
**Brazing for aerospace applications —
Qualification test for brazers and brazing
operators — Brazing of metallic
components**

*Brasage fort pour applications aérospatiales — Épreuve de qualification
des braseurs et des opérateurs braseurs — Brasage fort des
composants métalliques*



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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.

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The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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.

ISO 11745 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*.

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

Introduction

The application of this International Standard ensures that a qualification test can be carried out in accordance with a standard test specification on standard test pieces under standard conditions. A brazer or brazing operator qualification test properly passed in accordance with this International Standard ensures that the brazer or brazing operator concerned has proved possession of at least the minimum degree of manual skills and technical knowledge demanded by the state of the art.

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1 Scope

This International Standard specifies a qualification test for brazers engaged in manual brazing of parts and brazing operators in aerospace construction.

NOTE 1 Success in the test is an essential precondition for the qualification of brazers (3.1) and brazing operators (3.2) in new production and repair work in aerospace. However, brazing equipment operators (3.3) need not be qualified according to this International Standard.

NOTE 2 This International Standard does not apply to general brazing applications covered by ISO 13585^[3].

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 18279:2003, *Brazing — Imperfections in brazed joints*

ANSI/AWS B2.2, *Brazing procedure and performance qualification*

EN 4179:2009, *Aerospace series — Qualification and approval of personnel for non-destructive testing*

EN 12799, *Brazing — Non-destructive examination of brazed joints*

EN 13134, *Brazing — Procedure approval*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

brazer

person who performs the brazing in a manual operation and guides the heating means and ensures the introduction of the brazing filler material and verifies the braze joint configuration specified by the design

3.2

brazing operator

person who prepares the joint and sets up brazing equipment and thereby has direct influence on the brazed joint quality

NOTE Examples of brazing equipment are furnaces, salt baths, and induction equipment.