This is a free page sample. Access the full version online.

National Standards Authority of Ireland

IRISH STANDARD

I.S. EN 13134:2000

ICS 25.160.50

National Standards
Authority of Ireland
Dublin 9
Ireland

Tel: (01) 807 3800
Tel: (01) 807 3838

BRAZING - PROCEDURE APPROVAL

This Irish Standard was published under the authority of the National Standards Authority of Ireland and comes into effect on:

November 2, 2000

NO COPYING WITHOUT NSAI PERMISSION EXCEPT AS PERMITTED BY COPYRIGHT LAW

© NSAI 2000

Price Code G

Údarás um Chaighdeáin Náisiúnta na hÉireann

This is a free page sample. Access the full version online.

This is a free page sample. Access the full version online.

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 13134

August 2000

ICS 25.160.50

English version

Brazing - Procedure approval

Brasage fort - Qualification de mode opératoire de brasage fort

Hartlöten - Hartlötverfahrensprüfung

This European Standard was approved by CEN on 27 July 2000.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

© 2000 CEN All rights of exploitation in any form and by any means reserved worldwide for CEN national Members.

Ref. No. EN 13134:2000 E

This is a free page sample. Access the full version online.

Contents

		Page
Foreword		3
Introduction		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	5
4	Information and requirements to be agreed and to be documented	6
5	Brazing variables	7
6	pBPS	7
7	Approval of BPS	7
8	Test pieces and test specimens	8
9	Examination and testing	8
10	Range of approval	10
11	Brazing procedure approval record (BPAR)	10
Annex A (informative) Guidelines for practical application of brazing procedure approval		11
Annex B (informative) Brazing procedure approval record (BPAR) form - Part 1: Procedure approval certificate		14
Annex C (informative) Brazing procedure approval record (BPAR) form - Part 2: Approved brazing procedure		15
Annex D (informative) Brazing procedure approval record (BPAR) form - Part 3: Test results		16
Annex ZA (informative) Clauses of this European Standard addressing essential requirements or other provisions of EU Directives		17

This is a free page sample. Access the full version online.

Foreword

This European Standard has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS.

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 February 2001, and conflicting national standards shall be withdrawn at the latest by February 2001.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this standard.

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

This is a free page sample. Access the full version online.

Introduction

Approved brazing procedure specifications will frequently, but not always, be needed in order to provide a well defined basis for the planning of brazing operations and for quality control during brazing. Brazing is considered a special process in the terminology of standards for quality systems; such standards usually require that special processes be carried out in accordance with written procedure specifications.

This standard defines the content for the brazing procedure specifications which is considered to fulfil the requirements in current standards for quality systems as regards procedure specifications.

Preparation of a brazing procedure specification records the necessary instructions for evaluation but does not in itself ensure that the resulting brazes fulfil the service requirements. Some deviations can be evaluated by non-destructive methods on the finished product but others, e.g. metallurgical deviations, cannot. This has resulted in the establishment of a set of rules for approval of the brazing procedure prior to the release of the specification to actual production.

Guidelines for the practical application of brazing procedure approval are given in annex A.

Furthermore, this standard allows for brazing procedure approval to be related to previous experience of similar applications. Many manufacturers have considerable experience in fabricating brazed structures. Brazed components and structures may have been supplied for a variety of applications and have performed satisfactorily over a period of time in service. If this experience is traceable and verifiable, this standard provides a route for brazing procedure approval based on this experience.

SAI GLOBAL

This is a free preview. Purchase the entire publication at the link below:

Product Page

Looking for additional Standards? Visit Intertek Inform Infostore

Learn about LexConnect, All Jurisdictions, Standards referenced in Australian legislation