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BS EN ISO 15614-8:2016



BSI Standards Publication

Specification and qualification of welding procedures for metallic materials — Welding procedure test

Part 8: Welding of tubes to tube-plate joints
(ISO 15614-8:2016)

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This British Standard is the UK implementation of EN ISO 15614-8:2016. It supersedes BS EN ISO 15614-8:2002 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee WEE/36, Qualification of welding personnel and welding procedures.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

© The British Standards Institution 2016. Published by BSI Standards Limited 2016

ISBN 978 0 580 85698 3

ICS 25.160.10

Compliance with a British Standard cannot confer immunity from legal obligations.

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 30 April 2016.

Amendments issued since publication

Date	Text affected
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EUROPÄISCHE NORM

April 2016

ICS 25.160.10

Supersedes EN ISO 15614-8:2002

English Version

Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 8: Welding of tubes to tube-plate joints (ISO 15614-8:2016)

Descriptif et qualification d'un mode opératoire de soudage sur les matériaux métalliques - Épreuve de qualification d'un mode opératoire de soudage - Partie 8: Soudage de tubes sur plaques tubulaires (ISO 15614-8:2016)

Anforderung und Qualifizierung von Schweißverfahren für metallische Werkstoffe - Schweißverfahrensprüfung - Teil 8: Einschweißen von Rohren in Rohrböden (ISO 15614-8:2016)

This European Standard was approved by CEN on 2 January 2016.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

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European foreword

This document (EN ISO 15614-8:2016) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding" the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2016, and conflicting national standards shall be withdrawn at the latest by October 2016.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 15614-8:2002.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this document.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 15614-8:2016 has been approved by CEN as EN ISO 15614-8:2016 without any modification.

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Annex ZA (informative)

Relationship between this European Standard and the Essential Requirements of EU Directive 97/23/EC — Pressure Equipment

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association to provide a means of conforming to Essential Requirements of the New Approach Directive 97/23/EC.

Once this standard is cited in the Official Journal of the European Union under that Directive and has been implemented as a national standard in at least one Member State, compliance with the clauses of this standard given in Table ZA confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding Essential Requirements of that Directive and associated EFTA regulations.

Table ZA — Correspondence between this European Standard and Directive 97/23/EC

Clause(s)/subclause(s) of this EN	Essential Requirements (ERs) of Directive 97/23/EC	Qualifying remarks/Notes
Clauses 5, 6, 7, 8, 9	Annex I, 3.1.2	Permanent joining

WARNING — Other requirements and other EU Directives may be applicable to the product(s) falling within the scope of this part of ISO 15614.

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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).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Quality management in the field of welding*.

This second edition cancels and replaces the first edition (ISO 15614-8:2002), which has been technically revised.

ISO 15614 consists of the following parts, under the general title *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*
- *Part 2: Arc welding of aluminium and its alloys*
- *Part 3: Fusion welding of non-alloyed and low-alloyed cast irons*
- *Part 4: Finishing welding of aluminium castings*
- *Part 5: Arc welding of titanium, zirconium and their alloys*
- *Part 6: Arc and gas welding of copper and its alloys*
- *Part 7: Overlay welding*
- *Part 8: Welding of tubes to tube-plate joints*
- *Part 9: Underwater hyperbaric wet welding*
- *Part 10: Hyperbaric dry welding*
- *Part 11: Electron and laser beam welding*
- *Part 12: Spot, seam and projection welding*
- *Part 13: Upset (resistance butt) and flash welding*

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— *Part 14: Laser-arc hybrid welding of steels, nickel and nickel alloys*

Requests for official interpretations of any aspect of this International Standard should be directed to the Secretariat of ISO/TC 44/SC 10 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

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Introduction

All new welding procedure tests are to be carried out in accordance with this part of ISO 15614 from the date of its issue. However, this part of ISO 15614 does not invalidate previous welding procedure tests made to former national standards or specifications or previous issues of this part of ISO 15614.

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Specification and qualification of welding procedures for metallic materials — Welding procedure test —

Part 8: Welding of tubes to tube-plate joints

1 Scope

This part of ISO 15614 specifies requirements for the qualification testing of welding procedures for the arc welding of tube to tube-plate joints in metallic materials by manual, partly mechanized, fully mechanized, or automatic processes.

This part of ISO 15614 is a part of a series of standards. Details of this series are given in ISO 15607, Annex A.

Qualification by tube to tube-plate joint tests can be used for all joints even if they are fully loaded or only seal welded as required in application standards.

This part of ISO 15614 applies to fusion welding of metallic materials for tube to tube-plate joints with a remaining gap between the tube and the tube-plate for some length of the tube-plate thickness. This part of ISO 15614 does not apply to tube-sheets with forged end connections with welded tubes (external/internal bore welds).

For welding of tube to tube-plate joints with mechanical expansion which is load bearing, welding procedure test is to be defined.

For other applications and/or requirements, this part of ISO 15614 can be used if required by the specification.

Repair welding is to be considered in the welding procedure test.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3452-1, *Non-destructive testing — Penetrant testing — Part 1: General principles*

ISO 4063, *Welding and allied processes — Nomenclature of processes and reference numbers*

ISO 6520-1, *Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 1: Fusion welding*

ISO 9015-1, *Destructive tests on welds in metallic materials — Hardness testing — Part 1: Hardness test on arc welded joints*

ISO 9606-1, *Qualification testing of welders — Fusion welding — Part 1: Steels*

ISO 9606-2, *Qualification test of welders — Fusion welding — Part 2: Aluminium and aluminium alloys*

ISO 9606-3, *Approval testing of welders — Fusion welding — Part 3: Copper and copper alloys*

ISO 9606-4, *Approval testing of welders — Fusion welding — Part 4: Nickel and nickel alloys*