

Quality requirements for fusion welding of metallic materials —

Part 4: Elementary quality requirements

The European Standard EN ISO 3834-4:2005 has the status of a
British Standard

ICS 25.160.01

National foreword

This British Standard is the official English language version of EN ISO 3834-4:2005. It is identical with ISO 3834-4:2005. It supersedes BS EN 729-4:1995 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee WEE/-/1, Briefing committee for welding, which has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible international/European committee any enquiries on the interpretation, or proposals for change, and keep UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

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Summary of pages

This document comprises a front cover, an inside front cover, the EN ISO title page, the EN ISO foreword page, the ISO title page, pages ii to iv, pages 1 to 3 and a back cover.

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English Version

Quality requirements for fusion welding of metallic materials -
Part 4: Elementary quality requirements (ISO 3834-4:2005)

Exigences de qualité en soudage par fusion des matériaux
métalliques - Partie 4: Exigences de qualité élémentaire
(ISO 3834-4:2005)

Qualitätsanforderungen für das Schmelzschweißen von
metallischen Werkstoffen - Teil 4: Elementare
Qualitätsanforderungen (ISO 3834-4:2005)

This European Standard was approved by CEN on 28 October 2005.

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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 Central Secretariat has the same status as the official versions.

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EN ISO 3834-4:2005

Foreword

This document (EN ISO 3834-4:2005) 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of an identical text or by endorsement, at the latest by June 2006, and conflicting national standards shall be withdrawn at the latest by June 2006.

This document supersedes EN 729-4:1994.

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

Endorsement notice

The text of ISO 3834-4:2005 has been approved by CEN as EN ISO 3834-4:2005 without any modifications.

INTERNATIONAL STANDARD

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Quality requirements for fusion welding of metallic materials —

Part 4: Elementary quality requirements

*Exigences de qualité en soudage par fusion des matériaux
métalliques —*

Partie 4: Exigences de qualité élémentaire



Reference number
ISO 3834-4:2005(E)

Contents		Page
Foreword.....		iv
1	Scope	1
2	Normative references	1
3	Terms and definitions.....	1
4	Use of this part of ISO 3834	1
5	Review of requirements and technical review	1
6	Sub-contracting	2
7	Welding personnel.....	2
8	Inspection and testing personnel	2
9	Equipment	2
10	Welding and related activities	3
11	Welding consumables	3
12	Inspection and testing	3
13	Non-conformance and corrective actions.....	3
14	Quality records.....	3

Foreword

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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.

ISO 3834-4 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Unification of requirements in the field of metal welding*.

This second edition cancels and replaces the first edition (ISO 3834-4:1984), which has been technically revised.

ISO 3834 consists of the following parts, under the general title *Quality requirements for fusion welding of metallic materials*:

- *Part 1: Criteria for the selection of the appropriate level of quality requirements*
- *Part 2: Comprehensive quality requirements*
- *Part 3: Standard quality requirements*
- *Part 4: Elementary quality requirements*
- *Part 5: Documents with which it is necessary to conform to claim conformity to the quality requirements of ISO 3834-2, ISO 3834-3 or ISO 3834-4*

NOTE A Technical Report ISO/TR 3834-6, *Quality requirements for fusion welding of metallic materials — Part 6: Guidance on implementing ISO 3834* is being prepared.

Requests for official interpretations of any aspect of this part of ISO 3834 should be directed to the Secretariat of ISO/TC 44/SC 10 via your national standards body, a complete listing which can be found at <http://www.iso.org>.

Quality requirements for fusion welding of metallic materials —

Part 4: Elementary quality requirements

1 Scope

This part of ISO 3834 defines elementary quality requirements for fusion welding of metallic materials both in workshops and at field installation sites.

2 Normative references

The following referenced documents are indispensable for the application 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 3834-1, *Quality requirements for fusion welding of metallic materials — Part 1: Guidelines for the selection of the appropriate level of quality requirements*

ISO 3834-5:2005, *Quality requirements for fusion welding of metallic materials — Part 5: Documents with which it is necessary to conform to claim conformity to the quality requirements of ISO 3834-2, ISO 3834-3 or ISO 3834-4*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 3834-1 apply.

4 Use of this part of ISO 3834

For general information on the use of this part of ISO 3834, ISO 3834-1 shall be used.

In order to fulfil the quality requirements given in this part of ISO 3834, the conformity to relevant documents given in ISO 3834-5 shall be verified.

The requirements contained within this part of ISO 3834 shall be adopted in full.

5 Review of requirements and technical review

The manufacturer shall review the contractual requirements and any other requirements, together with any technical data provided by the purchaser or in-house data when the construction is designed by the manufacturer. The manufacturer shall establish that all information necessary to carry out the manufacturing operations is complete and available prior to the commencement of the work. The manufacturer shall affirm its capability to meet all requirements and shall ensure adequate planning of all quality-related activities.

The review of requirements is carried out by the manufacturer to verify that the work content is within its capability to perform, that sufficient resources are available to achieve delivery schedules and that documentation is clear and unambiguous. The manufacturer shall ensure that any variations between the contract and any previous quotation are identified and the purchaser notified of any programme, cost or engineering changes that may result.

6 Sub-contracting

When a manufacturer intends to use sub-contracted services or activities (e.g. welding, inspection, non-destructive testing), information necessary to meet applicable requirements shall be supplied by the manufacturer to the sub-contractor. The sub-contractor shall provide such records and documentation of his work as may be specified by the manufacturer.

A sub-contractor shall work under the order and responsibility of the manufacturer and shall fully comply with the relevant requirements of this part of ISO 3834. The manufacturer shall ensure that the sub-contractor can comply with the quality requirements as specified.

7 Welding personnel

7.1 General

The manufacturer shall provide sufficient supervision of the welding production in order to assure that the welding is carried out in a manner compatible with good workmanship.

7.2 Welders and welding operators

Welders and welding operators shall be qualified by an appropriate test.

The ISO documents to which it is required to conform to fulfil the quality requirements are specified in ISO 3834-5:2005, Table 1, for arc welding, electron beam welding, laser beam welding and gas welding, and in ISO 3834-5:2005, Table 10, for other fusion welding processes.

8 Inspection and testing personnel

8.1 General

The manufacturer shall carry out all inspection and testing as specified.

8.2 Non-destructive testing personnel

The non-destructive testing personnel shall be qualified. For visual testing, a qualification test may not be required. When a qualification test is not required, competence shall be verified by the manufacturer.

The ISO documents to which it is required to conform to fulfil the quality requirements are specified in ISO 3834-5:2005, Table 3, for arc welding, electron beam welding, laser beam welding and gas welding, and in ISO 3834-5:2005, Table 10, for other fusion welding processes.

9 Equipment

Welding equipment shall be available and maintained in proper working order.

10 Welding and related activities

Welding shall be performed in accordance with an appropriate welding technique.

11 Welding consumables

The manufacturer shall ensure that appropriate welding consumables are stored and used in accordance with the supplier's recommendations.

12 Inspection and testing

The manufacturer shall carry out all inspection and testing as specified.

13 Non-conformance and corrective actions

Measures shall be implemented to control items or activities which do not conform to specified requirements in order to prevent their inadvertent acceptance. Measures shall also be implemented to ensure that conditions adverse to quality of the welded construction are promptly identified and corrected.

14 Quality records

Quality records shall be retained for a minimum period of five years in the absence of any other specified requirements.

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