



SLOVENSKI STANDARD SIST CEN/TR 14633:2004

01-junij-2004

Varjenje - Položaji pri varjenju - Primerjava veljavnih mednarodnih, evropskih in ameriških oznak

Welding - Working positions - Comparison of current international, European and US designations

Schweißen - Arbeitspositionen - Vergleich zwischen üblichen internationalen, europäischen und US-Benennungen

Soudage - Positions de travail - Comparaison des désignations courantes internationales, européennes et US

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ICS:

01.040.25	Izdelavna tehnika (Slovarji)	Manufacturing engineering (Vocabularies)
25.160.40	Varjeni spoji in vari	Welded joints

SIST CEN/TR 14633:2004

en

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TECHNICAL REPORT
RAPPORT TECHNIQUE
TECHNISCHER BERICHT

CEN/TR 14633

December 2003

ICS 01.040.25, 25.160.40

English version

**Welding - Working positions - Comparison of current
international, European and US designations**

Soudage - Positions de travail - Comparaison des
désignations courantes internationales, européennes et US

Schweißen - Arbeitspositionen - Vergleich zwischen
üblichen internationalen, europäischen und US-
Benennungen

This Technical Report was approved by CEN on 18 October 2003. It has been drawn up by the Technical Committee CEN/TC 121.

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

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Foreword

This document (CEN/TR 14633:2003) has been prepared by Technical Committee CEN /TC 121, "Welding", the secretariat of which is held by DS.

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

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CEN/TR 14633:2003 (E)

1 Scope

This Technical Report provides a comparison between the common working and welding positions shown in EN ISO 6947 and the joint orientations shown in ANSI/AWS A3.0, and ASME Boiler and pressure vessel code Section IX.

2 Normative references

This Technical Report 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 Technical Report only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN ISO 6947, *Welds - Working positions - Definitions of angles of slope and rotation (ISO 6947:1993)*

ANSI/AWS A3.0, *Standard welding terms and definitions.*

ASME Boiler and Pressure Vessel Code, Section IX, *Qualification standard for welding and brazing procedures, welders, brazers, and welding and brazing operators.*

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3 Comparison of current international, European and US American designations for working and welding positions

A comparison of current international, European and US American designations for working and welding positions is given in Table 1.

Table 1 — Comparison of current international, European and US American designations for working and welding positions

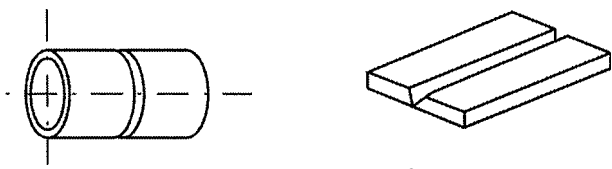
Illustration	Welding position according to ANSI/AWS ASME IX	Working position according to EN ISO 6947
 <p data-bbox="279 1780 478 1848">flat position (pipe rotating)</p> <p data-bbox="654 1747 821 1780">flat position</p>	1G	PA

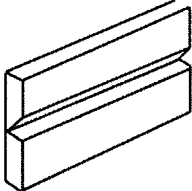
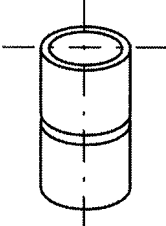
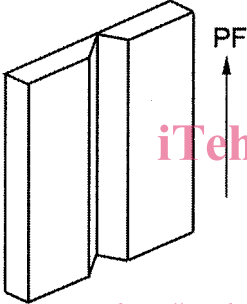
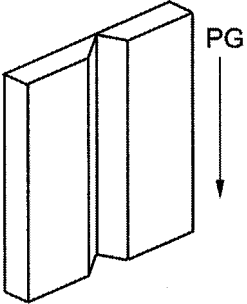
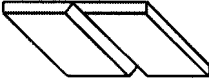
Illustration	Welding position according to ANSI/AWS ASME IX	Working position according to EN ISO 6947
 <p>horizontal position</p>  <p>horizontal position</p>	2G	PC
 <p>vertical up position</p> <p>PF</p>  <p>vertical down position</p> <p>PG</p> <p>STANDARD PREVIEW (standards.iteh.ai)</p> <p>https://standards.iteh.ai/catalog/standards/sist/7802860d-0e67-43b1-ad21-cfa8cc0e2e8/sist-cen-tr-14633-2004</p> <p>SIST CEN/TR 14633:2004</p>	3G	PF
 <p>overhead position</p>	4G	PE

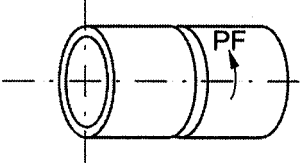
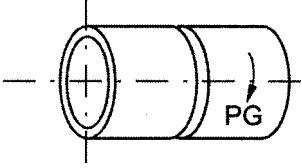
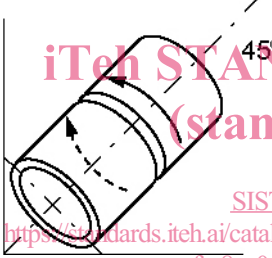
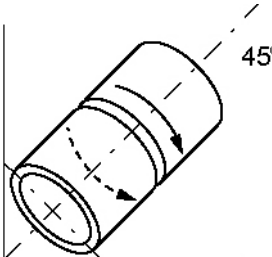
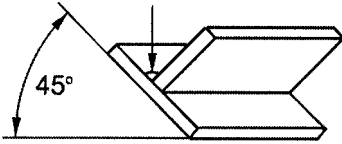
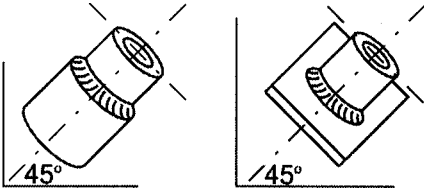
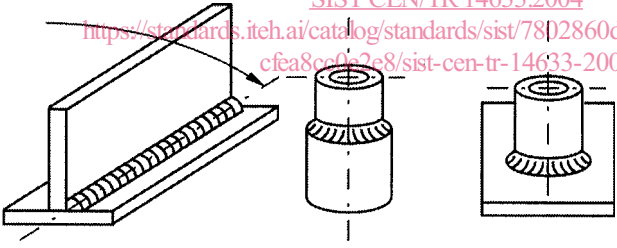
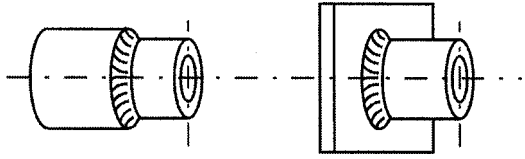
Illustration	Welding position according to ANSI/AWS ASME IX	Working position according to EN ISO 6947
 <p>Vertical up position (pipe fixed)</p>  <p>Vertical down position (pipe fixed)</p>	5G	PF
 <p>inclined position (pipe fixed) welding upwards</p>	6G	H-L045
 <p>inclined position (pipe fixed) welding downwards</p>	6G	J-L045

Illustration	Welding position according to ANSI/AWS ASME IX	Working position according to EN ISO 6947
 <p data-bbox="568 656 735 689">flat position</p>	1F	PA
 <p data-bbox="539 1016 906 1050">flat position (pipe rotating)</p>	1FR	PA
<p data-bbox="655 1137 935 1167">SIST CEN/TR 14633:2004</p> <p data-bbox="427 1171 1161 1227">https://standards.iteh.ai/catalog/standards/sist/7802860d-0e67-43b1-ad21-cfa8cc0b2e8/sist-cen-tr-14633-2004</p>  <p data-bbox="612 1429 995 1462">horizontal vertical position</p>	2F	PB
 <p data-bbox="384 1825 959 1859">horizontal vertical position (pipe rotated)</p>	2FR	PB