



**SLOVENSKI STANDARD  
SIST EN ISO 13585:2024**

**01-oktober-2024**

**Nadomešča:  
SIST EN ISO 13585:2012**

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**Trdo spajkanje - Preskušanje za kvalifikacijo spajkalcev in operaterjev (ISO 13585:2021)**

Brazing - Qualification testing of brazers and brazing operators (ISO 13585:2021)

Hartlöten - Prüfung von Hartlötern und Bedienern von Hartlöteinrichtungen (ISO 13585:2021)

Brasage fort - Essais de qualification des braseurs et des opérateurs braseurs en brasage fort (ISO 13585:2021)

**Ta slovenski standard je istoveten z: EN ISO 13585:2024**

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**ICS:**

03.100.30	Vodenje ljudi	Management of human resources
25.160.50	Trdo in mehko lotanje	Brazing and soldering

**SIST EN ISO 13585:2024** **en,fr,de**



EUROPEAN STANDARD

EN ISO 13585

NORME EUROPÉENNE

EUROPÄISCHE NORM

July 2024

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Supersedes EN ISO 13585:2012

English Version

## Brazing - Qualification testing of brazers and brazing operators (ISO 13585:2021)

Brasage fort - Essais de qualification des braseurs et des opérateurs braseurs en brasage fort (ISO 13585:2021)

Hartlöten - Prüfung von Hartlötern und Bedienern von Hartlöteinrichtungen (ISO 13585:2021)

This European Standard was approved by CEN on 9 March 2024.

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 CEN-CENELEC Management Centre 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 CEN-CENELEC Management Centre has the same status as the official versions.

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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

**EN ISO 13585:2024 (E)**

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## European foreword

The text of ISO 13585:2021 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 13585:2024 by Technical Committee CEN/TC 121 "Welding and allied processes" the secretariat of which is held by AFNOR.

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 January 2025, and conflicting national standards shall be withdrawn at the latest by January 2025.

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

This document supersedes EN ISO 13585:2012.

This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

For the relationship with EU Legislation, see informative Annex ZA, which is an integral part of this document.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

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

## Endorsement notice

The text of ISO 13585:2021 has been approved by CEN as EN ISO 13585:2024 without any modification.

## Annex ZA (informative)

### Relationship between this European Standard and the essential requirements of EU Directive 2014/68/EU aimed to be covered

This European Standard has been prepared under a Commission's standardization request M/601 "Mandate to CEN for standardization in the field of Pressure equipment" to provide one voluntary means of conforming to essential requirements of Directive 2014/68/EU "Pressure equipment".

Once this standard is cited in the Official Journal of the European Union under that Directive 2014/68/EU compliance with the normative clauses of this standard given in Table ZA.1 and application of the edition of the normatively referenced standards as given in Table ZA.2 confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding essential requirements of that Directive 2014/68/EU, and associated EFTA regulations.

**Table ZA.1 — Correspondence between this European Standard and Annex I of the Directive 2014/68/EU (PED)**

Essential Requirements of Directive 2014/68/EU	Clause(s)/sub-clause(s) of this EN	Remarks/Notes
3.1.2, paragraphs 3, 4 and 5	5 (without 5.3.4, 3rd paragraph), 6, 7, 8, 9, 10, Annex E2	Permanent joining. For pressure resistant components of pressure equipment in the categories II, III and IV the examiner/examining body is a competent third party.

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**Table ZA.2 — Applicable Standards to confer presumption of conformity as described in this Annex ZA**

<b>Column 1 Reference in Clause 2</b>	<b>Column 2 International Standard Edition</b>	<b>Column 3 Title</b>	<b>Column 4 Corresponding European Standard Edition</b>
ISO 857-2	ISO 857-2:2005	<i>Welding and allied processes — Vocabulary — Part 2: Soldering and brazing processes and related terms</i>	None For applicable standard edition see Column 2
ISO 4063:2009	ISO 4063:2009	<i>Welding and allied processes — Nomenclature of processes and reference numbers</i>	EN ISO 4063:2010
ISO 17672	ISO 17672:2016	<i>Brazing — Filler metals</i>	EN ISO 17672:2016
ISO 17779	ISO 17779:2021	<i>Brazing — Specification and qualification of brazing procedures for metallic materials</i>	None For applicable standard edition see Column 2
ISO 18279:2003	ISO 18279:2003	<i>Brazing — Imperfections in brazed joints</i>	EN ISO 18279:2003
ISO/TR 25901-1	ISO/TR 25901- 1:2016	<i>Welding and allied processes — Vocabulary — Part 1: General terms</i>	None For applicable standard edition see Column 2
EN 12797	None	<i>Brazing — Destructive tests of brazed joints</i>	EN 12797:2000 EN 12797:2000/A1:2003
EN 12799	None	<i>Brazing — Non-destructive examination of brazed joints</i>	EN 12799:2000 EN 12799:2000/A1:2003

The documents listed in the Column 1 of Table ZA.2, in whole or in part, are normatively referenced in this document, i.e. are indispensable for its application. The achievement of the presumption of conformity is subject to the application of the edition of Standards as listed in Column 4 or, if no European Standard Edition exists, the International Standard Edition given in Column 2 of Table ZA.2.

**WARNING 1** — Presumption of conformity stays valid only as long as a reference to this European Standard is maintained in the list published in the Official Journal of the European Union. Users of this standard should consult frequently the latest list published in the Official Journal of the European Union.

**WARNING 2** — Other Union legislation may be applicable to the products falling within the scope of this standard.





INTERNATIONAL  
STANDARD

ISO  
13585

Second edition  
2021-12

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**Brazing — Qualification testing of  
brazers and brazing operators**

*Brasage fort — Essais de qualification des braseurs et des opérateurs  
braseurs en brasage fort*

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