

**Welding and allied processes -
Recommendations for joint preparation
- Part 4: Clad steels**

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for joint preparation - Part 4: Clad steels

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 9692-4:2003 sisaldab Euroopa standardi EN ISO 9692-4:2003 ingliskeelset teksti. Käesolev dokument on jõustatud 17.09.2003 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN ISO 9692-4:2003 consists of the English text of the European standard EN ISO 9692-4:2003. This document is endorsed on 17.09.2003 with the notification being published in the official publication of the Estonian national standardisation organisation. The standard is available from Estonian standardisation organisation.
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Käsitlusala: This part of EN ISO 9692 gives recommendations for types of joint preparation for clad steels.	Scope: This part of EN ISO 9692 gives recommendations for types of joint preparation for clad steels.
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Võtmesõnad: aluminium, base materials, cladding, edge forms, metal welding, plated, recommendation, seams, specification, steel welding, steels, weld preparation, welded joints, welding, welding engineering, welds

English version

**Welding and allied processes – Recommendations
for joint preparation**

**Part 4: Clad steels
(ISO 9692-4 : 2003)**

Soudage et techniques connexes –
Recommandations pour la prépara-
tion de joints – Partie 4: Aciers
plaqués (ISO 9692-4 : 2003)

Schweißen und verwandte Prozesse –
Empfehlungen zur Schweißnahtvor-
bereitung – Teil 4: Plattierte Stähle
(ISO 9692-4 : 2003)

This European Standard was approved by CEN on 2003-02-20.

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CEN

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Comité Européen de Normalisation
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Foreword

This document (EN ISO 9692-4:2003) has been prepared by Technical Committee CEN/TC 121, "Welding", the secretariat of which is held by DS.

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of an identical text or by endorsement, at the latest by February 2004, and conflicting national standards shall be withdrawn at the latest by February 2004.

EN ISO 9692 "Welding and allied processes – Recommendations for joint preparation" consists of the following Parts:

- *Part 1: Manual metal-arc welding, gas-shielded metal-arc welding, gas welding, TIG Welding and beam welding of steels.*
- *Part 2: Submerged arc welding of steels.*
- *Part 3: Metal inert gas welding and tungsten inert gas welding of aluminium and its alloys.*
- *Part 4: Clad steels*

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 gives recommendations for types of joint preparation for clad steels.

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 revision 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 1011-5, Welding – Recommendations for welding of metallic materials – Part 5: Welding of clad steels

3 Materials

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

4 Types of joint preparation

The recommended types of joint preparation and dimensions are specified in Tables 1 to 4.

Details concerning welding recommendations for clad steels are given in EN 1011-5.

Figures showing the completed joint are given in Table 4 for clarity.

In certain cases, where the welding process may produce a brittle phase e.g. clad steels with cladding of titanium, zirconium and their alloys, a deviation from the weld preparations shown may be necessary.