



ISO/TC 44/SC 11
Qualification requirements for welding and allied processes personnel

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ISO 9606-1-2012 Interpretations 2014-07-29

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Expected action: INFO

Background: Replaces N292

We will soon have a public page where this information will be posted for users of ISO 9606-1 and EN ISO 9606-1

Committee URL: <http://isotc.iso.org/livelink/livelink/open/tc44sc11>

Interpretations
ISO 9606-1:2012 + Cor 1:2012 and Cor 2:2013

New interpretations to be considered by SC 11

A.1
Component: Clause 8.4, Type of weld b)
Question: If a welder took a test under 8.4 b) the additional required test methods to the volumetric examinations are bend test according to ISO 5173 or two macro sections according table 13 note e.
Proposed reply: Yes

A.2
Component: Type of weld, 5.4 e)
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?
Proposed reply: Yes.

A.3
Component: Table 11 and Annex A
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?
Proposed reply: Yes

A.4
Component: Table 11
Question: Does the use of Flux backing only apply to processes 121, 125, 13, 14 and 15
Proposed reply: Yes

Interpretations as considered by SC 11

Component: Introduction, 9.3 b)
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?
Reply: 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).
Date: 2014-04-08

Component: Introduction, 5.4 e)
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?
Reply: 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.
Date: 2014-04-08

Component: Introduction, 6.5.2.3
Question: 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?
Reply: Yes.
Date: 2014-04-08

Component: Table 9
Question: Does H-L045 qualify PH? and Does J-L045 qualify PJ?
Reply: Yes. The heading for columns 1 to 5 will be revised to read "Range of qualification for production welding" in the next edition
Date: 2014-04-08

Component: Table 6, Note f
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?
Reply: Yes
Date: 2012-07-18

Component: Table 11
Question: Does gas backing only apply for processes 13, 14 and 15?
Reply: Yes
Date: 2012-07-18

Component: Table 11
Question: Does consumable insert only apply to processes 14 and 15?
Reply: Yes
Date: 2012-07-18

Component: Table 11
Question: Does the use of Flux backing only apply to processes 13, 14 and 15
Reply: Yes
Date: 2012-07-18