

KÕVAJOODISJOOTMINE. JOOTJATE JA JOOTMISSEADME
OPERAATORITE KVALIFIKATSIOONIKATSED

Brazing - Qualification testing of brazers and brazing
operators (ISO 13585:2021)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>See Eesti standard EVS-EN ISO 13585:2024 sisaldab Euroopa standardi EN ISO 13585:2024 ingliskeelset teksti.</p> <p>Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.</p> <p>Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 24.07.2024.</p> <p>Standard on kättesaadav Eesti Standardimis- ja Akrediteerimiskeskusest.</p>	<p>This Estonian standard EVS-EN ISO 13585:2024 consists of the English text of the European standard EN ISO 13585:2024.</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 24.07.2024.</p> <p>The standard is available from the Estonian Centre for Standardisation and Accreditation.</p>
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EUROPEAN STANDARD

EN ISO 13585

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Brazing - Qualification testing of brazers and brazing operators (ISO 13585:2021)

Brasage fort - Essais de qualification des braseurs et des opérateurs braseurs en brasage fort (ISO 13585:2021)

Hartlöten - Prüfung von Hartlötern und Bedienern von Hartlöteinrichtungen (ISO 13585:2021)

This European Standard was approved by CEN on 9 March 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

The text of ISO 13585:2021 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 13585:2024 by Technical Committee CEN/TC 121 "Welding and allied processes" the secretariat of which is held by AFNOR.

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of an identical text or by endorsement, at the latest by January 2025, and conflicting national standards shall be withdrawn at the latest by January 2025.

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 13585:2012.

This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

For the relationship with EU Legislation, see informative Annex ZA, which is an integral part of this document.

Any feedback and questions on this document should be directed to the users' national standards body. 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 13585:2021 has been approved by CEN as EN ISO 13585:2024 without any modification.

Contents

Page

Foreword.....	iv
1 Scope.....	1
2 Normative references.....	1
3 Terms and definitions.....	2
4 Symbols and abbreviated terms.....	3
5 Essential variables and range of qualification.....	4
5.1 General.....	4
5.2 Brazing process.....	5
5.3 Brazer qualification.....	5
5.3.1 Product type.....	5
5.3.2 Type of joint.....	5
5.3.3 Parent material group(s).....	5
5.3.4 Filler metals and brazing filler application.....	6
5.3.5 Dimensions.....	6
5.3.6 Filler metal flow direction.....	7
5.4 Brazing operator qualification.....	7
5.4.1 Type of equipment.....	7
5.4.2 Filler metals and brazing filler application.....	7
6 Examination and testing.....	7
6.1 Supervision.....	7
6.2 Brazing conditions.....	8
6.3 Test piece.....	8
6.4 Assessment of work pieces.....	8
6.5 Extent of testing.....	8
6.6 Visual testing.....	8
6.7 Non-destructive testing.....	9
6.8 Destructive testing.....	9
6.9 Additional examination and testing.....	9
7 Acceptance requirements for test pieces.....	9
8 Re-tests.....	9
9 Period of validity.....	10
9.1 Initial qualification.....	10
9.2 Prolongation.....	10
10 Certificate.....	10
11 Designation.....	11
Annex A (informative) Quality requirements for brazing.....	12
Annex B (informative) Brazer qualification test certificate.....	13
Annex C (informative) Brazing operator qualification test certificate.....	15
Annex D (informative) Other non-essential variables.....	16
Annex E (normative) Material grouping system.....	17
Annex F (informative) Examples of test pieces.....	19
Bibliography.....	21

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).

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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.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes* Subcommittee SC 11, *Qualification requirements for welding and allied processes personnel*.

This second edition cancels and replaces the first edition (ISO 13585:2012), which has been technically revised.

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

- brazing processes, in accordance with ISO 4063:2009, covered by this document, have been moved to the scope;
- [Clause 3](#) has been updated and additional terms have been defined;
- additional symbols and abbreviated terms have been added to [Clause 4](#);
- [Clause 5](#) has been significantly revised and updated including clarifications on brazing operator qualification;
- material grouping has been moved to new [Annex E](#);
- [Clause 6](#) has been updated to refer to ISO or technically equivalent standards;
- the period of validity and prolongation of qualifications has been revised to 5 years in [Clause 9](#).

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.

Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

Brazing — Qualification testing of brazers and brazing operators

1 Scope

This document specifies requirements for qualification testing of brazers and brazing operators for metallic materials.

This document gives general provisions on quality requirements for brazing (see [Annex A](#)).

This document applies to the following brazing processes according to ISO 857-2 and ISO 4063:2009 with local and global heating:

- 911 Infrared brazing;
- 912 Flame brazing, torch brazing;
- 913 Laser beam brazing;
- 914 Electron beam brazing;
- 916 Induction brazing;
- 918 Resistance brazing;
- 919 Diffusion brazing;
- 921 Furnace brazing;
- 922 Vacuum brazing;
- 923 Dip-bath brazing;
- 924 Salt-bath brazing;
- 925 Flux bath brazing;
- 926 Immersion brazing;
- 972 Arc weld brazing.

This document is not applicable to personnel operating brazing equipment who do not have any direct influence on the quality of the brazed joint, for example, personnel performing exclusively loading/unloading the brazing unit or just initiating the brazing cycle in automatic brazing.

The principles of this document can be applied to other brazing processes and brazing of materials not listed.

This document does not apply to brazing for aerospace applications covered by ISO 11745.

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

ISO 4063:2009, *Welding and allied processes — Nomenclature of processes and reference numbers*

ISO 17672, *Brazing — Filler metals*

ISO 17779, *Brazing — Specification and qualification of brazing procedures for metallic materials*

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

ISO/TR 25901-1, *Welding and allied processes — Vocabulary — Part 1: General terms*

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

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

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 857-2, ISO/TR 25901-1 and the following 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/>

3.1

brazing

joining process using *filler metal* (3.12) with a liquidus temperature above 450 °C

[SOURCE: ISO 857-2:2005, 3.1.2.]

3.2

brazer

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

Note 1 to entry: The brazer verifies compliance with the pBPS or BPS prior to and during brazing.

3.3

brazing operator

person who controls or adjusts brazing parameters for *mechanized brazing* (3.5) or sets up brazing parameters for *automatic brazing* (3.6)

Note 1 to entry: The brazing operator verifies compliance with the pBPS or BPS prior to and during the brazing cycle.

3.4

manual brazing

brazing (3.1) where the required brazing conditions are maintained by hand

3.5

mechanized brazing

brazing (3.1) where the required brazing conditions are maintained by mechanical or electronic means but can be manually varied during the process

3.6

automatic brazing

brazing (3.1) in which all operations are performed without *brazing operator* (3.3) intervention during the process

Note 1 to entry: Manual adjustment of brazing variables by the brazing operator during brazing is not possible.