Deskriptoren: Schweißerprüfung, Interpretationen

1 Anwendungsbereich und Zweck

Dieses Merkblatt dient der Klärung von Fragen zur internationalen Norm ISO 9606-1.

Seit Veröffentlichung von ISO 9606-1 „Qualification testing of welders – Fusion welding – Part 1: Steels“ im Jahr 2012 sind aus verschiedenen Ländern Anfragen zum Verständnis und zur Auslegung der Norm gestellt worden. Das zuständige Normungsgremium ISO/TC 44/SC 11“Qualification requirements for welding and allied processes personnel“ behandelt diese Fragen in seinen Sitzungen und veröffentlicht diese dann regelmäßig. Alle bislang gestellten Fragen wurden in den Sitzungen von ISO/TC 44/SC 11 behandelt und beantwortet.

2 Gestellte Fragen

Im Folgenden sind die bisher gestellten Fragen in der Originalfassung zur ISO 9606-1:2012, einschließlich Cor 1:2012; entsprechend der Deutschen Fassung DIN EN ISO 9606-1:2013 „Prüfung von Schweißern – Schmelzschweißen – Teil 1: Stähle“, wiedergegeben.

ISO/TC44 /SC 11 wird dabei:

- keine Beratung zur Anwendung der Norm liefern,
- keine Erläuterungen der Anforderungen selbst geben;
- nur die Anforderungen in der Norm klären;
- die Antworten nur mit ja oder nein geben und ggf. lediglich kurze Erklärungen liefern, wo es dem Leser hilft.

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	5.4 d)	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
In the absence of a standard to qualify manual or semi-automatic welders for corrosion resistant overlay welding to a procedure qualified to ISO15614-7 can a test in accordance with ISO9606-1 : 5.4 d) be carried out as per ISO15614-7 Fig 1 or 2 but with sizes reduced to 150mm x 150mm for plate and a minimum of 150mm long for pipe to facilitate 100 % visual inspection and 4 off side bends as per ISO9606-1 Table 13?
Answer proposed by the author of the question:
YES. This would also align with ASME IX QW 453
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2016-05-18

Notes:

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4. SC XX will not provide justifications/explanations of any requirements

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

5. SC XX will only provide clarification of requirements

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	5.4, Type of weld b)	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
If a welder produced a test piece under 5.4 b), are the tests according to table 13 for fillet and butt welds required?
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed (will be clarified in next edition to say butt and fillet welds in p2 of 5.4, b))
Date of ISO/TC 44/SC 11 answer
2015-04-23

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	5.4, Type of weld e)	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
A welder is qualified for a butt weld in position PE with an additional supplementary fillet weld test piece in the position PB. Is his range qualified is PA, PB, PC, PD, PE for fillet welds?
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed (will be revised in next edition)
Date of ISO/TC 44/SC 11 answer
2015-04-23

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	5.4 e)	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Should the reference in paragraph 5.4 to Figure 3 be figure 4?
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed (will be revised in next edition)
Date of ISO/TC 44/SC 11 answer
2015-04-23

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	5.7	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
In the case of separate welder's qualification test certificate for a single welder, with different completion dates and with different examiner/examining body, can the range of qualification in diameter and thickness be combined under Clause 5.7
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2018-02-27

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012+COR1 and COR2	6.3	SC 11
Title		
Qualification testing of welders -- Fusion welding -- Part 1: Steels		

Needed interpretation :
Does the pWPS used for the qualification test have to be qualified?
Proposed interpretation by the author:
No
Response from the SC responsible for the standard:
Agreed - No
Date of ISO/TC 44/SC 11 answer
2019-03-25

Notes:

1. Requests should be submitted to national committees first (where they exist) before submittal to SC 11.
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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	9.3 c) and Annex A	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:

Is it possible to get an interpretation on Annex A in the new version of BS EN ISO 9606-1 regarding the expected involvement of a Notified Body or Recognised Third Party Organisation for prolongation in accordance with Clause 9.3c of the specification

Answer proposed by the author of the question:

Proposed Interpretation:

The opening sentence of 9.3 states the examiner or examining body carries out the re validation and this applies to all re validation methods.

a) – retest

b) – revalidate two years

c) – revalidate every six months

The certificate still needs to be signed by the RWC (Responsible Welding Coordinator) or responsible supervisor within the fabrication company every six months.

It may be that the original examiner or examining body does not carry out the revalidation. However, the organisation carrying out the revalidation under 9.3 b) or c) needs to be equivalent to make the certificate equivalent in acceptability to its original issue status. Example: a NoBo (notified body) or RTPO (Recognised Third Party Organisation) issues the certificate under the PED then re validation under 9.3 b) would be an equivalent body.

NOTE: recent developments from the CEN consultant that option c) under categories 2,3 and 4 that this option is not recognised under the PED."

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Answer of the SC in charge:
Agreed (Denmark and Japan disagree)
Date of ISO/TC 44/SC 11 answer
2016-08-01

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	5.3 b) and c)	SC 11

Title

Qualification testing of welders – Fusion welding – Part 1: Steels

Question:

I am confused about clause 5.3 b and c. Two plate test sample is welded and one is welded for butt weld in PA position, and the other one is welded for fillet weld in PB position. What should be range of qualification for product type in this test? Should it be " P, T; D >=500 mm fixed PB, D >=75 mm rotating PA and PB" like this or there is something that I have misunderstood about those clause? And if only one plate was welded in PA position, should range of qualification of product type have been like this according to the clause 5.3 b and c; "P, T; D >=75 mm rotating PA" ?

Answer proposed by the author of the question:

If I understand it well, the problem is that it isn't possible to weld in a BW or FW in a fixed pipe in the PA position, the pipe must rotated otherwise it isn't technical not possible to weld this pipe.

This means that 5.3.b cannot be applicable, and if he want to weld a pipe in the PA position he must rotate the pipe, and the 5.3.c is applicable and the range is D≥75 mm
For the butt weld the range should be PA ≥ 75 mm and for the fillet PA, PB D≥75 mm (rotated) or PB ≥ 500 mm (PA fixed in pipe is also not possible.)

Answer of the SC in charge:

Agreed

Date of ISO/TC 44/SC 11 answer

2016-05-18

Notes:

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Introduction and 5.4 e)	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Can a welder qualified in accordance with EN 287-1 be given an additional fillet weld test in accordance with ISO 9606-1:2012, Clause 5.4.e, to extend his range of qualification for butt welding to include fillet welds?
Answer proposed by the author of the question:
Yes And this shall be indicated on the alignment document. The validation period of the alignment document is determined by the validation period for the butt weld.
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2014-04-08

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Introduction and 6.5.2.3	SC 11

Title

Qualification testing of welders – Fusion welding – Part 1: Steels

Question:

A welder took a test under ISO 9606-1:1994 or EN 287-1. The test piece was examined by bend testing in full accordance with that standard. Is that test considered to be "technically equivalent" to the bend tests specified in (EN-) ISO 9606-1:2012?

Answer proposed by the author of the question:

Yes

Answer of the SC in charge:

Agreed

Date of ISO/TC 44/SC 11 answer

2014-04-08

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Introduction and 9.3 b)	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
For existing welder qualifications to ISO 9606-1:1994 or EN 287-1, can a new qualification record be prepared using the testing conditions shown on the existing qualification record but applying the ranges qualified in accordance with ISO 9606- 1:2012?
Answer proposed by the author of the question:
Yes Provided that sufficient data is available to address that all qualification variables specified in (EN) ISO 9606-1:2012 are satisfied. The new alignment document shall indicate that revalidation is based on the requirements of ISO 9606-1:2012+COR 1:2012, Clause 9.3 b).
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2014-04-08

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

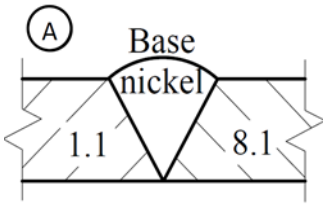
Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	N/A	SC 11

Title

Qualification testing of welders – Fusion welding – Part 1: Steels

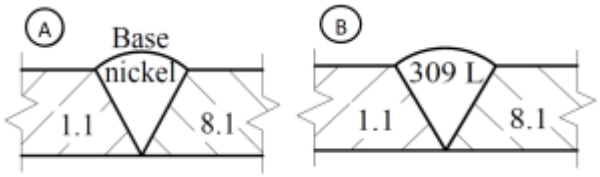
Question:

Q1. Which of ISO 287-1 or ISO 9606-4 standard shall be use to qualify the welders for type assembly 'A' here below?



Q2. Based on answer to question 1 above

A welder qualified with ISO 287-1 (or ISO 9606-4) standard in GTAW (141)process with solid wire on the assembly A is he qualified to weld assembly B?



Answer proposed by the author of the question:

A.1
EN 287-1 is withdrawn.

ISO 9606-1 shall be used

If this is an existing EN 287-1 qualification, the ranges of EN ISO 9606-1 applies.

A.2

According ISO 9606-1 FM6 qualifies for FM5 so the answer is 'Yes"

Answer of the SC in charge:

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Agreed (France disagreed)
Date of ISO/TC 44/SC 11 answer
2016-05-18

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 6	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:

A welder welds a butt weld test piece that is 12 mm thick in which he deposits one layer of weld metal 3 mm thick using process 138 followed by two layers of weld metal 9 mm thick using process 136 as permitted by the last clause of part 5.2

For the above test piece, may a welder make a production weld using both welding processes depositing 6 mm of weld metal using process 138 and 18 mm of weld metal using process 136 in one joint?

Answer proposed by the author of the question:

Yes

However, only process 138 can be used for the root deposit according to Table 1 when that root deposit is made without backing.

Answer of the SC in charge:

Agreed

Date of ISO/TC 44/SC 11 answer

2015-04-23

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 6	SC 11

Title

Qualification testing of welders – Fusion welding – Part 1: Steels

Question:

A welder welds a butt weld test piece that is 12 mm thick in which he deposits one layer of weld metal 3 mm thick using process 138 followed by two layers of weld metal 9 mm thick using process 136 as permitted by the last clause of part 5.2

Is this welder qualified to deposit weld metal from 3 to 6 mm in thickness using process 138 and from 3 to 18 mm in thickness using process 136 with each process separately?

Answer proposed by the author of the question:

Yes

The weld deposit thickness range for which the welder is qualified is based on the approximate deposit thickness that he deposits with each process in the test piece.

See Table 6, note f. and Table 1

Answer of the SC in charge:

Agreed

Date of ISO/TC 44/SC 11 answer

2015-04-23

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 6, Note f	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
"For multi-processes, s is the deposited thickness for each process" applies to the last line. Does it apply also to thinner test pieces that are welded with more than one process?
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2012-07-18

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 7	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Is the thickness range for a fillet weld test piece t=1,4 mm, 1,4mm to 3,0mm?
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2015-04-23

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 7	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Is the thickness range for a fillet weld test piece t=2,9 mm, 2,9mm – 5,8 mm.
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2015-04-23

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 7	SC 11

Title

Qualification testing of welders – Fusion welding – Part 1: Steels

Question:

What is the qualified thickness range for a welder that took a fillet weld test with a test piece with unequal plate thicknesses for example plate ta=2 mm welded to plate tB=20 mm?

The thickness range is:

Plate A = 2 - 4 mm

Plate B ≥ 3 mm.

Answer proposed by the author of the question:

Yes

Answer of the SC in charge:

Agreed

Date of ISO/TC 44/SC 11 answer

2015-04-23

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 9	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Does H-L045 qualify PH? and Does J-L045 qualify PJ?
Answer proposed by the author of the question:
Yes The heading for columns 1 to 5 will be revised to read "Range of qualification for production welding" in the next edition
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2014-04-08

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 11 & Annex A	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:

When using process 13, 14 or 15, a welder qualifies without material backing and without gas backing, his range qualified is with and without material backing and with and without gas backing.

When completing the “range qualified" column on the record, the abbreviations available to show what a welder is qualified to do are mb (with material backing), gb (with gas backing) and nb

(with no backing). Does the abbreviation “nb” include welding without material backing and without gas backing?

Answer proposed by the author of the question:

Yes

Answer of the SC in charge:

Agreed

Date of ISO/TC 44/SC 11 answer

2015-04-23

Notes:

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 11	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Does the use of Flux backing only apply to processes 121, 125, 13, 14 and 15
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2015-04-23

Notes:

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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 11	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Does gas backing only apply for processes 13, 14 and 15?
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2012-07-18

Notes:

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5. SC XX will only provide clarification of requirements

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 11	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Does consumable insert only apply to processes 14 and 15?
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2012-07-18

Notes:

1. Requests should be submitted to national committees first (where they exist) before submittal to SC XX.
2. Requests should be submitted with a proposed response where SC XX can respond YES or NO with additional explanation as needed.
3. SC XX will not provide consulting services
4. SC XX will not provide justifications/explanations of any requirements
5. SC XX will only provide clarification of requirements

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Table 11	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
Does the use of Flux backing only apply to processes 13, 14 and 15
Answer proposed by the author of the question:
Yes
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2012-07-18

Notes:

1. Requests should be submitted to national committees first (where they exist) before submittal to SC XX.
2. Requests should be submitted with a proposed response where SC XX can respond YES or NO with additional explanation as needed.
3. SC XX will not provide consulting services
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Type of question: ***Request for interpretation of ISO/TC 44 published standards***

Reference *(including edition and any published corrigenda or amendment)*	***Subclause number***	***SC in charge***
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013	Tables 1 and 6	SC 11
Title		
Qualification testing of welders – Fusion welding – Part 1: Steels		

Question:
A welder welds a butt weld test piece that is 12 mm thick in which he deposits one layer of weld metal 3 mm thick using process 138 followed by two layers of weld metal 9 mm thick using process 136 as permitted by the last clause of part 5.2 For the above test piece, may a welder make a production weld that is 24 mm of weld metal using only process 136 in one joint based on Table 1, multi-process qualification column where s = s1 + s2?
Answer proposed by the author of the question:
No In Table 1in the multi-process qualification column, s is simply the deposited thickness in the weld consisting of s1 + s2.
Answer of the SC in charge:
Agreed
Date of ISO/TC 44/SC 11 answer
2015-04-23

Notes:

1. Requests should be submitted to national committees first (where they exist) before submittal to SC XX.
2. Requests should be submitted with a proposed response where SC XX can respond YES or NO with additional explanation as needed.

Type of question: ***Request for interpretation of ISO/TC 44 published standards***

3. SC XX will not provide consulting services
4. SC XX will not provide justifications/explanations of any requirements
5. SC XX will only provide clarification of requirements