

Conditions for Use of ISO 15612 Standard Welding Procedures

SCOPE

ISO 15612 WPS are not permitted for construction where impact testing of the WPS is required by the construction code. ISO 15612 WPS may be required to be approved by the client / project prior to use.

USE OF STANDARD WELDING PROCEDURES

The use of this Standard Welding Procedure requires welding coordination in accordance with ISO 3834 as required by ISO 14731 (supercedes EN 719) and ISO 3834-1 (supercedes EN 729).

The user of this Standard Welding Procedure is responsible for the appropriate selection and application of the Standard Welding Procedure.

The manufacturer or contractor shall comply with the following requirements prior to use in production:

- a) Enter name of the manufacturer or contractor on the ISO 15612 Standard Welding Procedure.
- b) An employee of that manufacturer or contractor shall sign and date the welding procedure.
- c) All qualification records shall be traceable to the original source during the entire period of use.
- d) Welders employed by the manufacturer or contractor utilising ISO 15612 Standard Welding Procedures shall be qualified in accordance with ISO 9606-1.
- e) The type of welding equipment used in production shall be as stated on the Standard Welding Procedure and such equipment shall permit control of all essential welding parameters.

OTHER RESTRICTIONS USING STANDARD WELDING PROCEDURES

- a) The manufacturer or contractor may not deviate from the welding conditions specified on the WPS. Any change in the WPS variables shall require qualification in accordance with ISO 15614-1.
- b) ISO 15612 Standard Welding Procedures may not be supplemented with additional PQR's or revised in any manner.
- c) Multiple ISO 15612 Standard Welding Procedures shall not be used in the same production joint to increase wall thickness ranges or apply multiple welding processes.
- d) Weld bead depth shall not exceed the width at the surface for each individual pass.

CONSUMABLES

- a) Consumables may require special conditioning, storage, and handling prior to and during production to ensure hydrogen status classification is maintained.
- b) See ISO based welding consumable Standards for guides on consumable treatments.

GUIDELINES

- a) The user shall consider design Standard requirements where restrictions may apply in particular to joint design and WPS application.
- b) The user shall consider factors affecting the preheat temperature which may include carbon equivalent value, combined joint thickness, and restraint conditions.
- c) The user requires significant welding knowledge and accepts full responsibility for the performance of welds and for providing the engineering capability, qualified personnel, and suitable equipment to implement ISO 15612 Standard Welding Procedures
- d) The user shall consider applicability or relevance of health and safety regulatory limitations / precautions prior to use.