

Table of contents

| | |
|--|-----------|
| European Foreword | 6 |
| 1 Scope | 7 |
| 2 Normative references | 8 |
| 3 Terms, definitions and abbreviated terms | 11 |
| 3.1 Terms from other standards..... | 11 |
| 3.2 Terms specific to the present standard | 11 |
| 3.3 Abbreviated terms..... | 15 |
| 3.4 Conventions..... | 16 |
| 3.5 Nomenclature | 16 |
| 3.5.1 Formal verbs | 16 |
| 4 Principles | 18 |
| 4.1 General..... | 18 |
| 4.2 Classification of weld safety classes | 20 |
| 4.2.1 Overview..... | 20 |
| 4.2.2 Safety Class 1..... | 20 |
| 4.2.3 Safety Class 2..... | 20 |
| 4.2.4 Safety Class 3..... | 20 |
| 4.3 Weld sensitivity levels..... | 20 |
| 4.4 Tailoring of the weld acceptance criteria | 20 |
| 5 Welding design | 21 |
| 5.1 Design of Welded Connections..... | 21 |
| 5.2 Acceptable joints design | 21 |
| 6 Welding and inspection personnel | 22 |
| 6.1 Welding supervisor | 22 |
| 6.2 Qualification and certification of welders and welding operators | 22 |
| 6.2.1 Validity limits for operator qualification | 22 |
| 6.2.2 Manual arc welding | 23 |
| 6.2.3 Mechanised fusion and resistance welding | 23 |
| 6.2.4 Mechanised friction stir welding..... | 23 |

| | | |
|-----------|---|-----------|
| 6.3 | Qualification and certification of welding inspectors | 23 |
| 6.4 | Clothing requirements..... | 23 |
| 7 | Equipment and facilities | 25 |
| 7.1 | Qualification of the welding equipment..... | 25 |
| 7.1.1 | General requirements | 25 |
| 7.1.2 | Specific requirements..... | 25 |
| 7.2 | Maintenance and repair of the welding equipment..... | 26 |
| 7.3 | Materials and consumables | 26 |
| 7.3.1 | Base materials | 26 |
| 7.3.2 | Filler materials..... | 27 |
| 7.3.3 | Shielding and backing gas | 27 |
| 7.3.4 | Tooling and fixtures..... | 28 |
| 8 | Welding procedure specification (WPS)..... | 29 |
| 8.1 | Requirements applicable to all processes | 29 |
| 8.1.1 | General..... | 29 |
| 8.1.2 | Drawings..... | 29 |
| 8.1.3 | Welding process | 29 |
| 8.1.4 | Weld preparation..... | 29 |
| 8.1.5 | Cleanliness prior to welding | 30 |
| 8.1.6 | Tack welds..... | 30 |
| 8.1.7 | Backing and shielding gas..... | 30 |
| 9 | Weld inspection | 31 |
| 9.1 | Non-destructive techniques | 31 |
| 9.1.1 | General..... | 31 |
| 9.1.2 | Visual and dimensional examination | 31 |
| 9.1.3 | Penetrant inspection | 34 |
| 9.1.4 | Radiographic testing | 34 |
| 9.1.5 | Ultrasonic inspection..... | 34 |
| 9.1.6 | X-ray tomography inspection (CT scan)..... | 35 |
| 9.2 | Destructive testing | 35 |
| 9.2.1 | Metallographic measurement..... | 35 |
| 9.2.2 | Hardness measurement..... | 36 |
| 9.2.3 | Tensile test | 36 |
| 9.2.4 | Other tests | 36 |
| 10 | Weld acceptance criteria..... | 37 |
| 10.1 | General..... | 37 |

| | | |
|----------------|---|-----------|
| 10.2 | Outer features for fusion welds | 37 |
| 10.3 | Inner features for fusion welds | 43 |
| 10.4 | Features for friction stir welds | 46 |
| 11 | Welding process verification..... | 48 |
| 11.1 | Weld Samples | 48 |
| 11.1.1 | General..... | 48 |
| 11.1.2 | Safety Classes 1 and 2: assessment of weld samples | 48 |
| 11.1.3 | Safety Class 3: assessment of weld samples | 49 |
| 11.2 | Verification acceptance criteria | 49 |
| 11.3 | Delta verification | 49 |
| 11.3.1 | General..... | 49 |
| 11.3.2 | Safety Classes 1 and 2: delta verification..... | 50 |
| 11.3.3 | Safety Class 3: delta verification | 50 |
| 11.4 | Re-weld, in process correction..... | 50 |
| 11.5 | Repair welding..... | 51 |
| 11.6 | Documentation | 51 |
| 12 | Flight hardware production | 53 |
| 12.1 | Documentation | 53 |
| 12.2 | Requirements for flight hardware welding | 53 |
| 12.2.1 | General..... | 53 |
| 12.2.2 | Drawings..... | 54 |
| 12.2.3 | Extent of testing to support flight hardware production | 54 |
| 13 | Quality assurance..... | 56 |
| 13.1 | Maintenance of WPS..... | 56 |
| 13.2 | Quality control..... | 56 |
| 13.2.1 | Reference samples | 56 |
| 13.2.2 | Documentation of weld parameters..... | 57 |
| 13.2.3 | Anomalies and nonconformances occurring during the welding process | 57 |
| 13.2.4 | Inspection and test methods | 57 |
| Annex A | (normative) Welding Procedure Specification (WPS) - DRD | 58 |
| A.1.1 | Requirement identification and source document..... | 58 |
| A.1.2 | Purpose and objective..... | 58 |
| A.2 | Expected response | 58 |
| A.2.1 | Scope and content | 58 |
| A.2.2 | Special remarks | 67 |

| | |
|--|-----------|
| Annex B (normative) Welding Verification Test Plan (WVTP) - DRD | 68 |
| B.1 DRD identification..... | 68 |
| B.1.1 Purpose and scope | 68 |
| B.2 Expected response..... | 68 |
| B.2.1 Scope and content..... | 68 |
| B.2.2 Special remarks | 69 |
| Annex C (informative) Inner defect calculation | 70 |
| Bibliography..... | 71 |

Figures

| | |
|---|----|
| Figure 4-1 Flow chart showing the steps required to produce a verified weld process and flight hardware..... | 19 |
| Figure 9-1: Discoloration of the inside of austenitic stainless steel tubes..... | 33 |

Tables

| | |
|---|----|
| Table 7-1: Acceptable gas purity levels | 27 |
| Table 7-2: Recommended shielding gases for welding..... | 27 |
| Table 9-1: Colour acceptance criteria for titanium fusion welds | 32 |
| Table 9-2: Examples of weld discoloration for titanium fusion welds (for information only)..... | 33 |
| Table 10-1: Outer features for fusion welds | 38 |
| Table 10-2: Inner Features for Fusion Welds..... | 43 |
| Table 10-3: Features for friction stir welds | 46 |
| Table 11-1: Minimum acceptable amount of testing for manual arc welding | 49 |
| Table 11-2: Minimum acceptable amount of testing for all mechanised welding processes class 1 and 2 welds..... | 49 |
| Table 11-3: Minimum acceptable amount of testing for class 1 and 2 welds (all processes) | 50 |
| Table 12-1: Dew point conditions for welding | 54 |
| Table 12-2: Tests to be performed on parts performed during production of flight hardware | 55 |