
Brazing — Qualification test of brazers and brazing operators

*Brasage fort — Essais de qualification des braseurs et des opérateurs
braseurs en brasage fort*



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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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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 purpose of this International Standard is to provide a general set of rules for qualification, independent of product or application.

Brazing — Qualification test of brazers and brazing operators

1 Scope

This International Standard specifies basic requirements for the qualification testing of brazers and brazing operators providing conditions for brazing, testing, examination, acceptance criteria and range of qualification for certificates.

NOTE 1 Annex D gives guidelines on general quality requirements for brazing.

NOTE 2 This International Standard does not apply to brazing for aerospace applications covered by ISO 11745^[2].

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 857-2, *Welding and allied processes — Vocabulary — Part 2: Soldering and brazing processes and related terms*

ISO 17672, *Brazing — Filler metals*

ISO 18279, *Brazing — Imperfections in brazed joints*

ISO/TR 25901, *Welding and related processes — Vocabulary*

EN 12797, *Brazing — Destructive tests of brazed joints*

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 terms and definitions given in ISO 857-2, ISO/TR 25901 and the following apply.

3.1

brazer

person who holds and manipulates the device for heating the brazing area by hand

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 mechanized torch holders, furnaces, salt baths, and induction equipment.

3.3

brazing

joining process in which a molten filler material is used that has a liquidus temperature above 450 °C but lower than the solidus temperature of the parent material(s)

NOTE Adapted from ISO 857-2:2005, 3.1.2.