

KEEVITAMINE. PÕHILISED TERASEST KEEVISLIITE
DETAILID. OSA 2: SURVEVABAD KOMPONENDID

Welding - Basic weld joint details in steel - Part 2: Non
internal pressurized components

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 1708-2:2019 sisaldab Euroopa standardi EN 1708-2:2018 ingliskeelset teksti.	This Estonian standard EVS-EN 1708-2:2019 consists of the English text of the European standard EN 1708-2:2018.
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.
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English Version

Welding - Basic weld joint details in steel - Part 2: Non internal pressurized components

Soudage - Descriptif de base des assemblages soudés
en acier - Partie 2 : Composants non soumis à une
pression interne

Schweißen - Verbindungselemente beim Schweißen
von Stahl - Teil 2: Nicht innendruckbeanspruchte
Bauteile

This European Standard was approved by CEN on 28 September 2018.

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 foreword

This document (EN 1708-2:2018) has been prepared 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of an identical text or by endorsement, at the latest by June 2019 and conflicting national standards shall be withdrawn at the latest by June 2019.

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 1708-2:2000.

The main changes compared to the previous edition are as follows:

- a) the normative references and bibliography have been updated;
- b) process numbers have been updated according to EN ISO 4063;
- c) reference to EN ISO 9692-2 in Tables 2, 3, 4 and 5 has been deleted.

EN 1708, *Welding — Basic welded joint details in steel* is composed of the following parts:

- *Part 1: Pressurized components;*
- *Part 2: Non internal pressurized components.*

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.

1 Scope

The purpose of this document is to exemplify sound and accepted welded connections applicable to welded not internal pressurized steel components. It does not promote the standardization of connections that may be regarded as mandatory or restrict development in any way. The requirements of carrying capacity, fitness for purposes, fatigue and corrosion stress will be considered if necessary.

This document contains examples of connections welded by the following processes (process numbers according to EN ISO 4063):

- Manual metal arc welding (111);
- Self-shielded tubular-cored arc welding (114);
- Submerged arc welding (12);
- MIG welding; Metal inert gas welding with solid wire electrode (131);
- MAG welding; Metal active gas welding with solid wire electrode (135);
- Tubular cored metal arc welding with active gas shield (136);
- MAG welding; Metal active gas welding with metal cored electrode (138);
- MIG welding; Metal inert gas welding with flux cored electrode (132);
- MIG welding; Metal inert gas welding with metal cored electrode (133);
- TIG welding; Tungsten inert gas arc welding (14).

Other processes by agreement.

Further requirements will be considered in accordance with existing application standards.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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.

EN 1792, *Welding - Multilingual list of terms for welding and related processes*

EN ISO 2553, *Welding and allied processes - Symbolic representation on drawings - Welded joints (ISO 2553)*

EN ISO 9692-1, *Welding and allied processes - Types of joint preparation - Part 1: Manual metal arc welding, gas-shielded metal arc welding, gas welding, TIG welding and beam welding of steels (ISO 9692-1)*

EN ISO 9692-2, *Welding and allied processes - Joint preparation - Part 2: Submerged arc welding of steels (ISO 9692-2)*

EN ISO 15614-1, *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)*

EN ISO 17659, *Welding - Multilingual terms for welded joints with illustrations (ISO 17659)*