



**SLOVENSKI STANDARD**  
**oSIST prEN ISO 9606-1:2008**  
**01-oktober-2008**

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**Preskušanje varilcev - Talilno varjenje - 1. del: Jeklo (ISO/DIS 9606-1:2008)**

Qualification test of welders - Fusion welding - Part 1: Steels (ISO/DIS 9606-1:2008)

Prüfung von Schweißern - Schmelzschweißen - Teil 1: Stähle (ISO/DIS 9606-1:2008)

Épreuve de qualification des soudeurs - Soudage par fusion - Partie 1: Aciers (ISO/DIS 9606-1:2008)

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**ICS:**

25.160.10      Varilni postopki in varjenje      Welding processes

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**DRAFT**  
**prEN ISO 9606-1**

April 2008

ICS 25.160.10

Will supersede EN 287-1:2004

English Version

## Qualification test of welders - Fusion welding - Part 1: Steels (ISO/DIS 9606-1:2008)

Épreuve de qualification des soudeurs - Soudage par  
fusion - Partie 1: Aciers (ISO/DIS 9606-1:2008)

Prüfung von Schweißern - Schmelzschweißen - Teil 1:  
Stähle (ISO/DIS 9606-1:2008)

This draft European Standard is submitted to CEN members for second parallel enquiry. It has been drawn up by the Technical Committee CEN/TC 121.

If this draft becomes a European Standard, 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.

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**Contents**

Page

Foreword.....3

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## Foreword

This document (prEN ISO 9606-1:2008) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding" the secretariat of which is held by DIN.

This document is currently submitted to the second parallel Enquiry.

This document will supersede EN 287-1:2004.

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

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The text of ISO/DIS 9606-1:2008 has been approved by CEN as a prEN ISO 9606-1:2008 without any modification.

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## DRAFT INTERNATIONAL STANDARD ISO/DIS 9606-1.2

ISO/TC 44/SC 11

Secretariat: **SUTN**
 Voting begins on:  
**2008-04-24**

 Voting terminates on:  
**2008-08-24**

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# Qualification testing of welders — Fusion welding —

## Part 1: Steels

*Épreuve de qualification des soudeurs — Soudage par fusion —*
*Partie 1: Aciers*

(Revision of first edition ISO 9606-1:1994 and ISO 9606-1:1994/Amd.1:1998)

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# Contents

Page

Foreword .....	v
Introduction.....	2
1 Scope .....	2
2 Normative references .....	2
3 Terms and definitions .....	3
4 Symbols and abbreviated terms .....	5
4.1 General .....	5
4.2 Reference numbers of welding processes .....	5
4.3 Abbreviations.....	5
4.3.1 For test pieces .....	5
4.3.2 For consumables.....	6
4.3.3 For other weld details .....	6
4.3.4 For bend tests.....	6
5 Essential variables and range of qualification .....	6
5.1 General .....	6
5.2 Welding processes .....	7
5.3 Product type.....	8
5.4 Type of weld .....	8
5.5 Filler material groups .....	8
5.5.1 Steel groups of filler material.....	8
5.5.2 Range of qualification .....	9
5.6 Welding consumables.....	9
5.7 Dimensions .....	10
5.8 Welding positions.....	12
5.9 Weld details.....	13
6 Examination and testing .....	14
6.1 Examination .....	14
6.2 Test pieces .....	15
6.3 Welding conditions .....	18
6.4 Test methods .....	19
6.5 Test piece and test specimen .....	19
6.5.1 General .....	19
6.5.2 Butt weld in plate and pipe .....	19
6.5.3 Fillet weld on plate .....	21
6.5.4 Fillet weld on pipe .....	23
6.6 Test record .....	23
7 Acceptance requirements for test pieces .....	23
8 Re-tests.....	24
9 Period of validity.....	24
9.1 Initial qualification .....	24
9.2 Confirmation of the validity .....	24
9.3 Prolongation of qualification.....	24
9.4 Revocation of qualification.....	25
10 Certificate .....	25
11 Designation .....	25
Annex A (informative) Welder's qualification test certificate .....	27

## ISO/DIS 9606-1.2 (E)

<b>Annex B</b> (informative) <b>Job knowledge</b> .....	<b>29</b>
<b>B.1</b> <b>General</b> .....	<b>29</b>
<b>B.2</b> <b>Requirements</b> .....	<b>29</b>
<b>B.2.1</b> <b>Welding equipment</b> .....	<b>29</b>
<b>B.2.2</b> <b>Welding process</b> .....	<b>30</b>
<b>B.2.3</b> <b>Parent metals</b> .....	<b>30</b>
<b>B.2.4</b> <b>Welding consumables</b> .....	<b>30</b>
<b>B.2.5</b> <b>Safety precautions</b> .....	<b>31</b>
<b>B.2.6</b> <b>Welding sequences/procedures</b> .....	<b>31</b>
<b>B.2.7</b> <b>Joint preparation and weld representation</b> .....	<b>31</b>
<b>B.2.8</b> <b>Weld imperfections</b> .....	<b>32</b>
<b>B.2.9</b> <b>Welder qualification</b> .....	<b>32</b>
<b>Annex C</b> (informative) <b>FW/BW test assembly option</b> .....	<b>33</b>
<b>Annex ZA</b> (informative) <b>Relationship between this International Standard and the Essential requirements of EU Directive 97/23</b> .....	<b>34</b>

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<https://standards.iteh.ai/catalog/standards/sist/f6b5436-f973-4b9-80ee-ea2ec93fb188/osist-pren-iso-9606-1-2008>

## Foreword

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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 9606-1 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 11, *Qualification requirements for welding and allied processes personnel*.

This second edition cancels and replaces the first edition (ISO 9606-1:1994), which has been technically revised. It also incorporates ISO 9606-1:1994/Amd 1:1998.

Requests for official interpretations of any aspect of this standard should be directed to the Secretariat of ISO/TC 44/SC 11 via your national standards body, a complete listing which can be found at [www.iso.org](http://www.iso.org).

ISO 9606 consists of the following parts, under the general title *Qualification testing of welders — Fusion welding*:

- *Part 1: Steels*
- *Part 2: Aluminium and aluminium alloys*
- *Part 3: Copper and copper alloys*
- *Part 4: Nickel and nickel alloys*
- *Part 5: Titanium and titanium alloys, zirconium and zirconium alloys*

Annexes A and B of this part of ISO/DIS 9606-1:2007 are for information only.

**ISO/DIS 9606-1.2 (E)****Introduction**

The ability of a welder to follow verbal or written instructions and verification of a person's skills are important factors in ensuring the quality of the welded product.

The testing of a welder's skill in accordance with this standard depends on welding techniques and conditions used in which uniform rules are complied with, and standard test pieces are used.

The principle of this standard is that a qualification test qualifies a welder not only for the conditions used in the test, but also for all other conditions which are considered easier to weld in accordance with this standard. It is presumed that the welder has received training and/or has industrial practice within the range of qualification.

The qualification test can be used to qualify a welding procedure and a welder provided that all the relevant requirements e.g. test piece dimensions and testing requirements are satisfied (see ISO 15614-1).

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# Qualification testing of welders — Fusion welding —

## Part 1: Steels

### 1 Scope

This International Standard defines the requirements for qualification testing of welders for fusion welding of steels.

It provides a set of technical rules for a systematic qualification test of the welder, and enables such qualifications to be uniformly accepted independently of the type of product, location and examiner/examining body.

When qualifying welders, the emphasis is placed on the welder's ability to manually manipulate the electrode/welding torch/welding blowpipe and thereby producing a weld of acceptable quality.

The welding processes referred to in this standard include those fusion welding processes which are designated as manual or partly mechanized welding. It does not cover fully mechanized and automated welding processes (see ISO 14732).

### 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 referred document (including any amendments) applies.

ISO 857-1, *Welding and allied processes — Vocabulary — Part 1: Welding processes*

ISO 4063, *Welding and allied processes — Nomenclature of processes and reference numbers*

ISO 5173, *Destructive tests on welds in metallic materials — Bend tests*

ISO 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections*

ISO 6947, *Welds — Working positions — Definitions of angles of slope and rotation*

ISO 9017, *Destructive tests on welds in metallic materials — Fracture test*

ISO/TR 15608, *Welding — Guidelines for a metallic material grouping system*