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Second edition  
2019-08

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

## Part 2: Gas welding

*Descriptif et qualification d'un mode opératoire de soudage pour  
les matériaux métalliques — Descriptif d'un mode opératoire de  
soudage —*

*Partie 2: Soudage aux gaz*



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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](http://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](http://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 of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Quality management in the field of welding*.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

Official interpretations of TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

This second edition cancels and replaces the first edition (ISO 15609-2:2001), which has been technically revised.

The main changes compared to the previous edition are as follows:

- [Clause 2](#) has been updated;
- editorial changes have been made;
- surface conditions have been added in [4.4.4](#);
- new Subclauses [4.4.6](#), [4.4.7](#) and [4.4.10](#) have been added;
- Subclause [4.4.11](#) (former [4.4.9](#)) regarding pre-heat temperature has been technically revised;
- [Annex A](#) has been revised.

A list of all parts in the ISO 15609 series can be found on the ISO website.

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## Introduction

All new welding procedure specifications need to be prepared in accordance with this document from the date of its publication. However, this document does not invalidate previous welding procedure specifications made to former standards or specifications, or previous editions of this document.