



SAFETY ASSESSMENT
FEDERATION

Guidance

Welding Procedure and Welder Approval Testing

BS EN ISO 15614-1 2012 / BS EN 287 – 1 2011,
Thickness Approval Range for $t \leq 3\text{mm}$

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SITUATION

There is disparity between the standards BSEN 287-1 & BSEN ISO 15614-1 with regards to approval ranges on thinner materials with a single weld run deposited

BS EN ISO 15614-1 2012: Table 5: "Range of Approval for Thickness", gives a range for a single run weld using material with a thickness less than or equal to 3 mm as $0,7t$ to $1,3t$.

BS EN 287- 1 2011: Table 5: "Materials Range of Approval", gives the range for material with thickness less than or equal to 3 mm as t to $2t$.

What is the technical justification for this?

GUIDANCE

The welder approval standard BSEN 287-1 is focused on the welder's skill and the procedure testing standard BSEN ISO 15614-1 is concerned with metallurgical & mechanical properties of the weld.

This is why there is a different philosophy to approval ranges generally.

Because thinner materials require a different level of skill in relation to thicker sections and the welder has not proven his skill in welding thin materials, additional tests are required to qualify the welder.