



**SLOVENSKI STANDARD**  
**SIST EN 1011-1:1999/A1:2003**  
**01-maj-2003**

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Welding - Recommendations for welding of metallic materials - Part 1: General guidance for arc welding

Schweißen - Empfehlungen zum Schweißen metallischer Werkstoffe - Teil 1: Allgemeine Anleitungen für das Lichtbogenschweißen

Soudage - Recommandations pour le soudage des matériaux métalliques - Partie 1: Lignes directrices générales pour le soudage à l'arc

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Ta slovenski standard je istoveten z: **EN 1011-1:1998/A1:2002**

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**ICS:**

25.160.10 Varilni postopki in varjenje Welding processes

**SIST EN 1011-1:1999/A1:2003** en

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 1011-1:1998/A1**

May 2002

ICS 25.160.10

English version

## Welding - Recommendations for welding of metallic materials - Part 1: General guidance for arc welding

Soudage - Recommandations pour le soudage des  
matériaux métalliques - Partie 1: Lignes directrices  
générales pour le soudage à l'arc

Schweißen - Empfehlungen zum Schweißen metallischer  
Werkstoffe - Teil 1: Allgemeine Anleitungen für das  
Lichtbogenschweißen

This amendment A1 modifies the European Standard EN 1011-1:1998; it was approved by CEN on 1 April 2002.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant 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 amendment 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, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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

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

**EN 1011-1:1998/A1:2002 (E)****Foreword**

This document EN 1011-1:1998/A1:2002 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 1011-1:1998 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by November 2002, and conflicting national standards shall be withdrawn at the latest by November 2002.

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

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## Foreword

The foreword will now read:

"This European Standard has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS.

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 August 1998, and conflicting national standards shall be withdrawn at the latest by August 1998.

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).

This European Standard is composed of the following parts:

Part 1: General guidance for arc welding

Part 2: Arc welding of ferritic steels

Part 3: Arc welding of stainless steels

Part 4: Arc welding of aluminium and aluminium alloys"

Part 5: Welding of clad steel

Part 6: Laser beam welding

Part 7: Electron beam welding

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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

Paragraph 2 will now be deleted.

In paragraph 3, sentence 2 will now read:

"It is generally applicable to fusion welding of metallic materials and is appropriate regardless of the type of fabrication involved, although the application standard or design specification can have additional requirements."

In paragraph 3, sentence 5 will now read:

"These details should be obtained from the relevant application standard or design specification."

## Clause 3.12 "contract"

This subclause will now be deleted and 3.13 becomes 3.12.

**EN 1011-1:1998/A1:2002 (E)****Clause 5 "Provision of quality requirements"**

Sentence 2 will now read:

"If the manufacturer chooses to have a quality system, the information should be in accordance with the appropriate part of EN 729 (see annex A for further information)."

**Clause 7 "Fusion welding processes"**

Bullets for processes 138 and 139 are deleted.

**Clause 11 "Preparation of joint"**

Paragraph 3 will now read:

"In the event of an imperfection in the preparation of the joint this may be corrected by methods detailed in the design specification."

**Clause 15 "Temporary attachments"**

In paragraph 2, sentence 2 will now read:

"Care should be taken to ensure that such welding is carried out only if permitted by the design specification and that unintended detrimental effects are avoided, e.g. stress raisers and/or shrinkage stresses."

**Clause 21 "Traceability"**

Sentence 1 will now read:

"Adequate means of identification, either by an identification mark or other methods, shall be provided to enable each weld to be traced to the welder/welders or welding operator/operators by whom it was made."

**Clause 22 "Peening"**

The text will now read:

"Peening of welds shall be carried out only in accordance with the application standard or design specification."

**Clause 23 "Inspection and testing"**

The text will now read:

"The method and extent of inspection and testing shall be in accordance with the application standard or design specification."

**Clause 24 "Quality requirements"**

Sentence 2 will now read:

"Acceptance levels shall be in accordance with the design specification."

**Clause 25 "Correction of non-conformity"**

In paragraph 1, sentence 1 will now read:

"Where welds do not comply with the acceptance level of clause 24, remedial action in accordance with the design specification and re-inspection shall be carried out to the original welding procedure or to a procedure in accordance with the design specification."

**Clause 26 "Distortion"**

Sentence 1 will now read:

"Parts distorted by welding, beyond the specified tolerances, may be corrected only by a method in accordance with the design specification."

**Clause 27 "Post-weld heat treatment"**

Paragraph 1 will now read:

"When post-weld heat treatment and/or ageing is required, this shall be carried out in accordance with the design specification."

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**Clause 28 "Post-weld cleaning"**

Paragraph 1 will now read:

"Post-weld cleaning, if necessary, shall be carried out in accordance with the design specification."

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**Annex A "Information and items to be agreed and to be available prior to the start of fabrication"**

The title will now be:

"Information to be supplied prior to the start of fabrication and to be defined in the design specification"

**A.1 "General"**

A.1 will now read:

"When EN 729 is applied, only the relevant clauses of that standard are to be observed. When EN 729 is not applied, the information detailed in A.2 and A.3 should be available."

**A.2 "Information to be supplied by the purchaser"**

The title of A.2 will now be:

"Information to be supplied prior to the start of fabrication"

The footnote <sup>1)</sup> will now be deleted.

The first paragraph will now read:

**EN 1011-1:1998/A1:2002 (E)**

"The following information is to be supplied prior to the start of fabrication:"

The note will now read:

"NOTE The items referred to in this clause may have a significant effect upon the performance of the fabrication and its should be ensured that they relate appropriately to the particular joints and intended service of the final product."

**A.3 "Items to be agreed"**

The title will now be:

"Items to be defined in the design specification"

The first paragraph will now read:

"The following items are to be defined in the design specification are to be fully recorded."

**Annex ZA "Clauses of this European Standard addressing essential requirements or other provisions of EU Directives"**

This annex ZA have to be added as follows:

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