

**Keevitus. Elektron- ja laserkiirega
keevitatud liited. Juhised kvaliteeditasemete
määramiseks vastavalt keevitusvigadele.
Osa 1: Teras**

Welding - Electrons and laser beam welded joints -
Guidance on quality levels for imperfections - Part 1:
Steel

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN ISO 13919-1:1999 sisaldab Euroopa standardi EN ISO 13919-1:1996 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 23.11.1999 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN ISO 13919-1:1999 consists of the English text of the European standard EN ISO 13919-1:1996.</p> <p>This document is endorsed on 23.11.1999 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
--	---

<p>Käsitlusala: Käesolev standard annab juhiseid terase elektron- ja laserkiirkeevitatud liidete kvaliteeditasemete määramiseks keevitusvigade järgi. Esitatud on kolm taset, mida on võimalik kasutada väga erinevate keevistoodete korral. Need tasemed kehtivad tööstuslike toodete valmistamiskvaliteedi kohta, mitte aga kasutuseesmärgile vastavuse kohta. Käesolevat standardit rakendatakse elektron- ja laserkiirkeevitamise korral järgmistel juhtudel: mittelegeer- ja legeerterased; - kõik keevisõmbluste tüübid, kus on kasutatud lisametalli traate; - 0,5 mm või paksemad materjalid.</p>	<p>Scope:</p>
--	----------------------

ICS 25.160.40

Võtmesõnad: defektid, elekterkeevitus, elektronkiirkeevitus, keevislited, keevitus, keevitusvead, klassifikatsioon, kvaliteediklassid, sulakeevitus, terased

ICS 23.160.40

Descriptors: Welding, welded joints, quality levels.

English version

Welding

Electron and laser beam welded joints

Guidance on quality levels for imperfections

Part 1: Steel

(ISO 13919-1:1996)

Soudage – Assemblages soudés par faisceau d'électrons et par faisceau laser – Guide des niveaux de qualité des défauts – Partie 1: Acier (ISO 13919-1:1996)

Schweißen – Elektronen- und Laserstrahl-Schweißverbindungen – Leitfaden für Bewertungsgruppen für Unregelmäßigkeiten – Teil 1: Stahl (ISO 13919-1:1996)

This European Standard was approved by CEN on 1996-07-10.

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 Central Secretariat 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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart 36, B-1050 Brussels

Contents

	Page
Foreword	2
Introduction	2
1 Scope	4
2 Normative references	4
3 Symbols	4
4 Evaluation of welds	4
Annex A (informative) Additional information for use of this standard	12

Foreword

International Standard

ISO 13919-1:1996 Welding – Electron and laser-beam welded joints – Guidance on quality levels for imperfections – Steel, which was prepared by ISO/TC 44 ‘Welding and allied processes’ of the International Organization for Standardization, has been adopted by Technical Committee CEN/TC 121 ‘Welding’ as a European Standard.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, and conflicting national standards withdrawn, by February 1997 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard:

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

Endorsement notice

The text of the International Standard ISO 13919-1:1996 was approved by CEN as a European Standard without any modification.

Introduction

This European standard should be used as a reference in the drafting of application codes and/or for other application standards. It may be used within a total quality system for the production of satisfactory welded joints. It provides three sets of dimensional values from which a selection can be made for a particular application. The quality level necessary in each case should be defined by the application standard or the responsible designer in conjunction with the manufacturer, user and/or other parties concerned. The level shall be prescribed before the start of production, preferably at the inquiry or order stage. For special purposes, additional details may need to be prescribed.

The quality levels given in this standard are intended to provide basic reference data and are not specifically related to any particular application. They refer to welded joints and not the complete product or component itself. It is possible, therefore, for different quality levels to be applied to individual welded joints in the same product or component. Quality levels are listed in table 1.

Table 1: Quality levels for weld imperfections

Level symbol	Quality level
D	Moderate
C	Intermediate
B	Stringent

The three quality levels are arbitrarily identified as D, C and B and are intended to cover the majority of practical applications.

If higher requirements are made on welds than compatible with the above levels (e.g. for dynamic loading) such welds may be machined or ground after welding in order to remove surface imperfections.

It would normally be hoped that for a particular welded joint the dimensional limits for imperfections could all be covered by specifying one quality level. In some cases, however, e.g. for certain types of steels and structures as well as for fatigue loading or leak tightness applications it may be necessary to specify different quality levels for different imperfections in the same welded joint or to include additional requirements.

The choice of quality level for any application should take account of design considerations, subsequent processing, e.g. surfacing, mode of stressing (e.g. static, dynamic), service conditions (e.g. temperature, environment), and consequences of failure. Economic factors are also important and should include not only the cost of welding but also that of inspection, test and repair.

Although this standard includes types of imperfections relevant to the electron and laser beam welding processes, only those which are applicable to the process and application in question need to be considered.

Imperfections are quoted in terms of their actual dimensions, and their detection and evaluation may require the use of one or more methods of non-destructive testing. The detection and sizing of imperfections is dependent on the inspection methods and the extent of testing specified in the application standard or contract.

This standard does not include details of recommended methods of detection and sizing and, therefore, it needs to be supplemented by requirements for examination, inspection and testing. It should be appreciated that methods of non-destructive examination may not be able to give the detection, characterisation and sizing necessary for use within certain types of imperfections shown in table 2.

Although this standard covers a material thicknesses (penetration depths) from 0,5 mm and above for electron and laser beam welding. It should be noted that the permitted size for all types of imperfection has an absolute, upper limit. Application for thicknesses above 50 mm for electron beam welding and 12 mm for laser beam welding is, for that reason, usually safe, but may be overly conservative and may require special precautions, such as weld bead dressing in order to comply with the limits for reinforcement and undercut. Attention should be paid to such precautions during approval testing of the welding procedure and alternative requirements may have to be specified, if necessary.

Preview generated by EVS

1 Scope

This standard gives guidance on levels of imperfections in electron and laser beam welded joints in steel. Three levels are given in such a way as to permit application for a wide range of welded fabrications. The levels refer to production quality and not to the fitness-for-purpose of the product manufactured.

This standard applies to electron and laser beam welding of:

- unalloyed and alloyed steels;
- all types of welds welded with or without additional filler wire;
- materials equal to or above 0,5 mm thickness for electron and laser beam welding.

When significant deviations from the joint geometries and dimensions stated in this standard are present in the welded product, it is necessary to evaluate to what extent the provisions of this standard can apply.

Metallurgical aspects, e.g. grain size, hardness are not covered by this standard.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 25817

Arc welded joints in steel - Guidance on quality levels for imperfections (ISO 5817:1992)

EN 26520:

Classification of imperfections in metallic fusion welds, with explanations (ISO 6520:1982)

3 Symbols

The following symbols are used in table 2:

ΔL	distance between two imperfections (pore, cavity)
b	width of weld
d	maximum size of an imperfection (pore, cavity)
f	projected areas of pores or cavities
g	distance from centerline in T-joint
h	size of the imperfection (height, width)
$h_1; h_2$	deviation from the weld penetration
l	length of imperfection (measured in any direction)
L	weld length under consideration (weld length examined)
L_c	length of combined porosity (affected weld length)
s	weld penetration
s_t	weld penetration in T-joint
t	workpiece thickness

4 Evaluation of welds

Limits for imperfections are given in table 2.

A welded joint should normally be evaluated separately for each individual type of imperfection. Different types of imperfection occurring at any cross-section of the joint may need special consideration.