



**SLOVENSKI STANDARD**  
**SIST EN ISO 25239-5:2012**  
**01-marec-2012**

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**Varjenje z gnetenjem - Aluminij - 5. del: Zahteve za kakovost in kontrolo (ISO 25239-5:2011)**

Friction stir welding - Aluminium - Part 5: Quality and inspection requirements (ISO 25239-5:2011)

Rührreibschweißen - Aluminium - Teil 5: Qualitäts- und Prüfungsanforderungen (ISO 25239-5:2011)

Soudage par friction-malaxage - Aluminium - Partie 5: Exigences de qualité et de contrôle (ISO 25239-5:2011)

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**ICS:**

03.120.99	Drugi standardi v zvezi s kakovostjo	Other standards related to quality
25.160.10	Varilni postopki in varjenje	Welding processes
77.120.10	Aluminij in aluminijeve zlitine	Aluminium and aluminium alloys

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EUROPEAN STANDARD

EN ISO 25239-5

NORME EUROPÉENNE

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ICS 25.160.10

English Version

## Friction stir welding - Aluminium - Part 5: Quality and inspection requirements (ISO 25239-5:2011)

Soudage par friction-malaxage - Aluminium - Partie 5:  
Exigences de qualité et de contrôle (ISO 25239-5:2011)

Rührreißschweißen - Aluminium - Teil 5: Qualitäts- und  
Prüfungsanforderungen (ISO 25239-5:2011)

This European Standard was approved by CEN on 4 June 2011.

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**Contents**

Page

Foreword.....3

**iTeh STANDARD PREVIEW  
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[SIST EN ISO 25239-5:2012](https://standards.iteh.ai/catalog/standards/sist/dab1f03d-f94d-4d0f-854f-0f0fee99630c/sist-en-iso-25239-5-2012)

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## Foreword

This document (EN ISO 25239-5:2011) has been prepared by the International Institute of Welding in collaboration with Technical Committee CEN/TC 121 "Welding" 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of an identical text or by endorsement, at the latest by June 2012, and conflicting national standards shall be withdrawn at the latest by June 2012.

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

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, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

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The text of ISO 25239-5:2011 has been approved by CEN as a EN ISO 25239-5:2011 without any modification.

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# INTERNATIONAL STANDARD

**ISO**  
**25239-5**

First edition  
2011-12-15

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## Friction stir welding — Aluminium — Part 5: Quality and inspection requirements

*Soudage par friction-malaxage — Aluminium —*

*Partie 5: Exigences de qualité et de contrôle*

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## Contents

Page

Foreword .....	iv
Introduction.....	v
1 Scope .....	1
2 Normative references .....	1
3 Terms and definitions .....	2
4 Quality requirements.....	2
4.1 General .....	2
4.2 Welding personnel .....	2
4.3 Inspection and testing personnel .....	2
4.4 Equipment .....	2
4.5 Welding procedure specification.....	3
4.6 Friction stir welding tool.....	4
4.7 Preweld joint preparation and fit-up.....	4
4.8 Preheating and interpass temperature control .....	4
4.9 Tack welds .....	4
4.10 Welding.....	4
4.11 Postweld heat treatment.....	4
4.12 Inspection and testing .....	4
4.13 Identification and traceability.....	6
Annex A (normative) Imperfections, testing and examination, acceptance levels, and ISO 6520-1 reference number.....	7
Bibliography.....	9

## ISO 25239-5:2011(E)

## 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 25239-5 was prepared by the International Institute of Welding, which has been approved as an international standardizing body in the field of welding by the ISO Council.

ISO 25239 consists of the following parts, under the general title *Friction stir welding — Aluminium*:

- *Part 1: Vocabulary*
- *Part 2: Design of weld joints*
- *Part 3: Qualification of welding operators*
- *Part 4: Specification and qualification of welding procedures*
- *Part 5: Quality and inspection requirements*

Requests for official interpretations of any aspect of this part of ISO 25239 should be directed to the ISO Central Secretariat, who will forward them to the IIW Secretariat for an official response.

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## Introduction

Welding processes are widely used in the fabrication of engineered structures. During the second half of the twentieth century, fusion welding processes, wherein fusion is obtained by the melting of parent material and usually a filler metal, dominated the welding of large structures. Then, in 1991, Wayne Thomas at TWI invented friction stir welding (FSW), which is carried out entirely in the solid phase (no melting).

The increasing use of FSW has created the need for this International Standard in order to ensure that welding is carried out in the most effective way and that appropriate control is exercised over all aspects of the operation. This International Standard focuses on the FSW of aluminium because, at the time of publication, the majority of commercial applications for FSW involved aluminium. Examples include railway carriages, consumer products, food processing equipment, aerospace structures, and marine vessels.

The parts of this International Standard are listed in the foreword.

Part 1 defines terms specific to FSW.

Part 2 specifies design requirements for friction stir weld joints in aluminium.

Part 3 specifies requirements for the qualification of an operator for the FSW of aluminium.

Part 4 specifies requirements for the specification and qualification of welding procedures for the FSW of aluminium. A welding procedure specification (WPS) is needed to provide a basis for planning welding operations and for quality control during welding. Welding is considered a special process in the terminology of standards for quality systems. Standards for quality systems usually require that special processes be carried out in accordance with written procedure specifications. Metallurgical deviations constitute a special problem. Because non-destructive testing of the mechanical properties is impossible at the present level of technology, this has resulted in the establishment of a set of rules for qualification of the welding procedure prior to the release of the WPS to actual production. ISO 25239-4 defines these rules.

Part 5 specifies a method for determining the capability of a manufacturer to use the FSW process for the production of aluminium products of the specified quality. It defines specific quality requirements but does not assign those requirements to any specific product group. To be effective, welded structures should be free from serious problems in production and in service. To achieve that goal, it is necessary to provide controls from the design phase through material selection, fabrication, and inspection. For example, poor design can create serious and costly difficulties in the workshop, on site, or in service. Incorrect material selection can result in welding problems, such as cracking. Welding procedures have to be correctly formulated and qualified to avoid imperfections. To ensure the fabrication of a quality product, management should understand the sources of potential trouble and introduce appropriate quality and inspection procedures. Supervision should be implemented to ensure that the specified quality is achieved.