



SLOVENSKI STANDARD
SIST EN 287-1:2004/A2:2006
01-julij-2006

Preskušanje varilcev - Talično varjenje - 1. del: Jekla

Qualification test of welders - Fusion welding - Part 1: Steels

Prüfung von Schweißern - Schmelzschweißen - Teil 1: Stähle

Epreuve de qualification des soudeurs - Soudage par fusion - Partie 1 : Aciers

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Ta slovenski standard je istoveten z: EN 287-1:2004/A2:2006

[SIST EN 287-1:2004/A2:2006](https://standards.iteh.ai/catalog/standards/sist/8c5d62b1-9508-4c68-a227-8be1a54d2172/sist-en-287-1-2004-a2-2006)

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ICS:

25.160.10 Varilni postopki in varjenje Welding processes

SIST EN 287-1:2004/A2:2006

en

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ICS 25.160.10

English Version

Qualification test of welders - Fusion welding - Part 1: Steels

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fusion - Partie 1 : Aciers

Prüfung von Schweißern - Schmelzschweißen - Teil 1:
Stähle

This amendment A2 modifies the European Standard EN 287-1:2004; it was approved by CEN on 3 February 2006.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant 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 amendment 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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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

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Foreword

This European Standard (EN 287-1:2004/A2:2006) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DIN.

This Amendment to the European Standard EN 287-1:2004 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by September 2006, and conflicting national standards shall be withdrawn at the latest by September 2006.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this European Standard.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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Introduction

The publication of EN ISO 5817:2003 caused some significant increase in requirements concerning incorrect weld toe, undercut and angular misalignment in EN 287-1:2004. As corrective action, this Amendment is published.

This document incorporates also the revised Annex ZA, which was circulated with document EN 287-1:2004/AC:2004, with the modification of the reference to all normative clauses of EN 287-1.

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Subclause 5.3, b), second dash

The wording shall be amended as follows:

— welding position PE for plates covers outside pipe diameter $D \geq 500$ mm in welding position PF.

Clause 7

The 3rd paragraph is amended by the following wording (underlined):

The acceptance requirements for imperfections found by test methods according to this standard shall, unless otherwise specified, be assessed in accordance with EN ISO 5817. A welder is qualified if the imperfections are within quality level B in EN ISO 5817, except for imperfections as follows; excess weld metal, excessive convexity, excessive throat thickness and excessive penetration and incorrect weld toe, for which level C shall apply. The requirement $h \leq 0,05 t$ does not apply for undercut. Undercut shall not exceed 0,5 mm. Angular misalignment is not applicable for the welder qualification test.

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ANNEX ZA (informative)

Relationship between this European Standard and the Essential Requirements of EU Directive 97/23/EC

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association to provide a means of conforming to Essential Requirements of the New Approach Directive 97/23/EC.

Once this standard is cited in the Official Journal of the European Union under that Directive and has been implemented as a national standard in at least one Member State, compliance with the clauses of this standard given in Table ZA confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding Essential Requirements of that Directive and associated EFTA regulations.

Table ZA.1 — Correspondence between this European Standard and Directive 97/23/EC

Clauses/sub-clauses of this European Standard	Essential requirements (ERs) of Directive 97/23/EC	Qualifying remarks/Notes
Clauses 5, 6, 7, 8, 9, 10, 11	Annex I, 3.1.2	Permanent joining

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WARNING: Other requirements and other EU Directives may be applicable to the product(s) falling within the scope of this standard.

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