BS ISO 17927-1:2020

BSI Standards Publication

Welding for aerospace applications — Fusion welding of metallic components

Part 1: Process specification

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National foreword

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The UK participation in its preparation was entrusted to Technical Committee WEE/-/1, Briefing committee for welding.

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

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Part 1: Process specification

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Partie 1: Spécification de processus

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Contents

Page

Foreword ... **v**

1 Scope ... **1**

2 Normative references ... **1**

3 Terms and definitions ... **2**

4 Conformance ... **3**

5 Classification and inspection requirements of joints ... **3**

6 Quality levels ... **4**

7 Weldment design ... **4**

8 Welding procedure specification (WPS) ... **4**
8.1 General ... 4
8.2 WPS qualification/welding procedure qualification record (WPQR) ... 6

9 Fabrication ... **7**
9.1 General ... 7
9.2 Identification and traceability of welding consumables ... 8
9.3 Storage and use ... 8
9.3.1 Filler material ... 8
9.3.2 Welding fluxes ... 8
9.3.3 Gases ... 8
9.4 Welding equipment ... 8
9.4.1 General ... 8
9.4.2 Calibration ... 8
9.5 Weld joint preparation ... 9
9.5.1 Pre-weld joint configuration ... 9
9.5.2 Butt joint members of unequal thickness ... 9
9.6 Pre-weld cleaning and other preparation ... 10
9.6.1 Surface cleaning ... 10
9.6.2 Protection and recleaning of cleaned surfaces before fit-up ... 10
9.7 Preheating and interpass temperature control ... 10
9.8 Tack welds ... 10
9.9 Run-on, run-off tabs and beam stopper ... 11
9.10 Weld shielding ... 11
9.11 Spatter protection ... 11
9.12 Filler materials ... 11
9.13 Interpass cleaning ... 12
9.14 Welding and weldments ... 12
9.14.1 General ... 12
9.14.2 Weld settings ... 12
9.14.3 Arc strike ... 12
9.14.4 In-process correction ... 12
9.14.5 Post-weld processing ... 13
9.15 Weld identification requirements ... 13
9.15.1 Weld traceability ... 13
9.15.2 Acceptance inspection ... 13
9.15.3 Acceptance criteria ... 14
9.16 Rework ... 14
9.16.1 General ... 14
9.16.2 Allowed number of rework attempts ... 14
9.16.3 Root area rework ... 14
9.16.4 Inspection of the rework ... 14
9.16.5 Documentation of rework ... 14
9.17 Repair ... 14

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Full document details: BS ISO 17927-1:2020

9.17.1 General ... 14
9.17.2 Repair instructions ... 14
9.18 Record requirements ... 15
9.19 Welding parameters ... 15
9.20 Reproducibility tests for qualified machine welding settings ... 15
9.20.1 Applicability of requirements ... 15
9.20.2 Test requirements ... 15

10 Personnel ... 15
10.1 Welding coordination personnel ... 15
10.2 Qualification of welders and welding operators ... 15
10.3 Qualification of inspection personnel ... 15
10.3.1 Qualification of non-destructive testing (NDT) personnel ... 15
10.3.2 Visual weld inspectors ... 16

11 Inspection methods ... 16
11.1 Visual weld inspection ... 16
11.2 Non-destructive testing ... 16
11.2.1 General ... 16
11.2.2 Penetrant testing (PT) ... 16
11.2.3 Magnetic particle testing (MT) ... 16
11.2.4 Radiographic testing (RT) ... 17
11.2.5 Ultrasonic testing (UT) ... 17
11.2.6 Other non-destructive test methods ... 17
11.3 Destructive testing ... 17
11.3.1 General ... 17
11.3.2 Tensile testing ... 17
11.3.3 Bend testing ... 17
11.3.4 Hardness testing ... 17
11.3.5 Metallographic examination ... 18

12 Requirements specific to TIG and plasma welding processes ... 18

Annex A (informative) **Welding procedure qualification record (WPQR) ... 19**

Annex B (informative) **Welding procedure specification (WPS) ... 21**

Annex C (informative) **Example for preheat and interpass temperature ... 24**

Bibliography ... 25

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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).

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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.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 14, *Welding and brazing in aerospace*.

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. 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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Welding for aerospace applications — Fusion welding of metallic components —

Part 1:
Process specification

1 Scope

This document specifies the requirements for fusion welding of aerospace hardware. It is to be used in conjunction with the design/engineering authority's design documents or their accepted data.

This document covers the processes given in Table 1 and material groups given in Table 2.

Table 1 — Fusion welding processes covered by this document

Process	Process number (ISO 4063)
Oxyfuel welding	31
Gas-shielded arc welding with non-consumable tungsten electrode, Gas tungsten arc welding	14
Plasma arc welding	15
Electron beam welding	51
Laser welding, Laser beam welding	52

Table 2 — Material groups covered by this document (see ISO 24394:2018, 4.5)

Material group	Description
A	Unalloyed steel, low-alloyed steels, high-alloyed ferritic steels
B	Austenitic, martensitic and precipitation hardening steels
C	Titanium and titanium alloys, niobium, zirconium and other reactive metals
D	Aluminium and magnesium alloys
E	Materials that do not conform to other material groups (e.g. molybdenum, tungsten, copper alloys)
F	Nickel alloys, cobalt alloys.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3452 (all parts), *Non-destructive testing — Penetrant testing*

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

ISO 4136, *Destructive tests on welds in metallic materials — Transverse tensile test*

ISO 5173, *Destructive tests on welds in metallic materials — Bend tests*

ISO 6506-1, *Metallic materials — Brinell hardness test — Part 1: Test method*

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ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*

ISO 6508 (all parts), *Metallic materials — Rockwell hardness test*

ISO 6892 (all parts), *Metallic materials — Tensile testing*

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

ISO 10863, *Non-destructive testing of welds — Ultrasonic testing — Use of time-of-flight diffraction technique (TOFD)*

ISO 13588, *Non-destructive testing of welds — Ultrasonic testing — Use of automated phased array technology*

ISO 17636 (all parts), *Non-destructive testing of welds — Radiographic testing*

ISO 17638, *Non-destructive testing of welds — Magnetic particle testing*

ISO 17640, *Non-destructive testing of welds — Ultrasonic testing — Techniques, testing levels, and assessment*

ISO 17927-2[1)], *Welding for aerospace applications — Fusion welding of metallic components — Part 2: Acceptance criteria*

ISO 19828, *Welding for aerospace applications — Visual inspection of welds*

ISO 24394, *Welding for aerospace applications — Qualification test for welders and welding operators — Fusion welding of metallic components*

ISO/TR 25901-1, *Welding and allied processes — Vocabulary — Part 1: General terms*

EN 4179, *Aerospace series — Qualification and approval of personnel for non-destructive testing*

ASTM E8/E8M, *Test Methods for Tension Testing of Metallic Materials*

ASTM E18, *Test Methods for Rockwell Hardness of Metallic Materials*

ASTM E21, *Standard Test Methods for Elevated Temperature Tension Tests of Metallic Materials*

ASTM E384, *Standard Test Method for Microindentation Hardness of Materials*

ASTM E1417/E1417M, *Standard Practice for Liquid Penetrant Testing*

ASTM E1742/E1742M, *Standard Practice for Radiographic Examination*

ASTM E1444/E1444M, *Standard Practice for Magnetic Particle Testing*

SAE AMS 2644, *Inspection Material, Penetrant*

SAE AMS-STD-2154, *Inspection, Ultrasonic, Wrought Metals, Process for*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO/TR 25901-1 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at http://www.electropedia.org/

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3.1
backgouging
removal of weld metal and base metal from the weld root side of a welded joint to facilitate complete fusion and complete joint penetration upon subsequent welding from that side

3.2
design/engineering authority
organization having the responsibility for the structural integrity or maintenance of airworthiness of the hardware and compliance with all relevant documents

[SOURCE: ISO 24394:2018, 3.8]

3.3
welding procedure specification
WPS
document providing in detail the required variables of the welding procedure to ensure repeatability

3.4
welding procedure qualification record
WPQR
record comprising all necessary data needed for qualification of a preliminary welding procedure specification

3.5
autogenous weld
fusion weld without filler material

4 Conformance

When conformance to this document is claimed, all provisions of this document are to be complied with, except those for provisions that the design/engineering authority specifically exempts.

5 Classification and inspection requirements of joints

For the purposes of this document, three classes of welds are defined. This classification shall be stated in the design documents. If there are no other testing requirements defined by the design/engineering authority, the minimum amount of testing shall be as follows.

— Class I: A welded joint whose failure under operating conditions causes the loss of the aircraft/spacecraft or one of its main components, or constitutes a direct hazard to people.

  Visual and dimensional inspection: 100 % of all welds; penetrant or and magnetic particle testing or any other surface test method: 100 % of all welds; testing of the sub-surface characteristics: 100 % of all welds.

— Class II: A welded joint whose failure causes malfunctions without compromising continued safe flight until the end of the mission.

  Visual and dimensional inspection, 100 % of all welds and penetrant or and magnetic particle testing or any other adequate test method, 100 % of all welds.

— Class III: A welded joint whose failure does not affect the safety and the transport function of the aircraft/spacecraft.

  Visual and dimensional inspection, 100 % of all welds.

For the purpose of series preparation/pre-production or in the case of critical welding operations, it can be necessary, also for classes II and III, to increase the scope of testing beyond that specified here. Likewise, in the course of series production, the scope of testing may be reduced if sufficient evidence of process reliability can be provided.

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