joint preparation

Part 2: Submerged arc welding of steels

(ISO 9692-2 : 1998)

(includes Corrigendum AC : 1999)

Soudage et techniques connexes –
Préparation de joints – Partie 2:
Soudage à l'arc sous flux en poudre
des aciers (ISO 9692-2 : 1998)
(corrigendum AC : 1999 inclus)

Schweißen und verwandte Verfahren –
Schweißnahtvorbereitung – Teil 2:
Unterpulverschweißen von Stahl
(ISO 9692-2 : 1998)
(enthält Berichtigung AC : 1999)

This European Standard was approved by CEN on 1998-01-26 and corrigendum AC on 1999-07-14.

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 Central Secretariat 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 Central Secretariat has the same status as the official versions.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart 36, B-1050 Brussels

Foreword

International Standard

ISO 9692-2 : 1998 Welding and allied processes – Joint preparation – Part 2: Submerged arc welding of steels,

which was prepared by ISO/TC 44 'Welding and allied processes' of the International Organization for Standardization, has been adopted by Technical Committee CEN/TC 121 'Welding', the Secretariat of which is held by DS, as a European Standard.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association and supports essential requirements of the relevant EU Directive.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, and conflicting national standards withdrawn, by October 1998 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard:

Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

Endorsement notice

The text of the International Standard ISO 9692-2 : 1998 was approved by CEN as a European Standard without any modification.

NOTE: Normative references to international publications are listed in Annex ZA (normative).

Introduction

The intention of this International Standard is to use it as an addition to ISO 9692:1992 (which is to become ISO 9692-1, see Foreword) *Metal-arc welding with covered electrode, gas-shielded metal-arc welding and gas welding — Joint preparations for steel*. It follows similar rules and the same layout. Therefore, the introduction given in ISO 9692 also applies.

1 Scope

This part of ISO 9692 applies to types of joint preparation for submerged arc welding with one wire electrode (process 121 according to ISO 4063) on steel.

This part of ISO 9692 covers only the welding positions PA and PB according to ISO 6947. In case PC is used, special preparation will be necessary.

It applies to fully penetrated welds. For partly penetrated welds, types of joint preparation, shapes and dimensions may differ from the listed proposals if they are specified in the relevant application standard or agreed by parties concerned.

If the root is welded by a different arc welding process (see ISO 4063), the joint preparation according to ISO 9692 should be taken into account.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards listed below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 2553 : 1992, *Welded, brazed and soldered joints — Symbolic representation on drawings*.

ISO 3834-1 : 1994, *Quality requirements for welding — Fusion welding of metallic materials — Part 1: Guidelines for selection and use*.

ISO 3834-2 : 1994, *Quality requirements for welding — Fusion welding of metallic materials — Part 2: Comprehensive quality requirements*.

ISO 3834-3 : 1994, *Quality requirements for welding — Fusion welding of metallic materials — Part 3: Standards quality requirements*.

ISO 3834-4 : 1994, *Quality requirements for welding — Fusion welding of metallic materials — Part 4: Elementary quality requirements*.

ISO 4063:—¹⁾, *Welding and allied processes — Nomenclature of processes and reference numbers.*

ISO 6947:1990, *Welds — Working positions — Definitions of angles of slope and rotation.*

ISO 9692:1992²⁾, *Metal-arc welding with covered electrode, gas-shielded metal arc welding and gas welding — Joint preparations for steel.*

ISO 9956-2:1995 and Amd.1—³⁾, *Specification and approval of welding procedures for metallic materials — Part 2: Welding procedure specification for arc welding.*

3 Materials

Joint preparations recommended in this part of ISO 9692 are suitable for all types of weldable steel.

4 Types of joint preparation

The recommended types of joint preparation and dimensions are specified in tables 1 and 2.

The root gaps referred to in this part of ISO 9692 are those gaps presented after tack welding, if used.

This part of ISO 9692 gives no dimensions or type of possibly used backing materials. Root runs may also be used as backing. They may influence the quality requirements for welding (according to the relevant part of ISO 3834) and the preparation as given in tables 1 and 2. They shall be part of the welding procedure specification according to ISO 9956-2.

According to the application standard or agreement between contracting parties, it may be necessary to grind the slag before welding the next run.

NOTE — The reference numbers have been determined in accordance with the following scheme:

The first digit corresponds to the number of the table; the second digit or numerical group corresponds to the number in ISO 2553; the third indication, expressed by a letter, takes into account the variants of joint preparations.

1) To be published. (Revision of ISO 4063:1990)

2) See Foreword.

3) To be published.