Keevitamine ja liidetud protsessid. Soovitused õmbluse ettevalmistamiseks. Osa 3: Alumiiniumi ja selle sulamite metallkeevitus inertgaasis ja elektroodkeevitus inertgaasis

Welding and allied processes - Recommendations for joint preparation - Part 3: Metal inert gas welding and tungsten inert gas welding of aluminium and its alloys

EESTI STANDARDIKESKUS

EESTI STANDARDI EESSÕNA **NATIONAL FOREWORD**

Käesolev Eesti standard EVS-EN ISO 9692-3:2001 sisaldab Euroopa standardi EN ISO 9692-3:2001 ingliskeelset teksti. Käesolev dokument on jõustatud 19.12.2001 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN ISO 9692-3:2001 consists of the English text of the European standard EN ISO 9692-3:2001. This document is endorsed on 19.12.2001 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 standard specifies types of joint preparation for metal inert gas welding, MIG, (131) and tungsten inert gas welding, TIG, (141) on aluminium and its alloys. It applies to fully penetrated welds.	**Scope:** This standard specifies types of joint preparation for metal inert gas welding, MIG, (131) and tungsten inert gas welding, TIG, (141) on aluminium and its alloys. It applies to fully penetrated welds.

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Võtmesõnad: gas wel, inert gas-shielded arc welding, metal welding, mig welding, recommendation, seam welding, specification, steel welding, steels, tig welding, tungsten inert-gas welding, weld preparation, weld preparations, welded joints, welding, welding engineering, welds

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Welding and allied processes – Recommendations for joint preparation

Part 3: Metal inert gas welding and tungsten inert gas welding of aluminium and its alloys

(ISO 9692-3 : 2000)

Soudage et techniques connexes – Recommandations pour la préparation de joints – Partie 3: Soudage MIG et TIG de l'aluminium et de ses alliages (ISO 9692-3 : 2000)

Schweißen und verwandte Prozesse – Empfehlungen für Fugenformen – Teil 3: Metall-Inertgasschweißen und Wolfram-Inertgasschweißen von Aluminium und Aluminium-Legierungen (ISO 9692-3 : 2000)

This European Standard was approved by CEN on 2001-02-15.

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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.

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CEN

European Committee for Standardization
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Europäisches Komitee für Normung

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Foreword

International Standard

ISO 9692-3 : 2000 Welding and allied processes – Recommendations for joint preparation – Part 3: Metal inert gas welding and tungsten inert gas welding of aluminium and its alloys,

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 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 September 2001 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 9692-3 : 2000 was approved by CEN as a European Standard without any modification.

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

Introduction

This part of ISO 9692 defines the parameters characterizing the joint preparation and assembly of the most often encountered dimensions and shapes.

The recommendations given in this part of ISO 9692 have been compiled on the basis of experience and contain dimensions for types of joint preparation that are generally found to provide suitable welding conditions. However, the extended field of application makes it necessary to give a range of dimensions. The dimension ranges specified represent design limits and are not tolerances for manufacturing purposes. Manufacturing limits depend, for instance, on welding process, parent metal, welding position, quality level, etc. Due to the common character of this part of ISO 9692, the examples given cannot be regarded as the only solution for the selection of a joint type.

Specific fields of application and manufacturing requirements may be covered by selected ranges of dimensions specified in the relevant application standard.

1 Scope

This part of ISO 9692 specifies types of joint preparation for metal inert gas welding, MIG, (131) and tungsten inert gas welding, TIG, (141) on aluminium and its alloys.

It applies to fully penetrated welds.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 9692. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 9692 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

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

ISO 4063:1998, *Welding and allied processes — Nomenclature of processes and reference numbers.*

3 Materials

Joint preparations recommended in this part of ISO 9692 are suitable for all types of aluminium and its weldable alloys.

4 Welding processes

Joint preparations recommended in this part of ISO 9692 are suitable for welding carried out in accordance with the following processes as specified in Tables 1 to 3. Combinations of different processes are possible:

— metal inert gas welding (MIG) (131)

— tungsten inert gas welding (TIG) (141)

NOTE The numbers in parantheses refer to the reference number of the welding process specified in ISO 4063.