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Specification and qualification of welding procedures
for metallic materials - Welding procedure test - Part 1:
Arc and gas welding of steels and arc welding of nickel
and nickel alloys (ISO 15614-1:2017, Corrected version
2017-10-01)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN ISO 15614-1:2017 sisaldab Euroopa standardi EN ISO 15614-1:2017 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 15614-1:2017 consists of the English text of the European standard EN ISO 15614-1:2017.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 21.06.2017.	Date of Availability of the European standard is 21.06.2017.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

Tagasisidet standardi sisu kohta on võimalik edastada, kasutades EVS-i veebilehel asuvat tagasiside vormi või saates e-kirja meiliaadressile standardiosakond@evs.ee.

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EUROPEAN STANDARD

EN ISO 15614-1

NORME EUROPÉENNE

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Supersedes EN ISO 15614-1:2004

English Version

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys (ISO 15614-1:2017, Corrected version 2017-10-01)

Descriptif et qualification d'un mode opératoire de soudage pour les matériaux métalliques - Épreuve de qualification d'un mode opératoire de soudage - Partie 1: Soudage à l'arc et aux gaz des aciers et soudage à l'arc du nickel et des alliages de nickel (ISO 15614-1:2017, Version corrigée 2017-10-01)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 1: Lichtbogen- und Gasschweißen von Stählen und Lichtbogenschweißen von Nickel und Nickellegierungen (ISO 15614-1:2017, korrigierte Fassung 2017-10-01)

This European Standard was approved by CEN on 17 April 2017.

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 CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists 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 CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

European foreword

This document (EN ISO 15614-1:2017) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" 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 December 2017 and conflicting national standards shall be withdrawn at the latest by December 2017.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 15614-1:2004.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative Annex ZA and ZB, which is an integral part of this document.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 15614-1:2017, Corrected version 2017-10-01 has been approved by CEN as EN ISO 15614-1:2017 without any modification.

Annex ZA

(informative)

Relationship between this European Standard and the Essential Requirements of EU Directive 2014/68/EU (PED)

This European Standard has been prepared under a Commission's standardization request M/071 "Mandate to CEN for standardization in the field of pressure equipment" to provide one voluntary means of conforming to essential requirements of Directive 2014/68/EU (PED) on the harmonisation of the laws of the Member States relating to the making available on the market of pressure equipment.

Once this standard is cited in the Official Journal of the European Union under that Directive, compliance with the normative clauses of this standard given in Table ZA.1 confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding essential requirements of that Directive, and associated EFTA regulations.

Table ZA.1 — Correspondence between this European Standard and Directive 2014/68/EU (PED)

Essential Requirements of Directive 2014/68/EU (PED)	Clauses of this European Standard	Remarks/Notes
Annex I, 3.1.2	All clauses limited to level 2	Permanent joining

WARNING 1 — Presumption of conformity stays valid only as long as a reference to this International Standard is maintained in the list published in the Official Journal of the European Union. Users of this standard should consult frequently the latest list published in the Official Journal of the European Union.

WARNING 2 — Other Union legislation may be applicable to the product(s) and services falling within the scope of this standard.

Annex ZB (informative)

Relationship between this International Standard and the Essential Requirements of EU Directive 2014/29/EU (SPVD)

This European Standard has been prepared under a Commission's standardization request M/071 "Mandate to CEN for standardization in the field of pressure equipment" to provide one voluntary means of conforming to essential requirements of Directive 2014/29/EU (SPVD) on the harmonisation of the laws of the Member States relating to the making available on the market of simple pressure vessels.

Once this standard is cited in the Official Journal of the European Union under that Directive, compliance with the normative clauses of this standard given in Table ZB.1 confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding essential requirements of that Directive, and associated EFTA regulations.

Table ZB.1 — Correspondence between this European Standard and Directive 2014/29/EU (SPVD)

Essential Requirements of Directive 2014/29/EU (SPVD)	Clauses of this European Standard	Remarks/Notes
Annex II, 3.c.iii	Clause 9, Annex B	Report on Welding procedure test

WARNING 1 — Presumption of conformity stays valid only as long as a reference to this International Standard is maintained in the list published in the Official Journal of the European Union. Users of this standard should consult frequently the latest list published in the Official Journal of the European Union.

WARNING 2 — Other Union legislation may be applicable to the product(s) and services falling within the scope of this standard.

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Quality management in the field of welding*.

This second edition cancels and replaces the first edition (ISO 15614-1:2004), which has been technically revised. It also incorporates the Amendments ISO 15614-1:2004/Amd 1:2008 and ISO 15614-1:2004/Amd 2:2012 and the Technical Corrigendum ISO 15614-1:2004/Cor. 1:2005.

A list of all parts in the ISO 15614 series can be found on the ISO website.

Requests for official interpretations of any aspect of this document should be directed to the Secretariat of ISO/TC 44/SC 10 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

This corrected version of ISO 15614-1:2017 incorporates the following corrections:

- in [Table 5](#), the value “10-5” has been added for test piece material A of group 10 for test piece material B of group 5;
- [Figure 6](#) has been updated to match the Key.

Introduction

All new welding procedure tests are to be carried out in accordance with this document from the date of its issue. However, this document does not invalidate previous welding procedure tests made to former national standards or specifications or previous issues of this document.

Two levels of welding procedure tests are given in order to permit application to a wide range of welded fabrication. They are designated by levels 1 and 2.

Level 1 is based on requirements of ASME Section IX and level 2 is based on the previous issues of this document.

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Specification and qualification of welding procedures for metallic materials — Welding procedure test —

Part 1:

Arc and gas welding of steels and arc welding of nickel and nickel alloys

1 Scope

This document specifies how a preliminary welding procedure specification is qualified by welding procedure tests.

This document applies to production welding, repair welding and build-up welding.

This document defines the conditions for the execution of welding procedure tests and the range of qualification for welding procedures for all practical welding operations within the qualification of this document.

The primary purpose of welding procedure qualification is to demonstrate that the joining process proposed for construction is capable of producing joints having the required mechanical properties for the intended application.

Two levels of welding procedure tests are given in order to permit application to a wide range of welded fabrication. They are designated by levels 1 and 2. In level 2, the extent of testing is greater and the ranges of qualification are more restrictive than in level 1.

Procedure tests carried out to level 2 automatically qualify for level 1 requirements, but not vice-versa.

When no level is specified in a contract or application standard, all the requirements of level 2 apply.

This document applies to the arc and gas welding of steels in all product forms and the arc welding of nickel and nickel alloys in all product forms.

Arc and gas welding are covered by the following processes in accordance with ISO 4063.

111 — manual metal arc welding (metal-arc welding with covered electrode);

114 — self-shielded tubular-cored arc welding;

12 — submerged arc welding;

13 — gas-shielded metal arc welding;

14 — gas-shielded arc welding with non-consumable electrode;

15 — plasma arc welding;

311 — oxy-acetylene welding.

The principles of this document may be applied to other fusion welding processes.

NOTE A former process number does not require a new qualification test according to this document.

Specification and qualification of welding procedures that were made in accordance with previous editions of this document may be used for any application for which the current edition is specified. In this case, the ranges of qualification of previous editions remain applicable.