# SLOVENSKI STANDARD
# oSIST prEN ISO 13585:2026

**01-april-2026**

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**Trdo spajkanje - Preskušanje za kvalifikacijo spajkalcev in operaterjev (ISO/DIS 13585:2026)**

Brazing - Qualification testing of brazers and brazing operators (ISO/DIS 13585:2026)

Hartlöten - Qualifizierungsprüfung von Hartlötern und Bedienern von Hartlöteinrichtungen (ISO/DIS 13585:2026)

Brasage fort - Essais de qualification des braseurs et des opérateurs braseurs en brasage fort (ISO/DIS 13585:2026)

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**ICS:**

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

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# DRAFT International Standard

# ISO/DIS 13585

## Brazing — Qualification testing of brazers and brazing operators

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

ICS: 25.160.01

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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.

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).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes* Subcommittee SC 11, *Qualification requirements for welding and allied processes personnel*, 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).

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This third edition cancels and replaces the second edition (ISO 13585:2021), which has been technically revised.

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

— brazing processes, in accordance with ISO 4063:2023 , covered by this document, have been moved to the scope;

— Clause 3 has been updated and additional terms have been defined;

— additional symbols and abbreviated terms have been added to Clause 4;

— Clause 5 has been significantly revised and updated including clarifications on brazing operator qualification;

— material grouping has been moved to new Annex E;

— Clause 6 has been updated to refer to ISO or technically equivalent standards;

— the period of validity and prolongation of qualifications has been revised to 5 years in Clause 9.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: https://committee.iso.org/sites/tc44/home/interpretation.html.

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# Brazing — Qualification testing of brazers and brazing operators

## 1 Scope

This document specifies requirements for qualification testing of brazers and brazing operators for metallic materials.

This document applies to the following brazing processes according to ISO 857-2 and ISO 4063:2023 with local and global heating:

— 911 Infrared brazing;

— 912 Flame brazing, torch brazing;

— 913 Laser beam brazing;

— 914 Electron beam brazing;

— 916 Induction brazing;

— 918 Resistance brazing;

— 919 Diffusion brazing;

— 921 Furnace brazing;

— 922 Vacuum brazing;

— 923 Dip-bath brazing;

— 924 Salt-bath brazing;

— 925 Flux bath brazing;

— 926 Immersion brazing;

— 972 Arc weld brazing.

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This document is not applicable to personnel operating brazing equipment who do not have any direct influence on the quality of the brazed joint, for example, personnel performing exclusively loading/unloading the brazing unit or just initiating the brazing cycle in automatic brazing.

This document does not apply to brazing for aerospace applications covered by ISO 11745.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 857-2:2005, *Welding and allied processes — Vocabulary — Part 2: Soldering and brazing processes and related terms*

ISO 4063:2023, *Welding, brazing, soldering and cutting — Nomenclature of processes and reference numbers*

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