

METALLIDE KEEVITUSPROTSEDUURIDE  
SPETSIFITSEERIMINE JA KVALIFITSEERIMINE.  
EELNEVAL KEEVITUSKOGEMUSEL PÕHINEV  
KVALIFITSEERIMINE

Specification and qualification of welding procedures  
for metallic materials - Qualification based on  
previous welding experience (ISO 15611:2024)

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>See Eesti standard EVS-EN ISO 15611:2024 sisaldab Euroopa standardi EN ISO 15611:2024 ingliskeelset teksti.</p> <p>Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.</p> <p>Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 17.01.2024.</p> <p>Standard on kättesaadav Eesti Standardimis- ja Akrediteerimiskeskusest.</p>	<p>This Estonian standard EVS-EN ISO 15611:2024 consists of the English text of the European standard EN ISO 15611:2024.</p> <p>This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation and Accreditation.</p> <p>Date of Availability of the European standard is 17.01.2024.</p> <p>The standard is available from the Estonian Centre for Standardisation and Accreditation.</p>
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EUROPEAN STANDARD

EN ISO 15611

NORME EUROPÉENNE

EUROPÄISCHE NORM

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Supersedes EN ISO 15611:2003

English Version

Specification and qualification of welding procedures for  
metallic materials - Qualification based on previous  
welding experience (ISO 15611:2024)

Descriptif et qualification d'un mode opératoire de  
soudage pour les matériaux métalliques - Qualification  
sur la base de l'expérience en soudage (ISO  
15611:2024)

Anforderung und Qualifizierung von Schweißverfahren  
für metallische Werkstoffe - Qualifizierung aufgrund  
von vorliegender schweißtechnischer Erfahrung (ISO  
15611:2024)

This European Standard was approved by CEN on 5 January 2024.

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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

## European foreword

This document (EN ISO 15611:2024) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with 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 July 2024, and conflicting national standards shall be withdrawn at the latest by July 2024.

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 15611:2003.

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

## Endorsement notice

The text of ISO 15611:2024 has been approved by CEN as EN ISO 15611:2024 without any modification.

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Quality management in the field of welding*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 15611:2003), which has been technically revised.

The main changes are as follows:

- normative references have been updated;
- [Clause 5](#) and [Clause 7](#) have been revised;
- [Clause 8](#) has been deleted;
- the bibliography has been deleted.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html). Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

## Introduction

In ISO 15607, one of the methods of welding procedure qualification is by relating to previous welding 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 document provides a route to welding procedure qualification based on this experience.

This document is a part of a series of standards, details of this series are given in ISO 15607:2019, Annex A.

This document is a preview generated by EVS

# Specification and qualification of welding procedures for metallic materials — Qualification based on previous welding experience

## 1 Scope

This document gives the necessary information to explain the requirements referenced in ISO 15607 about the qualification of welding procedures based on previous welding experience.

In addition, it gives the range of qualification.

The use of this document can be restricted by an application standard or a specification.

## 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.

ISO 14555, *Welding — Arc stud welding of metallic materials*

ISO 15607, *Specification and qualification of welding procedures for metallic materials — General rules*

ISO 15609 (all parts), *Specification and qualification of welding procedures for metallic materials — Welding procedure specification*

ISO 15614 (all parts), *Specification and qualification of welding procedures for metallic materials — Welding procedure test*

ISO 15620, *Welding — Friction welding of metallic materials*

ISO 18785-4, *Friction stir spot welding — Aluminium — Part 4: Specification and qualification of welding procedures*

ISO 25239-4, *Friction stir welding — Aluminium — Part 4: Specification and qualification of welding procedures*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 15607 apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

## 4 Preliminary welding procedure specifications (pWPS)

The qualification of a welding procedure related to previous welding experience shall be based on a pWPS according to ISO 14555, the relevant part of the ISO 15609 series, ISO 15620, ISO 18785-4 or ISO 25239-4. This pWPS shall specify the range for all the relevant parameters.