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**Friction stir welding — Aluminium —  
Part 5:  
Quality and inspection requirements**

*Soudage par friction-malaxage — Aluminium —  
Partie 5: Exigences de qualité et de contrôle*

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## Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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This document was prepared by IIW, *International Institute of Welding*, Commission III, *Resistance Welding, Solid State Welding and Allied Joining Process*, 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 second edition cancels and replaces the first edition (ISO 25239-5:2011), which has been technically revised.

The main changes compared to the previous edition are as follows:

- the concept of three different acceptance levels for the assessment of weld quality has been added to [Annex A](#);
- the following imperfections have been added to [Table A.1](#): angular misalignment, joint area deformation, surface breaking cavity, solid inclusion, joint remnants and multiple imperfections;
- the requirements for personnel performing non-destructive testing and visual testing have been aligned with ISO 17637

A list of all parts in the ISO 25239 series can be found on the ISO website.

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