
Popis in kvalifikacija varilnih postopkov za kovinske materiale - Preskus varilnega postopka - 6. del: Obločno in plamensko varjenje bakra in njegovih zlitin (ISO 15614-6:2006)

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 6: Arc and gas welding of copper and its alloys (ISO 15614-6:2006)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 6: Lichtbogen- und Gasschweißen von Kupfer und seinen Legierungen (ISO 15614-6:2006)

Descriptif et qualification d'un mode opératoire de soudage pour les matériaux métalliques - Épreuve de qualification d'un mode opératoire de soudage - Partie 6: Soudage à l'arc et aux gaz du cuivre et de ses alliages (ISO 15614-6:2006)

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25.160.10	Varilni postopki in varjenje	Welding processes
77.120.30	Baker in bakrove zlitine	Copper and copper alloys

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Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 6: Arc and gas welding of copper and its alloys (ISO 15614-6:2006)

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Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 6: Lichtbogenschweißen von Kupfer seinen Legierungen (ISO 15614-6:2006)

This European Standard was approved by CEN on 16 March 2006.

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, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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

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EN ISO 15614-6:2006 (E)**Foreword**

This document (EN ISO 15614-6:2006) 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 October 2006, and conflicting national standards shall be withdrawn at the latest by October 2006.

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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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ANNEX ZA

(informative)

Relationship between this International Standard and the Essential Requirements of EU Directive 97/05/IEC

This European Standard has been prepared under a mandate given to CEN by the European Commission to provide a means of conforming to Essential Requirements of the New Approach Directives 97/23/EC.

Once this standard is cited in the Official Journal of the European Communities under that Directive and has been implemented as a national standard in at least one Member State, compliance with the clauses of this standard given in Table ZA confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding Essential Requirements of that Directive and associated EFTA regulations.

Table ZA — Correspondence between this European Standard and Directive 97/23/EC

Clause(s)/Sub-clause(s) of this EN	Essential Requirements (ERs) of Directive 97/23/EC	Qualifying remarks/Notes
Clauses 4, 5, 6, 7, 8, 9, 10	Annex I, 3.1.2	Permanent joining

WARNING: Other requirements and other EU Directives may be applicable to the product(s) falling within the scope of this standard.

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Welding procedure test —**

Part 6:

**Arc and gas welding of copper and its
alloys**

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*Descriptif et qualification d'un mode opératoire de soudage pour les
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Partie 6: Soudage à l'arc et aux gaz du cuivre et de ses alliages

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ISO 15614-6:2006(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 15614-6 was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding*, in collaboration with Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Unification of requirements in the field of metal welding*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

ISO 15614 consists of the following parts, under the general title *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
- Part 2: Arc welding of aluminium and its alloys
- Part 3: Fusion and pressure welding of non-alloyed and low-alloyed cast irons
- Part 4: Finishing welding of aluminium castings
- Part 5: Arc welding of titanium, zirconium and their alloys
- Part 6: Arc and gas welding of copper and its alloys
- Part 7: Overlay welding
- Part 8: Welding of tubes to tube-plate joints
- Part 9: Underwater hyperbaric wet welding
- Part 10: Hyperbaric dry welding
- Part 11: Electron and laser beam welding
- Part 12: Spot, seam and projection welding
- Part 13: Resistance butt and flash welding

Introduction

ISO 15614 is part of a series of standards. Details of this series are given in ISO 15607:2003, Annex A.

Requests for official interpretations of any aspect of this part of ISO 15614 should be directed to the Secretariat of ISO/TC 44/SC 10 via your national standards body, a complete listing of which can be found at www.iso.org.

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