
Popis in kvalifikacija varilnih postopkov za kovinske materiale - Preskus varilnega postopka - 1. del: Obločno in plamensko varjenje jekel in obločno varjenje niklja in nikljevih zlitin (ISO/DIS 15614-1:2025)

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 (ISO/DIS 15614-1:2025)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 1: Lichtbogen- und Gasschweißen von Stählen und Lichtbogenschweißen von Nickel und Nickellegierungen (ISO/DIS 15614-1:2025)

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 (ISO/DIS 15614-1:2025)

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77.080.20	Jekla	Steels
77.120.40	Nikelj, krom in njune zlitine	Nickel, chromium and their alloys

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DRAFT International Standard

ISO/DIS 15614-1

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

*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*

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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).

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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 third edition cancels and replaces the second edition (ISO 15614-1:2017 and ISO 15614:2017/Amd 1:2019), which has been technically revised. prEN ISO 15614-1:2025

The main changes are as follows:

- change of structure from two-column to single-column display of Level 1 and Level 2;
- unambiguous definition of square or rectangular hollow section under [6.2.3](#);
- steel group 11 added in [Table 3](#) (permitted maximum hardness values);
- [subclause 7.6](#) (Re-testing) restructured.
- definition of “welding under the same technical and quality control” were clarified under [subclause 8.2](#);
- [subclause 8.3.3](#) (Diameter of pipes and branch connections) for Level 2 were technical revised;
- degree of mechanization is no longer an essential requirement, see [8.4.1](#);
- welding position is no longer an essential requirement, see [8.4.2](#);
- reference to ISO 18491 were added under [subclause 8.4.7](#) (Arc energy or heat input);
- limit of 150°C were added under [subclause 8.4.9](#) (Interpass temperature);
- under Level 2, the requirements regarding submerged arc welding were revised, see [8.5.1](#);
- normative references and bibliography were updated.

A list of all parts in the ISO 15614 series can be found on the ISO website.