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**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**

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AMENDMENT 1

*ISO 15614-1:2004/Amd.1:2008*  
*Descriptif et qualification d'un mode opératoire de soudage pour les*  
*matériaux métalliques — Épreuve de qualification d'un mode opératoire*  
*de soudage — 1-2004-amd-1-2008*  
<https://standards.iteh.ai/en/standards/iso/9771/iso-15614-1-2004-amd-1-2008/366244791409/>

*Partie 1: Soudage à l'arc et aux gaz des aciers et soudage à l'arc des  
nickels et alliages de nickel*

AMENDEMENT 1



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Published in Switzerland

## Foreword

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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.

Amendment 1 to ISO 15614-1:2004 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).

Requests for official interpretations of any aspect of this Amendment to ISO 15614-1 should be directed to the Secretariat of ISO/TC 44/SC 10 via your national standards body. A complete listing of these bodies can be found at [www.iso.org](http://www.iso.org).

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# 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

### AMENDMENT 1

*Page v, Foreword, para 1*

Delete “DS”, insert “DIN”.

*Pages 2 to 3, Clause 2* iTeh STANDARD PREVIEW

Delete the entries for EN 439 and EN 25817.

After the normative reference entry for EN 1714, delete the remaining entries, and insert:

“EN 12062, *Non-destructive examination of welds — General rules for metallic materials*

ISO 4063:1998, *Welding and allied processes — Nomenclature of processes and reference numbers*

ISO 5817:2003, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections*

ISO 6947:1990, *Welds — Working positions — Definitions of angles of slope and rotation*

ISO 9606-1, *Qualification test of welders — Fusion welding — Part 1: Steels*

ISO 9606-4:1999, *Approval testing of welders — Fusion welding — Part 4: Nickel and nickel alloys*

ISO 14175, *Welding consumables — Gases and gas mixtures for fusion welding and allied processes*

ISO 15607:2003, *Specification and qualification of welding procedures for metallic materials — General rules*

ISO/TR 15608:2005, *Welding — Guidelines for a metallic materials grouping system*

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

ISO 15609-2:2001, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 2: Gas welding*

ISO 15613:2004, *Specification and qualification of welding procedures for metallic materials — Qualification based on pre-production welding test”*

**ISO 15614-1:2004/Amd.1:2008(E)**

*Page 6, Figure 3*

In the drawing, delete the (lowest horizontal) label for the front edge width, “*b*”, insert “*a*”.

*Page 16, 7.5*

Delete “EN 25817”, insert “ISO 5817”.

Delete the text after the colon and the NOTE, and insert “excess convexity, excess throat thickness and excessive penetration and incorrect weld toe, for which level C shall apply. The requirement  $\leq 0,05 t$  does not apply for undercut. Undercut shall be  $\leq 0,5$  mm. Angular misalignment is not applicable for the welding procedure test.

NOTE The correlation between the quality levels of ISO 5817 and the acceptance levels of the different NDT techniques are given in EN 12062.”

*Page 17, 8.1*

Delete “Clause 7”, insert “Clause 8”.

*Page 17, 8.3.1*

Insert the following sentence immediately before the NOTE:

“Permanent backing material shall be considered as a parent metal within the approval (sub-)group.”

*Page 18, Table 3, column 2, row 11*

Against “8-8”, delete “8<sup>c</sup>”, insert “8<sup>b</sup>”.

*Pages 23 and 24: 8.5.2.1, 8.5.3.1, 8.5.4.2*

Delete (six times) “EN 439”, insert (six times) “ISO 14175”.

*Page 24, 8.5.4.2*

Delete “qualified”, insert “used in the test”.

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