
**Health and safety in welding and allied
processes — Laboratory method for
sampling fume and gases —**

Part 5:

**Identification of thermal-degradation
products generated when welding or
cutting through products composed
wholly or partly of organic materials
using pyrolysis-gas chromatography-
mass spectrometry**

*Hygiène et sécurité en soudage et techniques connexes — Méthode de
laboratoire d'échantillonnage des fumées et des gaz —*

*Partie 5: Identification des produits de dégradation thermique
générés lors du soudage ou du coupage de produits entièrement
ou partiellement constitués de matériaux organiques, par pyrolyse-
chromatographie en phase gazeuse-spectrométrie de masse*



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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 15011-5 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 9, *Health and safety*.

This first edition cancels and replaces ISO/TS 15011-5:2006, which has been technically revised.

ISO 15011 consists of the following parts, under the general title *Health and safety in welding and allied processes — Laboratory method for sampling fume and gases*:

- *Part 1: Determination of fume emission rate during arc welding and collection of fume for analysis*
- *Part 2: Determination of emission rates of carbon monoxide (CO), carbon dioxide (CO₂), nitrogen monoxide (NO) and nitrogen dioxide (NO₂) during arc welding, cutting and gouging*
- *Part 3: Determination of ozone emission rate during arc welding*
- *Part 4: Fume data sheets*
- *Part 5: Identification of thermal-degradation products generated when welding or cutting through products composed wholly or partly of organic materials using pyrolysis-gas chromatography-mass spectrometry*
- *Part 6: Procedure for quantitative determination of fume and gases from resistance spot welding* [Technical Specification]

Requests for official interpretations of any aspect of this part of ISO 15011 should be directed to the Secretariat of ISO/TC 44/SC 9, via your national standards body. A complete listing of these bodies can be found at www.iso.org.

Introduction

Welding and allied processes generate fume and gases, which, if inhaled, can be harmful to human health. Knowledge of the composition and the emission rate of the fume and gases can be useful to occupational hygienists in assessing worker exposure and in determining appropriate control measures.

ISO 15011-1^[1] and ISO 15011-2^[2] have been promulgated primarily to generate emission rate data when welding uncoated metals. However, it is now common practice in the welding industry to weld or cut through a variety of coatings that are composed wholly or partly of organic materials. These coatings include shop primers, paints, oils, waxes and inter-weld materials such as adhesives and sealants. When heated, these coatings give rise to a wide range of thermal degradation products, the composition of which depends upon the temperatures to which the coatings are subjected. During welding and cutting activities, the coating material is subjected to a range of temperatures due to the existence of temperature profiles within the material being processed.

The purpose of this part of ISO 15011 is to describe procedures that can be used to identify and make semi-quantitative measurements of the organic components generated when welding and cutting, preheating and straightening metal treated with the coatings mentioned above, with a view to identifying those components that are significant hygienically. The data generated can be used to provide information on degradation products for use on safety data sheets. If desired, the degradation products identified in these tests can then be measured quantitatively using existing standards for making workplace exposure measurements.

Comparative testing of various weld-through coatings has been carried out using laboratory based heating tests, pyrolysis, and different welding techniques^{[3][4][5]}. From the results of these tests, it was decided that pyrolysis should be adopted as the basis for the testing procedure^[6] prescribed in this part of ISO 15011. This was based on the following observations and conclusions:

- pyrolysis successfully identifies most of the hygienically significant components;
- despite the fact that pyrolysis tests are carried out in an atmosphere of helium, results are very comparable with those obtained in air by thermal decomposition in a furnace;
- the cost of pyrolysis testing is significantly lower than the cost of welding tests;
- pyrolysis test results show good interlaboratory consistency;
- it is easier to define standard conditions for pyrolysis tests than for welding tests; and
- in order to reduce the sampling regime required, any welding test programme would, in all likelihood, need to incorporate some pre-testing in the laboratory, probably using pyrolysis.

Health and safety in welding and allied processes — Laboratory method for sampling fume and gases —

Part 5:

Identification of thermal-degradation products generated when welding or cutting through products composed wholly or partly of organic materials using pyrolysis-gas chromatography-mass spectrometry

1 Scope

This part of ISO 15011 specifies procedures for obtaining information about thermal degradation products generated when welding, cutting through, preheating and straightening metal treated with coatings composed wholly or partly of organic substances, e.g. shop primers, paints, oils, waxes and inter-weld materials such as adhesives and sealants. It is aimed primarily at test laboratories performing such procedures. The data generated can be used by coating manufacturers to provide information for inclusion in safety data sheets and by occupational hygienists to identify thermal degradation products of significance in the performance of risk assessments and/or workplace exposure measurements. The data cannot be used to estimate workplace exposure directly.

This part of ISO 15011 is applicable to all coatings composed partly or wholly of organic materials that can be heated during welding and cutting, preheating and straightening to temperatures at which thermal degradation products are generated and where it is not apparent what those degradation products are.

2 Normative references

The following referenced documents are indispensable for the application 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 16000-6, *Indoor air — Part 6: Determination of volatile organic compounds in indoor and test chamber air by active sampling on Tenax TA® sorbent, thermal desorption and gas chromatography using MS/FID*

3 Terms and definitions

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

3.1

chemical agent

any chemical element or compound, on its own or admixed, as it occurs in the natural state or as produced, used or released, including release as waste, by any work activity, whether or not produced intentionally and whether or not placed on the market

[Council Directive 98/24/EC^[7], Art. 2(a)]