



SLOVENSKI STANDARD SIST EN ISO 17637:2011

01-december-2011

Nadomešča:
SIST EN 970:1998

Neporušitveno preskušanje zvarov - Vizualni pregled zvarnih spojev pri talilnem varjenju (ISO 17637:2003)

Non-destructive testing of welds - Visual testing of fusion-welded joints (ISO 17637:2003)

Zerstörungsfreie Prüfung von Schweißverbindungen - Sichtprüfung von Schmelzschweißverbindungen (ISO 17637:2003)

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Contrôle non destructif des assemblages soudés - Contrôle visuel des assemblages soudés par fusion (ISO 17637:2003)

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Ta slovenski standard je istoveten z: EN ISO 17637:2011

ICS:

25.160.40 Varjeni spoji in vari Welded joints

SIST EN ISO 17637:2011 **en,de**

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EUROPEAN STANDARD

EN ISO 17637

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2011

ICS 25.160.40

Supersedes EN 970:1997

English Version

Non-destructive testing of welds - Visual testing of fusion-welded joints (ISO 17637:2003)

Contrôle non destructif des assemblages soudés - Contrôle visuel des assemblages soudés par fusion (ISO 17637:2003)

Zerstörungsfreie Prüfung von Schweißverbindungen - Sichtprüfung von Schmelzschweißverbindungen (ISO 17637:2003)

This European Standard was approved by CEN on 13 February 2011.

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

Management Centre: Avenue Marnix 17, B-1000 Brussels

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Foreword

The text of ISO 17637:2003 has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" of the International Organization for Standardization (ISO) and has been taken over as EN ISO 17637:2011 by Technical Committee CEN/TC 121 "Welding" the secretariat of which is held by DIN.

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of an identical text or by endorsement, at the latest by September 2011, and conflicting national standards shall be withdrawn at the latest by September 2011.

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

This document supersedes EN 970:1997.

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Endorsement notice

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INTERNATIONAL
STANDARD

ISO
17637

First edition
2003-07-15

**Non-destructive testing of welds —
Visual testing of fusion-welded joints**

*Contrôle non destructif des assemblages soudés — Contrôle visuel des
assemblages soudés par fusion*

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Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
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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 17637 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 5, *Testing and inspection of welds*.

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Non-destructive testing of welds — Visual testing of fusion-welded joints

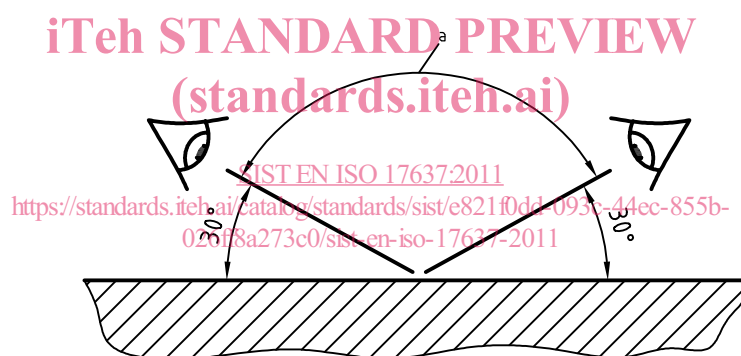
1 Scope

This International Standard covers the visual testing of fusion welds in metallic materials. It may also be applied to visual testing of the joint prior to welding.

2 Test conditions and equipment

The illuminance at the surface shall be a minimum of 350 lx. However, 500 lx is recommended.

For direct inspection, the access shall be sufficient to place the eye within 600 mm of the surface to be examined and at an angle not less than 30° (see Figure 1).



^a Range

Figure 1 — Access for testing

Remote inspection using mirrors, boroscopes, fibre optic cables or cameras shall be considered when the access for testing in accordance with Figure 1 is not possible or when specified by an application standard.

An additional light source can be used to increase the contrast and relief between imperfections and the background.

Where the result of visual testing is inconclusive, the visual test should be supplemented by other non-destructive testing methods for surface inspections.

Examples of equipment used for visual testing are given in Annex A.

3 Personnel qualification

Visual testing of welds and the evaluation of results for final acceptance shall be performed by qualified and capable personnel. It is recommended that personnel be qualified in accordance with ISO 9712 or an equivalent standard at an appropriate level in the relevant industry sector.