



ISO 15614-11

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

Part 11: Electron and laser beam welding

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

Partie 11: Soudage par faisceau d'électrons et par faisceau laser

Second edition
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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 15614-11:2002), which has been technically revised.

The main changes are as follows:

- normative references updated and ISO 15607 moved to Bibliography;
- acceptance level changed to quality level in accordance with the ISO 13919-1 and ISO 13919-2;
- terminology aligned with that used in other parts of the ISO 15614 series, where appropriate;
- figures updated and corrected, including symbols and keys;
- [Tables 1 to 4](#) revised;
- [6.2](#) reformatted and revised;
- [Clause 7](#) revised.

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All new welding procedure tests are intended to be carried out in accordance with this document. However, this document does not invalidate previous welding procedure tests made to former national standards or specifications or previous editions of this document.

Where additional tests have to be carried out to make a qualification technically equivalent, these should be done on a test piece which is made in accordance with this document.

Specification and qualification of WPSs that were made in accordance with previous editions of this document can be used for any application for which the current edition is specified. In this case, the ranges of qualification of previous editions remain applicable.

It is possible to create a new welding procedure qualification record (WPQR) range of qualification according to this edition based on an existing qualified WPQR, provided the technical intent of the testing requirements of this document have been satisfied.