

Metallide keevitusprotseduuride spetsifitseerimine ja atesteerimine. Osa 6: Atesteerimine eelneva keevituskogemuse alusel

Specification and approval of welding procedures for metallic materials - Part 6: Approval related to previous experience

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 288-6:1998 sisaldab Euroopa standardi EN 288-6:1994 ingliskeelset teksti.

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EUROPEAN STANDARD

EN 288-6

NORME EUROPÉENNE

EUROPÄISCHE NORM

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English version

**Specification and approval of welding procedures
for metallic materials - Part 6: Approval related to
previous experience**

Descriptif et qualification d'un mode
opérateur de soudage pour les matériaux
métalliques - Partie 6: Qualification par
référence à l'expérience acquise

Anforderung und Anerkennung von
Schweißverfahren für metallische Werkstoffe -
Teil 6: Anerkennung aufgrund vorliegender
Erfahrung

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CEN

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

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Foreword

This European Standard has been prepared by the Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS.

The Technical Committee CEN/TC 121 has decided to submit the final draft to the formal vote. The result was positive.

This European Standard consists of the following parts:

- Part 1 : General rules for fusion welding;
- Part 2 : Welding procedure specification for arc welding;
- Part 3 : Welding procedure tests for the arc welding of steels;
- Part 4 : Welding procedure tests for the arc welding of aluminium and its alloys;
- Part 5 : Approval by using approved welding consumables for arc welding;
- Part 6 : Approval related to previous experience;
- Part 7 : Approval by a standard welding procedure for arc welding;
- Part 8 : Approval by a preproduction welding test.

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of an identical text or by endorsement, at the latest by February 1995, and conflicting national standards shall be withdrawn at the latest by February 1995.

According to the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, United Kingdom.

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0 Introduction

In EN 288-1, one of the methods of welding procedure approval is by relating to previous experience.

Many manufacturers have considerable experience in fabricating welded structures. Welded components and structures may have been supplied to end users/clients for a variety of applications and have performed satisfactorily over a period of time in service. If this experience is traceable and documented this standard provides a route to welding procedure approval based on this experience.

1 Scope

This standard specifies the conditions for approval of a welding procedure based on previous experience according to EN 288-1. In addition it gives the range of approval and the validity.

This standard applies to fusion welding of metallic materials. The process numbers refer to EN 24 063.

Essentially this standard covers the following processes :

- 111 : Metal arc welding with covered electrode
- 114 : Flux cored metal-arc welding without gas shield
- 121 : Submerged arc welding with wire electrode
- 122 : Submerged arc welding with strip electrode
- 131 : Metal-arc inert gas welding ; MIG-welding
- 135 : Metal-arc active gas welding ; MAG-welding
- 136 : Flux cored wire metal-arc welding with active gas shield
- 137 : Flux cored wire metal-arc welding with inert gas shield
- 141 : Tungsten inert-gas arc welding ; TIG-welding
- 15 : Plasma arc welding

Other welding processes may be accepted by agreement when sufficient experience is available.

The use of this standard may be restricted by an application standard or at the enquiry/order stage by the contracting parties.

2 Normatives 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 revisions 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.

- | | |
|----------|---|
| EN 288-1 | Specification and approval of welding procedures for metallic materials - Part 1 : General rules for fusion welding. |
| EN 288-2 | Specification and approval of welding procedures for metallic materials - Part 2 : Welding procedure specification for arc welding. |
| EN 288-3 | Specification and approval of welding procedures for metallic materials - Part 3 : Welding procedure tests for the arc welding of steels |
| EN 288-4 | Specification and approval of welding procedures for metallic materials - Part 4 : Welding procedure tests for the arc welding of aluminium and its alloys. |
| EN 24063 | Welding, brazing, soldering and braze welding of metals. Nomenclature of processes and reference numbers for symbolic representation on drawing. |

3 Definitions

For the purpose of this standard, the definitions listed in EN 288-1 shall apply.

4 Preliminary welding procedure specifications (pWPS)

The approval of a welding procedure based on previous experience shall be based on a pWPS according to EN 288-2. It shall specify the range for all the relevant parameters.

5 Approval of the welding procedure

The approval of the welding procedure shall be carried out by an examiner or test body according to EN 288-1.

The essential items for the approval are :

- pWPS according to EN 288-2
- documentation of the existing previous experience (see clause 6).