



# SLOVENSKI STANDARD SIST EN ISO 15609-1:2005

01-januar-2005

BUXca Yý U

SIST EN 288-2:1996

SIST EN 288-2:1996/A1:1999

---

Dcd]g`]b`\_j U]Z\_ UYUj Uf]b] `dcg]cd\_cj`nU\_cj ]bg\_Y'a UHf]UY!'Dcd]g`j Uf]bY[ U  
dcg]cd\_UÉ`%`XY.`CV`c bc`j Uf]bY`f]G`%`)\*\$-!%&\$\$(`L

Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 1: Arc welding (ISO 15609-1:2004)

iTeh STANDARD PREVIEW

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißanweisung - Teil 1: Lichtbogenschweißen (ISO 15609-1:2004)

[SIST EN ISO 15609-1:2005](https://standards.iteh.ai/catalog/standards/sist/ad011b76-f119-4141-850c-b5fac6754068/sist-en-iso-15609-1-2005)

Descriptif et qualification d'un mode opératoire de soudage pour les matériaux métalliques - Descriptif d'un mode opératoire de soudage - Partie 1: Soudage a l'arc (ISO 15609-1:2004)

Ta slovenski standard je istoveten z: EN ISO 15609-1:2004

---

**ICS:**

25.160.10 Varilni postopki in varjenje Welding processes

**SIST EN ISO 15609-1:2005** en

**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

[SIST EN ISO 15609-1:2005](#)

<https://standards.iteh.ai/catalog/standards/sist/ad01bb76-f119-4141-850c-b5fac6754068/sist-en-iso-15609-1-2005>

EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN ISO 15609-1**

October 2004

ICS 25.160.10

Supersedes EN 288-2:1992

English version

Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 1: Arc welding  
(ISO 15609-1:2004)

Descriptif et qualification d'un mode opératoire de soudage pour les matériaux métalliques - Descriptif d'un mode opératoire de soudage - Partie 1: Soudage à l'arc (ISO 15609-1:2004)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißanweisung - Teil 1: Lichtbogenschweißen (ISO 15609-1:2004)

This European Standard was approved by CEN on 16 January 2004.

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 Central Secretariat 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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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

Management Centre: rue de Stassart, 36 B-1050 Brussels

**Contents****Page**

Foreword.....	3
1 Scope .....	4
2 Normative references .....	4
3 Terms and definitions .....	4
4 Technical content of welding procedure specification (WPS).....	4
4.1 General.....	4
4.2 Related to the manufacturer .....	5
4.3 Related to the parent material .....	5
4.4 Common to all welding procedures.....	5
4.5 Specific to a group of welding processes.....	7
Annex A (informative) Welding Procedure Specification (WPS) .....	9
Annex ZA (normative) Normative references to International publications with their relevant European publications .....	10

**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

[SIST EN ISO 15609-1:2005](https://standards.iteh.ai/catalog/standards/sist/ad01bb76-fl19-4141-850c-b5fac6754068/sist-en-iso-15609-1-2005)

<https://standards.iteh.ai/catalog/standards/sist/ad01bb76-fl19-4141-850c-b5fac6754068/sist-en-iso-15609-1-2005>

## Foreword

This document (EN ISO 15609-1:2004) 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 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 April 2005, and conflicting national standards shall be withdrawn at the latest by April 2005.

This document supersedes EN 288-2:1992.

NOTE Normative references to International Standards are listed in annex ZA (normative).

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

## iTeh STANDARD PREVIEW (standards.iteh.ai)

[SIST EN ISO 15609-1:2005](https://standards.iteh.ai/catalog/standards/sist/ad01bb76-fl19-4141-850c-b5fac6754068/sist-en-iso-15609-1-2005)

<https://standards.iteh.ai/catalog/standards/sist/ad01bb76-fl19-4141-850c-b5fac6754068/sist-en-iso-15609-1-2005>

## EN ISO 15609-1:2004 (E)

### 1 Scope

This standard specifies requirements for the content of welding procedure specifications for arc welding processes.

This standard is part of a series of standards, details of this series are given in EN ISO 15607:2003, Annex A.

The variables listed in this standard are those influencing the quality of the welded joint.

### 2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

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

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

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

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

EN ISO 13916, *Welding – Guidance on the measurement of preheating temperature, interpass temperature and preheat maintenance temperature. (ISO 13916:1996)*

EN ISO 15607:2003, *Specification and qualification of welding procedures for metallic materials – General rules. (ISO 15607:2003)*

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

### 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN ISO 15607:2003 apply.

### 4 Technical content of welding procedure specification (WPS)

#### 4.1 General

A preliminary Welding Procedure Specification/Welding Procedure Specification (pWPS/WPS) shall provide all the necessary information required to make a weld. The information required in a pWPS/WPS is given in 4.2 to 4.5.

NOTE For some applications it may be necessary to supplement or reduce the list.

Welding procedure specifications cover a certain range of material thickness and also cover a range of parent materials and even welding consumables. Some manufacturers prefer additionally to prepare work instructions for each specific job as part of detailed production planning.

Ranges and tolerances, according to the relevant standard of the series (see EN ISO 15607) and to the manufacturer's experience, shall be specified where appropriate.

An example of the WPS-format is shown in annex A.

## 4.2 Related to the manufacturer

- Identification of the manufacturer;
- Identification of the WPS;
- Reference to the Welding Procedure Qualification Record (WPQR) or other documents as required (see EN ISO 15607:2003, Annex C).

## 4.3 Related to the parent material

### 4.3.1 Parent material type

- Designation of the material(s), and reference standard(s);
- Number(s) of the group(s) as given in CR ISO 15608.

A WPS may cover a group of materials.

### 4.3.2 Material dimensions

- Thickness ranges of the joint;
- Outside diameter ranges for pipes.

## 4.4 Common to all welding procedures

### 4.4.1 Welding process

<https://standards.iteh.ai/catalog/standards/sist/ad01bb76-fl19-4141-850c-b5fac6754068/sist-en-iso-15609-1-2005>

Welding process(es) used in accordance with EN ISO 4063.

### 4.4.2 Joint design

- A sketch of the joint design/configuration and dimensions or reference to standards which provide such information.
- Weld run sequence given on the sketch if essential for the properties of the weld.

### 4.4.3 Welding position

Applicable welding positions in accordance with EN ISO 6947.

### 4.4.4 Joint preparation

- Joint preparation methods, cleaning, degreasing, including methods to be used;
- Jigging, fixtures and tack welding.

### 4.4.5 Welding technique

- Weaving if applicable
  - a) For manual welding maximum width of the run.

**EN ISO 15609-1:2004 (E)**

b) For mechanized and automatic welding maximum weaving or amplitude, frequency and dwell time of oscillation.

- Torch, electrode and/or wire angle.

**4.4.6 Back gouging**

- The method to be used.
- Depth and shape.

**4.4.7 Backing**

- The method and type of backing, backing material and dimensions.
- For gas backing, gas in accordance with EN 439.

**4.4.8 Welding consumables**

- Designation, make (manufacturer and trade name).
- Dimensions (size).
- Handling (baking, exposure to atmosphere, re-drying, etc.).

**4.4.9 Electrical parameters**

- Type of current (alternating current (AC) or direct current (DC)) and polarity.
- Pulse welding details (machine settings, programme selection) if applicable.
- Current range.

**4.4.10 Mechanized and automatic welding**

- Travel speed range.
- Wire/strip feed speed range.

If the equipment does not permit control of one of either variable, the machine settings shall be specified instead. The range of application for the WPS shall then be limited to equipment of that particular type. This applies to 4.4.9 and 4.4.10.

**4.4.11 Preheat temperature**

- The minimum temperature applied at the start of welding and during welding.
- If pre-heating is not required the lowest work piece temperature prior to welding.

**4.4.12 Interpass temperature**

Maximum and if necessary minimum interpass temperature.



**4.4.13 Preheat maintenance temperature**

The minimum temperature in the weld zone which shall be maintained if welding is interrupted.

See EN ISO 13916 for application of 4.4.11, 4.4.12 and 4.4.13.

**4.4.14 Post-heating for hydrogen release**

- Temperature range.
- Minimum holding time.

**4.4.15 Post-weld heat-treatment**

The minimum time and temperature range for post-weld heat treatment or ageing shall be specified or reference shall be made to other standards which specify this information.

**4.4.16 Shielding gas**

Designation in accordance with EN 439 and, where applicable, the composition, manufacturer and trade name.

**4.4.17 Heat input**

Range of heat input (if specified).

**4.5 Specific to a group of welding processes****4.5.1 Process 111 (Manual metal arc welding)**

For process 111, the run-out length of electrode consumed or travel speed.

**4.5.2 Process 12 (Submerged arc welding)**

- For multiple electrode systems the number and configuration of wire electrodes and polarity.
- Distance contact tube/work piece: The distance from contact tip nozzle to the surface of the work piece.
- Flux: Designation, manufacturer and trade name.
- Additional filler material.
- Arc voltage range.

**4.5.3 Process 13 (Gas-shielded metal arc welding)**

- Shielding gas flow rate and nozzle diameter.
- Number of wire electrodes.
- Additional filler material.
- The distance from the contact tip/contact tube to the surface of the workpiece.
- Arc voltage range.