SLOVENSKI STANDARD
SIST EN 288-2:1996/A1:1999

01-december-1999

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Specification and approval of welding procedures for metallic materials - Part 2: Welding procedure specification for arc welding

Anforderung und Anerkennung von Schweißverfahren für metallische Werkstoffe - Teil 2: Schweißanweisung für das Lichtbogenschweißen

Descriptif et qualification d'un mode opératoire de soudage sur les matériaux métalliques - Partie 2: Descriptif d'un mode opératoire de soudage pour le soudage a l'arc

Ta slovenski standard je istoveten z: EN 288-2:1992/A1:1997

ICS:

25.160.10	Varilni postopki in varjenje	Welding processes

SIST EN 288-2:1996/A1:1999   **en**

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EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 288-2:1992/A1

June 1997

ICS 25.160.10

Descriptors: welding, arc welding, metals, procedure, qualification, description, specifications

English version

Specification and approval of welding procedures for metallic materials - Part 2: Welding procedure specification for arc welding

Descriptif et qualification d'un mode opératoire de soudage pour les matériaux métalliques - Partie 2: Descriptif d'un mode opératoire de soudage pour le soudage à l'arc

Anforderung und Anerkennung von Schweißverfahren für metallische Werkstoffe - Teil 2: Schweißanweisung für das Lichtbogenschweißen

This amendment 1 modifies the European Standard EN 288-2:1992.This amendment was approved by CEN on 1996-12-11. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this amendment 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 Central Secretariat or to any CEN member.

The European Standards exist 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 Central Secretariat 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.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart,36 B-1050 Brussels

Ref. No. EN 288-2:1992/A1:1997 E

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Foreword

This Amendment EN 288-2:1992/A1:1997 to EN 288-2:1992 has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS.

This Amendment to the European Standard EN 288-2:1992 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by December 1997, and conflicting national standards shall be withdrawn at the latest by December 1997.

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.

2 Normative references

Delete the text of clause 2 and replace by the following :

This 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 standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 288-1   Specification and approval of welding procedures for metallic materials - Part 1 : General rules for fusion welding

EN 439   Welding consumables - Shielding gases for arc welding and cutting

EN 24063   Welding, brazing, soldering and braze welding of metals - Nomenclature of processes and reference numbers for symbolic representation on drawings (ISO 4063:1990)

EN 26848   Tungsten electrodes for inert gas shielded arc welding and for plasma cutting and welding - Codification (ISO 6848:1984)

EN ISO 6947   Welds - Working positions - Definitions of angles of slope and rotation (ISO 6947:1990)

3 Definitions

Delete clause 3 and replace by the following :

For the purpose of this standard, the definitions given in EN 288-1 apply.

4.4.1 Welding process

Replace the reference to "standard ISO 4063" by reference to "EN 24063".

4.4.3 Welding position

Replace the reference to "standard ISO 6947" by reference to "EN ISO 6947".

4.4.8 Filler metal, designation :

Amend the title to "Welding consumable, designation".

Delete 4.4.8 and replace by the following :

   - Designation, manufacturer and trade name.

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4.4.9 Filler metal, dimensions

Amend the title to "Welding consumable, dimensions".

4.4.13   Preheat temperature

Delete 4.4.13 and replace by the following :

- The nominal temperature applied at the start of the welding process.

- If pre-heating is not required the lowest work piece temperature immediatly prior to welding.

Add a new sub-clause :

4.4.16   Shielding gas

Designation in accordance with EN 439, manufacturer and trade name.

4.5   Specific to a group of welding processes

Delete 4.5 and replace by the following :

4.5.1 Process group 11 (Metal-arc welding without gas protection) :
- For process 111 the run-out length of electrode consumed.

4.5.2 Process group 12 (Submerged arc welding) :

- For multiple electrode systems the number and configuration of wire electrodes and electrical connections.

- Distance contact tube/work piece : The distance from contact tip nozzle to the surface of the workpiece for mechanized welding.

- Flux : Designation, manufacturer and trade name.

- Additional filler metal.

4.5.3 Process group 13 (Gas-shielded metal arc welding) :

- Gas flow rate and nozzle diameter.

- Number of wire electrodes.

- Additional filler metal.

- Distance contact tube/work piece : The distance from contact tip nozzle to the surface of the workpiece for mechanized welding.

4.5.4 Process group 14 (Gas-shielded welding with non-consumable electrode) :

- For tungsten electrode, the diameter, and designation in accordance with EN 26848.

- Gas flow rate and nozzle diameter.

4.5.5 Process group 15 (Plasma arc welding) :

- Plasma gas parameters, e.g. type, nozzle diameter, flow rate.

- Shielding gas flow rate and nozzle diameter.

- Type of torch.

- Plasma current.

- Distance contact tube/work piece.

Annex A

Replace twice "test body" by "examining body".

Delete "welder's name".

Change "Travel speed" by "Run-out length/travel speed".

Change "filler metal classification" by "designation of welding consumables".

Change "stand off distance" by "distance contact tube/work piece"