

**TERMOLÕIKAMINE. TERMOLÕIGETE
KLASSIFITSEERIMINE. TOOTE GEOMEETRILISED
SPETSIFIKATSIOONID JA KVALITEEDI TOLERANTSID.**

**Thermal cutting - Classification of thermal cuts -
Geometrical product specification and quality tolerances
(ISO 9013:2017 + ISO 9013:2017/Amd 1:2024)**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN ISO 9013:2017+A1:2024 sisaldab Euroopa standardi EN ISO 9013:2017 ja selle muudatuse A1:2024 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 9013:2017+A1:2024 consists of the English text of the European standard EN ISO 9013:2017 and its amendment A1:2024.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas. Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 15.02.2017, muudatus A1 25.09.2024.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation and Accreditation. Date of Availability of the European standard is 15.02.2017, for A1 25.09.2024.
Muudatusega A1 lisatud või muudetud teksti algus ja lõpp on tekstis tähistatud sümboolitega $\boxed{A1}$ $\boxed{A1}$.	The start and finish of text introduced or altered by amendment A1 is indicated in the text by tags $\boxed{A1}$ $\boxed{A1}$.
Standard on kättesaadav Eesti Standardimis- ja Akrediteerimiskeskusest.	The standard is available from the Estonian Centre for Standardisation and Accreditation.

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English Version

Thermal cutting - Classification of thermal cuts -
Geometrical product specification and quality tolerances
(ISO 9013:2017 + ISO 9013:2017/Amd 1:2024)

Coupage thermique - Classification des coupes
thermiques - Spécification géométrique des produits et
tolérances relatives à la qualité (ISO 9013:2017 + ISO
9013:2017/Amd 1:2024)

Thermisches Schneiden - Einteilung thermischer
Schnitte - Geometrische Produktspezifikation und
Qualität (ISO 9013:2017 + ISO 9013:2017/Amd
1:2024)

This European Standard was approved by CEN on 1 January 2017. Amendment A1 was approved by CEN on 16 April 2024.

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

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

European foreword

This document (EN ISO 9013:2017) 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 August 2017, and conflicting national standards shall be withdrawn at the latest by August 2017.

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Endorsement notice

The text of ISO 9013:2017 has been approved by CEN as EN ISO 9013:2017 without any modification.

A1 Amendment A1 European foreword

This document (EN ISO 9013:2017/A1:2024) 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 AFNOR.

This Amendment to the European Standard EN ISO 9013:2017 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by March 2025, and conflicting national standards shall be withdrawn at the latest by March 2025.

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Endorsement notice

The text of ISO 9013:2017/Amd 1:2024 has been approved by CEN as EN ISO 9013:2017/A1:2024 without any modification. **A1**

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Foreword

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The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 8, *Equipment for gas welding, cutting and allied processes*.

This third edition cancels and replaces the second edition (ISO 9013:2002), which has been technically revised.

Requests for official interpretations of any aspect of this document should be directed to the Secretariat of ISO/TC 44/SC 8 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

A1 Amendment A1 Foreword

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 8, *Equipment for gas welding, cutting and allied processes*, 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).

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Thermal cutting — Classification of thermal cuts — Geometrical product specification and quality tolerances

1 Scope

This document presents geometrical product specifications and quality tolerances for the classification of thermal cuts in materials suitable for oxyfuel flame cutting, plasma cutting and laser cutting. It is applicable to flame cuts from 3 mm to 300 mm, plasma cuts from 0,5 mm to 150 mm and laser cuts from 0,5 mm to 32 mm.

The geometrical product specifications are applicable if reference to this document is made in drawings or pertinent documents, e.g. delivery conditions. If this document were also to apply, by way of exception, to parts produced by other cutting processes, this would have to be agreed upon separately.

Flatness defects are not addressed as such in this document. The references are to the current standards for the materials used.

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.

A1 *deleted text* **A1**

ISO 3274, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Nominal characteristics of contact (stylus) instruments*

A1 ISO 21920-3, *Geometrical product specifications (GPS) – Surface texture: Profile – Part 3: Specification operators* **A1**

ISO 8015, *Geometrical product specifications (GPS) — Fundamentals — Concepts, principles and rules*

3 Terms and definitions

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

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

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

3.1 General

3.1.1

cutting

operation of cutting the work piece

3.1.2

cut

result of the cutting operation