

**KEEVITAJATE KVALIFITSEERIMISE KATSE  
SULAKEEVITUS  
OSA 1: TERASED**

**Qualification testing of welders**

**Fusion welding**

**Part 1: Steels**

**(ISO 9606-1:2012 including Cor 1:2012 and Cor 2:2013)**

**EESTI STANDARDI EESSÕNA****NATIONAL FOREWORD**

See Eesti standard EVS-EN ISO 9606-1:2017 sisaldab Euroopa standardi EN ISO 9606-1:2017 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 9606-1:2017 consists of the English text of the European standard EN ISO 9606-1:2017.
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 23.08.2017.	Date of Availability of the European standard is 23.08.2017.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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English Version

**Qualification testing of welders - Fusion welding - Part 1:  
Steels (ISO 9606-1:2012 including Cor 1:2012 and Cor  
2:2013)**

Épreuve de qualification des soudeurs - Soudage par  
fusion - Partie 1 : Aciers (ISO 9606-1:2012, y compris  
Cor 1:2012 et Cor 2:2013)

Prüfung von Schweißern - Schmelzschweißen - Teil 1:  
Stähle (ISO 9606-1:2012, einschließlich Cor 1:2012  
und Cor 2:2013)

This European Standard was approved by CEN on 16 July 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.

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

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

## European foreword

The text of ISO 9606-1:2012 including Cor 1:2012 and Cor 2:2013 has been prepared by Technical Committee ISO/TC 44 “Welding and allied processes” of the International Organization for Standardization (ISO) and has been taken over as EN ISO 9606-1:2017 by 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 February 2018, and conflicting national standards shall be withdrawn at the latest by February 2018.

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 9606-1:2013.

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 Directives 2014/68/EU and 2014/29/EU.

For relationship with EU Directives, 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 9606-1:2012 including Cor.1:2012 and Cor 2:2013 has been approved by CEN as EN ISO 9606-1:2017 without any modification.

## Annex ZA (informative)

### Relationship between this European Standard and the essential requirements of EU Directive 2014/68/EU [2014 OJ L 189] (PED) aimed to be covered

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 [2014 OJ L 189].

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) [2014 OJ L 189]**

Essential Requirements of Directive 2014/68/EU (PED)	Clause(s)/sub-clause(s) of this EN	Remarks/Notes
Annex I, 3.1.2	Clauses 5, 6.2 to 6.6, 7, 8, 10, 11	Qualification testing
	Clauses 6.1, 9.1, 9.3 a), 9.3 b)	For pressure equipment in categories II, III and IV the examiner/examining body (according to 3.3 and 3.4) is a competent third party – a notified body or a recognized third party organization.
	Clause 9.3 c)	Not permitted for categories II, III and IV products.

**WARNING 1** — Presumption of conformity stays valid only as long as a reference to this European 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 European Standard and the Essential Requirements of EU Directive 2014/29/EU (SPVD) [2014 OJ L96]

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 [2014 OJ L96].

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) [2014 OJ L96]**

Essential Requirements of Directive 2014/29/EU (SPVD)	Clause(s)/sub-clause(s) of this EN	Remarks/Notes
Annex I, 3.2	Clauses 5, 6, 7, 8, 9.1, 9.3 a), 9.3 b), 10, 11	For welds on pressurised parts of simple pressure vessels the examiner/examining body (according to 3.3 and 3.4) is a notified body.

**WARNING 1** — Presumption of conformity stays valid only as long as a reference to this European 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.

# Contents

Page

Foreword .....	iv
Introduction .....	v
1 Scope .....	1
2 Normative references .....	1
3 Terms and definitions .....	2
4 Reference numbers, symbols and abbreviated terms .....	4
4.1 General .....	4
4.2 Reference numbers of welding processes .....	4
4.3 Symbols and abbreviated terms .....	4
5 Essential variables and range of qualification .....	6
5.1 General .....	6
5.2 Welding processes .....	7
5.3 Product type .....	8
5.4 Type of weld .....	9
5.5 Filler material grouping .....	9
5.6 Filler material type .....	10
5.7 Dimensions .....	11
5.8 Welding positions .....	13
5.9 Weld details .....	15
6 Examination and testing .....	15
6.1 Examination .....	15
6.2 Test pieces .....	16
6.3 Welding conditions .....	18
6.4 Test methods .....	18
6.5 Test piece and test specimen .....	19
6.6 Test report .....	23
7 Acceptance requirements for test pieces .....	23
8 Re-tests .....	24
9 Period of validity .....	24
9.1 Initial qualification .....	24
9.2 Confirmation of the validity .....	24
9.3 Revalidation of welder qualification .....	24
9.4 Revocation of qualification .....	24
10 Welder's qualification test certificate .....	25
11 Designation .....	25
Annex A (informative) Welder's qualification test certificate .....	27
Annex B (informative) Job knowledge .....	28
Annex C (informative) FW/BW test assembly option .....	31
Bibliography .....	32

## Introduction

The ability of a welder to follow verbal or written instructions and verification of a person's skills are important factors in ensuring the quality of the welded product.

The testing of a welder's skill in accordance with this International Standard depends on the welding techniques and conditions used, in which uniform rules are complied with and standard test pieces are used.

The principle of this International Standard is that a qualification test qualifies a welder not only for the conditions used in the test, but also for all other conditions which are considered easier to weld in accordance with this International Standard. It is presumed that the welder has received training and/or has industrial practice within the range of qualification.

The qualification test can be used to qualify a welding procedure and a welder provided that all the relevant requirements, e.g. test piece dimensions and testing requirements are satisfied (see ISO 15614-1<sup>[11]</sup>).

All new qualifications shall be in accordance with each part of this International Standard from its date of issue.

At the end of its period of validity, existing qualification tests of welders in accordance with the requirement of a national standard may be revalidated according to this International Standard. This is providing that the technical intent of this International Standard is satisfied. It is necessary for the new range of qualification to be interpreted in accordance with the requirements of this International Standard.