



SLOVENSKI STANDARD
oSIST prEN ISO 13585:2010
01-marec-2010

Trdo spajkanje - Preskušanje spajkalcev (ISO/DIS 13585:2009)

Brazing - Brazer qualification (ISO/DIS 13585:2009)

Hartlöten - Hartlöterprüfung (ISO/DIS 13585:2009)

Brasage fort - Qualification des braseurs en brasage fort (ISO/DIS 13585:2009)

Ta slovenski standard je istoveten z: prEN ISO 13585

<https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2010>

ICS:

25.160.01	Varjenje, trdo in mehko spajkanje na splošno	Welding, brazing and soldering in general
-----------	--	---

oSIST prEN ISO 13585:2010

en,fr,de

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

DRAFT
prEN ISO 13585

September 2009

ICS 25.160.01

Will supersede EN 13133:2000

English Version

Brazing - Brazer qualification (ISO/DIS 13585:2009)

Brasage fort - Qualification des braseurs en brasage fort
(ISO/DIS 13585:2009)

Hartlöten - Hartlöterprüfung (ISO/DIS 13585:2009)

This draft European Standard is submitted to CEN members for 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.

This draft European Standard was established by CEN 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 CEN Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, 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.

Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

Warning : This document is not a European Standard. It is distributed for review and comments. It is subject to change without notice and shall not be referred to as a European Standard.



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

Management Centre: Avenue Marnix 17, B-1000 Brussels

Contents	Page
Foreword.....	3

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 13585:2012

<https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2012>

Foreword

This document (prEN ISO 13585:2009) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DIN, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

This document is currently submitted to the parallel Enquiry.

This document will supersede EN 13133:2000.

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).

iTeh STANDARD PREVIEW
(standards.iteh.ai)

[SIST EN ISO 13585:2012](https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2012)

<https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2012>



DRAFT INTERNATIONAL STANDARD ISO/DIS 13585

ISO/TC 44

Secretariat: **AFNOR**

Voting begins on:
2009-09-03

Voting terminates on:
2010-02-03

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Brazing — Brazer qualification

Brasage fort — Qualification des braseurs en brasage fort

ICS 25.160.01

iTeh STANDARD PREVIEW
(standards.iteh.ai)

ISO/CEN PARALLEL PROCESSING

This draft has been developed within the European Committee for Standardization (CEN), and processed under the **CEN-lead** mode of collaboration as defined in the Vienna Agreement.

This draft is hereby submitted to the ISO member bodies and to the CEN member bodies for a parallel five-month enquiry.

Should this draft be accepted, a final draft, established on the basis of comments received, will be submitted to a parallel two-month approval vote in ISO and formal vote in CEN.

To expedite distribution, this document is circulated as received from the committee secretariat. ISO Central Secretariat work of editing and text composition will be undertaken at publication stage.

Pour accélérer la distribution, le présent document est distribué tel qu'il est parvenu du secrétariat du comité. Le travail de rédaction et de composition de texte sera effectué au Secrétariat central de l'ISO au stade de publication.

THIS DOCUMENT IS A DRAFT CIRCULATED FOR COMMENT AND APPROVAL. IT IS THEREFORE SUBJECT TO CHANGE AND MAY NOT BE REFERRED TO AS AN INTERNATIONAL STANDARD UNTIL PUBLISHED AS SUCH.

IN ADDITION TO THEIR EVALUATION AS BEING ACCEPTABLE FOR INDUSTRIAL, TECHNOLOGICAL, COMMERCIAL AND USER PURPOSES, DRAFT INTERNATIONAL STANDARDS MAY ON OCCASION HAVE TO BE CONSIDERED IN THE LIGHT OF THEIR POTENTIAL TO BECOME STANDARDS TO WHICH REFERENCE MAY BE MADE IN NATIONAL REGULATIONS.

RECIPIENTS OF THIS DRAFT ARE INVITED TO SUBMIT, WITH THEIR COMMENTS, NOTIFICATION OF ANY RELEVANT PATENT RIGHTS OF WHICH THEY ARE AWARE AND TO PROVIDE SUPPORTING DOCUMENTATION.

ISO/DIS 13585

PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

iTeh STANDARD PREVIEW

(standards.iteh.ai)

[SIST EN ISO 13585:2012](https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2012)

<https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2012>

Copyright notice

This ISO document is a Draft International Standard and is copyright-protected by ISO. Except as permitted under the applicable laws of the user's country, neither this ISO draft nor any extract from it may be reproduced, stored in a retrieval system or transmitted in any form or by any means, electronic, photocopying, recording or otherwise, without prior written permission being secured.

Requests for permission to reproduce should be addressed to either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Reproduction may be subject to royalty payments or a licensing agreement.

Violators may be prosecuted.

Contents

Page

Foreword	iv
Introduction.....	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Symbols and abbreviated terms	2
4.1 General	2
4.2 Abbreviations.....	2
4.3 Reference numbers	2
5 Essential variables and range of qualification	3
5.1 General	3
5.2 Brazing process.....	3
5.3 Dimensions	4
5.4 Material groups.....	4
5.5 Brazing consumables	5
5.6 Product type.....	5
5.7 Brazing flow position	6
5.8 Degree of mechanization.....	6
6 Examination and testing	6
6.1 Supervision	6
6.2 Brazing conditions	7
6.3 Test piece	7
6.4 Assessment of work pieces	7
6.5 Extent of testing	7
6.6 Visual examination	7
6.7 Non-destructive testing	7
6.8 Destructive testing	7
6.9 Additional examination and testing.....	8
7 Acceptance requirements for test pieces	8
8 Re-tests.....	8
9 Period of validity.....	8
9.1 Initial qualification	8
9.2 Prolongation	9
10 Certificate	9
Annex A (informative) Brazer qualification test certificate	10
Annex B (informative) Examples of test pieces	11
Annex C (informative) Quality requirements for brazing	13
C.1 Information and requirements for the work shop	13
Annex D (informative) Other non-essential variables	14
D.1 Fuel/gases	14
D.2 Brazing torch	14
D.3 Joint location	14
D.4 Jigs and fixtures	14
D.5 Test location	14

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 13585 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Working Group 3, and by Technical Committee CEN/TC 121, *Welding* in collaboration.

iteh STANDARD PREVIEW
(standards.iteh.ai)

[SIST EN ISO 13585:2012](https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2012)

<https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2012>

Introduction

The purpose of this standard is to provide general set of rules for qualification un-dependant of product or application.

Requests for official interpretations of any aspects of this part of ISO 13585 should be directed to the Secretariat of ISO/TC 44/WG 3 via the user's national standardization body; a complete listing of these bodies can be found at www.iso.org.

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 13585:2012

<https://standards.iteh.ai/catalog/standards/sist/581814fa-78f0-444d-a718-6ad46d459771/sist-en-iso-13585-2012>