
Varjenje - Spoji, zvarjeni z elektronskim in laserskim žarkom - Smernice za stopnje sprejemljivosti napak - 2. del: Aluminij in njegove varive zlitine (ISO 13919-2:2001)

Welding - Electron and laser beam welded joints - Guidance on quality levels for imperfections - Part 2: Aluminium and its weldable alloys (ISO 13919-2:2001)

Schweißen - Elektronenstrahl- und Laserstrahl-Schweißverbindungen - Richtlinie für Bewertungsgruppen für Unregelmäßigkeiten - Teil 2: Aluminium und seine schweißgeeigneten Legierungen (ISO 13919-2:2001)

Soudage - Assemblages soudés par faisceau d'électrons et par faisceau laser - Guide des niveaux de qualité des défauts - Partie 2: Aluminium et ses alliages soudables (ISO 13919-2:2001)

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 13919-2

September 2001

ICS 25.160.00

English version

**Welding - Electron and laser beam welded joints - Guidance on
quality levels for imperfections - Part 2: Aluminium and its
weldable alloys (ISO 13919-2:2001)**

Soudage - Assemblages soudés par faisceau d'électrons et
par faisceau laser - Guide des niveaux de qualité des
défauts - Partie 2: Aluminium et ses alliages soudables
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Schweißen - Elektronenstrahl- und Laserstrahl-
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für Unregelmäßigkeiten - Teil 2: Aluminium und seine
schweißgeeigneten Legierungen (ISO 13919-2:2001)

This European Standard was approved by CEN on 13 April 2000.

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. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

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.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.



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Foreword

The text of EN ISO 13919-2:2001 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 March 2002, and conflicting national standards shall be withdrawn at the latest by March 2002.

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 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, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

Introduction

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This European standard should be used as a reference in the drafting of application codes and/or for other application standards. It may be used within a total quality system for the production of satisfactory welded joints. It provides three sets of dimensional values from which a selection can be made for a particular application. The quality level necessary in each case should be defined by the application standard or the responsible designer in conjunction with the manufacturer, user and/or other parties concerned. The level should be prescribed before the start of production, preferably at the inquiry or order stage. For special purposes, additional details may need to be prescribed.

The quality levels given in this standard are intended to provide basic reference data and are not specifically related to any particular application. They refer to welded joints and not the complete product or component itself. It is possible, therefore, for different quality levels to be applied to individual welded joints in the same product or component. Quality levels are listed in table 1.

Table 1 — Quality levels for weld imperfections

Level symbol	Quality level
D	Moderate
C	Intermediate
B	Stringent

The three quality levels are arbitrarily identified as D, C and B and are intended to cover the majority of practical applications.

If higher requirements are made on welds than compatible with the above levels (e.g. for dynamic loading) such welds may be machined or ground after welding in order to remove surface imperfections.

It would normally be hoped that for a particular welded joint the dimensional limits for imperfections could all be covered by specifying one quality level. In some cases, however, e.g. for certain types of aluminium or aluminium alloys and structures as well as for fatigue loading or leak tightness applications it may be necessary to specify different quality levels for different imperfections in the same welded joint or to include additional requirements.

The choice of quality level for any application should take account of design considerations, subsequent processing, e.g. surfacing, mode of stressing (e.g. static, dynamic), service conditions (e.g. temperature, environment), and

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consequences of failure. Economic factors are also important and should include not only the cost of welding but also that of inspection, test and repair.

Although this standard includes types of imperfections relevant to the electron and laser beam welding processes, only those which are applicable to the process and application in question need to be considered.

Imperfections are quoted in terms of their actual dimensions, and their detection and evaluation may require the use of one or more methods of non-destructive testing. The detection and sizing of imperfections is dependent on the inspection methods and the extent of testing specified in the application standard or contract.

This standard does not include details of recommended methods of detection and sizing and, therefore, it needs to be supplemented by requirements for examination, inspection and testing. It should be appreciated that methods of non-destructive examination may not be able to give the detection, characterisation and sizing necessary for use within certain types of imperfections shown in table 2.

Although this standard covers material thicknesses (penetration depths) from 1 mm and above for electron and laser beam welding, it should be noted that the permitted size for all types of imperfection has an absolute, upper limit.

Application for thicknesses above 50 mm for electron beam welding and 12 mm for laser beam welding is, for that reason, usually safe, but may be overly conservative and may require special precautions, such as weld bead dressing in order to comply with the limits for reinforcement and undercut. Attention should be paid to such precautions during approval testing of the welding procedure and alternative requirements may have to be specified, if necessary.

Application for thicknesses below 1 mm is possible, but the requirements may be overly conservative for certain types of imperfections.

1 Scope

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This standard provides guidance on levels of imperfections in electron and laser welded joints in aluminium and its alloys. Three levels are given in such a way as to permit application for a wide range of welded fabrications. The levels refer to production quality and not to the fitness-for-purpose of the product manufactured.

This standard applies to electron and laser beam welding of:

- aluminium and its alloys;
- all types of welds welded with or without additional filler wire;
- materials equal to or above 1 mm thickness for electron and laser beam welding.

When significant deviations from the joint geometries and dimensions stated in this standard are present in the welded product, it is necessary to evaluate to what extent the provisions of this standard can apply.

NOTE For circular welds, a lower quality level e.g., may be specified for the fade-out zone.

Metallurgical aspects, e.g. grain size, hardness are not covered by this standard.

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 here after. 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.

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

EN 30042, *Arc-welded joints in aluminium and its weldable alloys — Guidance on quality levels for imperfections (ISO 10042 : 1992)*

3 Symbols

The following symbols are used in table 2:

ΔL	distance between two imperfections (pore, cavity)
b	width of weld
b_r	width of weld root
d	maximum size of an imperfection (pore, cavity)
f	projected areas of pores or cavities
g	distance from center line in T-joint
h	size of the imperfection (height, width)
$h_1; h_2$	deviation from the weld penetration
l	length of imperfection (measured in any direction)
L	weld length under consideration (weld length examined)
L_c	length of combined porosity (affected weld length)
s	weld penetration
s_1	weld penetration in T-joint
t	work-piece thickness

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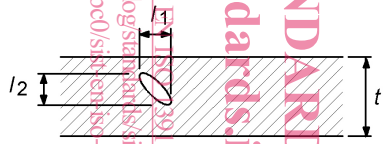
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4 Evaluation of welds

Limits for imperfections are given in table 2.

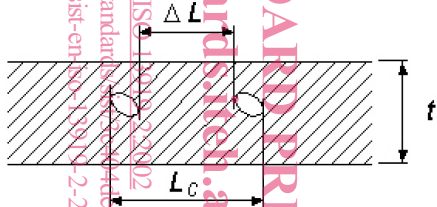
A welded joint should normally be evaluated separately for each individual type of imperfection. Different types of imperfection occurring at any cross-section of the joint may need special consideration.

Table 2 — Imperfections

No	Imperfection, designation	EN ISO 6520-1 reference	Remarks	Limits for imperfections for quality levels:		
				moderate D	intermediate C	stringent B
1	Cracks	100	All types of cracks except micro cracks (less than 1 mm ² crack area). For crater cracks see No 2.	Not permitted	Not permitted	Not permitted
2	Crater cracks	104		Local crater cracks permitted	Local crater cracks Permitted	Not permitted
3	Porosity and gas pores	200	<p>The following conditions and limits for imperfections shall be fulfilled:</p> <p>a) Maximum dimension l (l_1, l_2 or h) for a single pore;</p> <p>b) Maximum dimension of the summation of the projected area of the imperfections.</p> <p>Projection is in a direction parallel to the surface and perpendicular to the weld axis. It relates to an area t multiplied by weld length, where weld length is the actual length of the weld or 100 mm, whichever is the smaller.</p> 	<p>l or $h \leq 0,5 t$ max. 6 mm</p> <p>Electron beam welding: $f \leq 6 \%$ Laser beam welding: $f \leq 10 \%$</p>	<p>l or $h \leq 0,4 t$ max. 5 mm</p> <p>Electron beam welding: $f \leq 3 \%$ Laser beam welding: $f \leq 6 \%$</p>	<p>l or $h \leq 0,3 t$ max. 4 mm</p> <p>Electron beam welding: $f \leq 1,5 \%$ Laser beam welding: $f \leq 3 \%$</p>

(continued)

Table 2 (continued)

No	Imperfection, designation	EN ISO 6520-1 reference	Remarks	Limits for imperfections for quality levels:		
				moderate D	intermediate C	stringent B
4	Localised (clustered) and linear porosity	2013 2014	<p>The following conditions and limits for imperfections shall be fulfilled:</p> <p>a) Maximum dimension l (l_1, l_2 or h) for a single pore;</p> <p>b) Maximum dimension of the summation of the projected area of the imperfections. Projection is in a direction parallel to the surface and perpendicular to the weld axis. It relates to an area t multiplied by weld length, where weld length is the actual length of the weld or 100 mm, whichever is the smaller.</p> <p>In addition:</p> <p>c) The distances ΔL between the individual pores in clustered or linear porosity shall be assessed. Any two pores closer than:</p> <p>shall be considered a combined porosity.</p> <p>d) Combined porosity is permitted, provided the affected weld length L_c is less than:</p>  <p>Affected weld length L_c for combined porosity. Use d) acceptance limit.</p>	<p>l or $h \leq 0,5 t$ max. 6 mm</p> <p>$f \leq 15 \%$</p> <p>0,25 t max. 5 mm</p> <p>$L_c \leq 2 t$</p>	<p>l or $h \leq 0,4 t$ max. 5 mm</p> <p>$f \leq 5 \%$</p> <p>0,5 t max. 10 mm</p> <p>$L_c \leq t$</p>	<p>l or $h \leq 0,3 t$ max. 4 mm</p> <p>$f \leq 2 \%$</p> <p>0,5 t max. 15 mm</p> <p>$L_c \leq t$</p>

(continued)