

ISO/TC 44/SC 10

Secretariat: DIN

Voting begins on:  
2020-07-23

Voting terminates on:  
2020-09-17

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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 2**

*Descriptif et qualification d'un mode opératoire de soudage pour  
les matériaux métalliques — Épreuve de qualification d'un mode  
opératoire de soudage*

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

*AMENDEMENT 2*

<https://standards.iteh.ai/catalog/standards/sist/15848c46-7a57-401d-8978-9c0d765bcca1a/iso-15614-1-2017-fdam-2>

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Reference number  
ISO 15614-1:2017/FDAM 2:2020(E)

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Published in Switzerland

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

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Quality management in the field of welding*.

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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 2

#### 8.4.1

Replace the first paragraphs for levels 1 and 2 with the following:

The degree of mechanization is not an essential variable.

#### 8.4.7

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Replace the second paragraph for level 2 with the following:

For level 2: When impact requirements apply, the upper limit of the heat input qualified is 25 % greater than the average heat input used in welding the test piece. When hardness requirements apply, the lower limit of the heat input qualified is 25 % lower than the average heat input used in welding the test piece. If welding procedure test has been performed at both a high and a low heat input level, then all intermediate heat input levels are also qualified.

It is recommended to split the heat input for root, filler and capping run(s).