



SLOVENSKI STANDARD
SIST EN ISO 15614-8:2003
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Specification and qualification of welding procedures for metallic materials - Welding
procedure test - Part 8: Welding of tubes to tube-plate joints (ISO 15614-8:2002)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe -
Schweißverfahrensprüfung - Teil 8: Einschweißen von Rohren in Rohrböden (ISO 15614-
-8:2002)

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Descriptif et qualification d'un mode opératoire de soudage sur les matériaux métalliques
- Epreuve de qualification d'un mode opératoire de soudage - Partie 8: Soudage de
tubes sur plaques tubulaires (ISO 15614-8:2002)

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English version

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This European Standard 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 Management Centre has the same status as the official versions.

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

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Foreword

This document (EN ISO 15614-8:2002) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

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of an identical text or by endorsement, at the latest by October 2002, and conflicting national standards shall be withdrawn at the latest by October 2002.

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 EU Directive(s).

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

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

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1 Scope

This European Standard specifies requirements for the qualification testing of welding procedures for the arc welding of tube to tube-plate joints in metallic materials by manual, partly mechanized, mechanized or automatic processes.

This standard is a part of a series of standards. Details of this series are given in prEN ISO 15607, Annex A.

Qualification by tube to tube-plate joint tests can be used for all joints even if they are fully loaded or only seal welded as required in application standards.

In such cases, one or more special test pieces should be made to simulate the production joint in all essential features, e.g. dimensions, restraint, heat sink effects. The test should be carried out prior to and under the conditions to be used in production.

This standard applies to fusion welding of metallic materials for tube to tube-plate joints with gap. This standard does not apply to tube-sheets with forged end connections with welded tubes (external/internal bore welds). For welding of tube to tube-plate joints without gap welding procedure test should be defined in the specification.

For other applications and/or requirements the standard can be used if required by the specification.

Repair welding should be considered in the welding procedure test.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 287-2, *Approval testing of welders - Fusion welding - Part 2: Aluminium and aluminium alloys*

EN 439, *Welding consumables – Shielding gases for arc welding and cutting.*

EN 571-1, *Non destructive testing – Penetrant testing – Part 1 : General principles.*

EN 1043-1, *Destructive tests on welds in metallic materials – Hardness testing – Part 1 : Hardness test on arc welded joints.*

EN 1321, *Destructive tests on welds in metallic materials – Macroscopic and microscopic examination of welds.*

EN 1418, *Welding personnel – Approval testing of welding operators for fusion welding and resistance weld setters for fully mechanized and automatic welding of metallic materials.*

EN 1435, *Non destructive examination of welds – Radiographic examination of welded joints.*

EN 1708-1, *Welding – Basic weld joint details in steels – Part 1 : Pressurized components.*

EN ISO 4063, *Welding and allied processes – Nomenclature of processes and reference numbers (ISO 4063:1998).*

prEN ISO 9606-1, *Approval testing of welders - Fusion welding - Part 1: Steels (ISO/DIS 9606-1:2000)*

EN ISO 9606-3, *Approval testing of welders – Fusion welding – Part 3: Copper and copper alloys (ISO 9606-3:1999).*

EN ISO 9606-4, *Approval testing of welders – Fusion welding – Part 4: Nickel and nickel alloys (ISO 9606-4:1999).*

EN ISO 9606-5, *Approval testing of welders – Fusion welding – Part 5: Titanium and titanium alloys, zirconium and zirconium alloys (ISO 9606-5:2000)*.

prEN ISO 15607:2000, *Specification and qualification of welding procedures for metallic materials – General rules (ISO/DIS 15607:2000)*.

CR ISO 15608, *Welding – Guidelines for a metallic material grouping system (ISO/TR 15608:2000)*.

prEN ISO 15609-1:2000, *Specification and qualification of welding procedures for metallic materials – Welding procedure specification – Part 1 : Arc welding (ISO/DIS 15609-1:2000)*.

prEN ISO 15614-1:2000, *Specification and qualification of welding procedures for metallic materials — Welding procedure test – Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys (ISO/DIS 15614-1:2000)*.

EN ISO 6520-1, *Welding and allied processes - Classification of geometric imperfections in metallic materials – Part 1: Fusion welding (ISO 6520-1:1998)*.

EN 29692, *Metal-arc welding with covered electrode, gas-shielded metal-arc welding and gas welding - Joint preparations for steels (ISO 9692:1992)*.

3 Terms, definitions and symbols

3.1 Terms and definitions

For the purposes of this European standard, the terms and definitions given in prEN ISO 15607:2000 apply.

3.2 Symbols

For the purposes of this standard, the following symbols apply and are shown in Figure 1, 2 and 3:

- a throat thickness (mm) (in this case, the minimal distance between root point and weld surface)
- d_p pore size (mm)
- d_a tube-outside diameter (mm)
- d_l minimum distance between two pipes (mm), see Figure 2
- g gap between tube and tube plate
- s_p starting point of the root run
- t tube-wall thickness (mm)
- t_1 cladding thickness (mm)
- t_2 tube-plate thickness (mm)
- x overlap (mm)

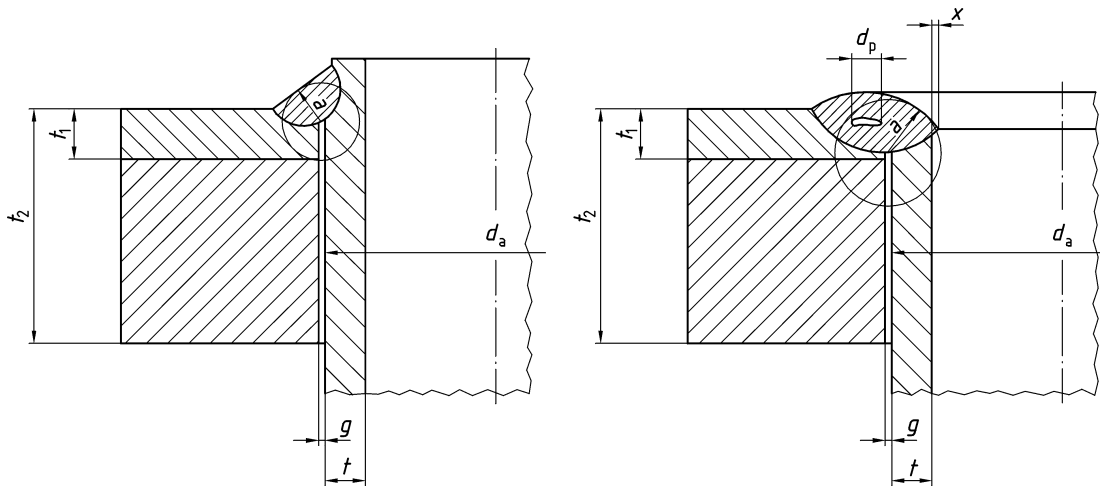


Figure 1 — Presentation of symbols in an example

4 Preliminary Welding Procedure Specification (pWPS)

4.1 General

The qualification for tube to tube-plate welding tests shall be based on a pWPS in accordance with prEN ISO 15609-1:2000. It shall specify the relevant parameters listed in 4.2 and 4.3.

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4.2 Items for all welding process

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Details relating to the following items shall be recorded for all welding processes :

- a) welding process, or processes when more than one is used in making a complete joint ;
- b) tube-plate specification and thickness and details of any cladding and its thickness ;
- c) tube specification, thickness and outside diameter ;
- d) pitch type (square or triangular) and distance between pipes ;
- e) joint geometry, actual borehole diameter and fit-up tolerances (sketch) in accordance with EN 29692 ;
- f) cleaning and degreasing (time during the fabrication steps and type) ;
- g) jiggling or tacking, tacking position and expansion;
- h) tube-plate and welding position ;
- i) type and/or trade name of welding consumables ;
- j) size (diameter) and wire lengths per run ;
- k) pre-heating and interpass temperature, including method of control ;
- l) welding speed (mechanized welding) ;
- m) number and arrangement of runs, starting points of runs and weld dimensions (sketch) ;

- n) welding sequence ;
- o) post-weld heat treatment, including method of control ;
- p) if necessary, the temperature and time recommended for drying/backing of welding consumables before use ;
- q) any special features, including heat input control requirements, any heat sinks effects or post-weld tube expansion.

4.3 Items for particular welding processes

Details relating to the items given in 4.3 a) to 4.3 d) shall be recorded for these particular processes, in addition to the items given in 4.2. The reference numbers of welding processes relate to EN ISO 4063.

- a) Manual metal arc welding (111)
 - alternating or direct current and polarity ;
 - current.
- b) MIG welding, MAG welding, solid wire or cored wire, with or without separate gas shield (114), (131), (135), (136), (137)
 - shielding gas designation in accordance with EN 439 and flow rate ;
 - arc voltage ;
 - wire feed speed or current ;
 - for pulsed welding : the pulse time and frequency, pulsed current and background current.
- c) TIG welding (141) <https://standards.iteh.ai/catalog/standards/sist/8775229d-35bc-4aa6-bbb6-97552c22761e/sist-en-iso-15614-8-2003>
 - shielding gas designation in accordance with EN 439 and flow rate ;
 - alternating current (AC) or direct current (DC) and polarity ;
 - current in ampere ;
 - for pulsed welding : the pulse time and frequency, pulsed current and background current ;
 - whether filler metal is used.
- d) Mechanized or automatic welding
 - all items detailed in b) or c) and the following items if necessary :
 - arc length or arc voltage ;
 - where filler metal is used its rate of addition or wire feed speed relating to the wire diameter (see 4.2));
 - other pre-programmed welding variables such as :
 - pre- and post-gas purge times ;
 - changes in current level ;
 - current slope up and down rates ;
 - welding travel speed and degree of overlap ;

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- when considering front face welding, the following additional information :
 - radius of electrode rotation ;
 - electrode angle relative to the tube axis ;

For all other welding processes, the welding parameters shall be specified.

5 Qualification of welding procedure

The qualification of welding procedure for the tube to tube-plate welding shall be carried out by an examiner or examining body related to the appropriate application standard or specification.

6 Welding of test pieces

6.1 General

Procedure test pieces shall be produced in accordance with 6.2 and shall simulate the joint geometry to be used in production or a similar geometry within the requirements of clause 4. Welders shall be qualified in accordance with prEN ISO 9606-1, EN 287-2, EN ISO 9606-3, EN ISO 9606-4 or EN ISO 9606-5. For welding operators, the qualification can be carried out during the tests in accordance with EN 1418.

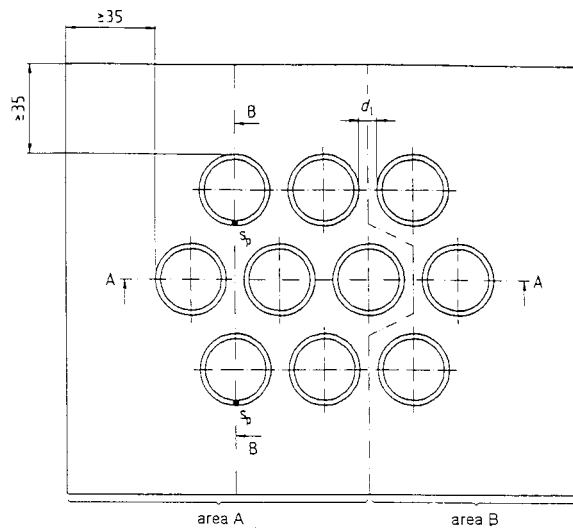
6.2 Type of test piece

6.2.1 Joint preparation and joint construction

Examples of joint preparation according to EN 29692 and joint construction are given in EN 1708-1.

6.2.2 Tube ends welded on triangular pitch

Where tube end welds are involved on a triangular pitch, a minimum of 10 tube ends with an outside diameter smaller than 40 mm (< 40 mm) or a minimum of 7 tube ends (area A) with an outside diameter greater than or equal to 40 mm (≥ 40 mm), shall be welded as shown in Figure 2.



Key

- d_i Minimum distance between two pipes
 s_p Starting point of the root run
 A-A/B-B Ground sections of a test specimen (examples for the location of the cut lines)

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Figure 2 — Test piece for tube ends on triangular pitch

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6.2.3 Tube ends welded on square pitch

Where tube end welds are involved on a square pitch, a minimum of 12 tube ends with an outside diameter smaller than 40 mm (< 40 mm) or a minimum of nine tube ends (area A) with an outside diameter greater than or equal to 40 mm (≥ 40 mm) shall be welded as shown in Figure 3.