



International

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**ISO 15613**

**Specification and qualification of  
welding procedures for metallic  
materials — Qualification based on  
a pre-production welding test**

*Descriptif et qualification d'un mode opératoire de soudage  
pour les matériaux métalliques — Qualification sur la base d'un  
assemblage soudé de préproduction*

**Second edition  
2025-08**



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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Quality management in the field of welding*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 15613:2004), which has been technically revised.

The main changes are as follows:

- the normative references have been updated and extensively revised;
- all parts of the document related to the changes in normative references have been updated accordingly;
- Tables have been added to [Clause 4](#) and [5](#) to give the relevant standards for each welding process;
- [Clause 5](#) has been revised to clarify the intent;
- the text of [Clause 7](#) has been revised and refers to the standards in [Table 2](#). All testing information has been deleted to avoid conflict with the relevant parts of the ISO 15614 series;
- the title of [7.2.1](#) has been updated to reflect the title of ISO 15614-12;
- [Clauses 8](#) and [10](#) have been revised.

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

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One of the methods for welding procedure qualification is based on a pre-production welding test as given in ISO 15607.

Qualification based on a pre-production welding test can be used where the shape and dimensions of the standard test pieces do not adequately represent the joint to be welded.

In such cases, one or more special test pieces can be made to simulate the production joint in all essential features, for example dimensions, restraint, heat sink effects and limited access.

This document is one of a number of standards dealing with specification and qualification of welding procedures. Details are given in ISO 15607.