



**NSAI**  
Standards

Irish Standard  
I.S. EN ISO 13919-2:2021

Electron and laser-beam welded joints -  
Requirements and recommendations on  
quality levels for imperfections - Part 2:  
Aluminium, magnesium and their alloys  
and pure copper (ISO 13919-2:2021)

**I.S. EN ISO 13919-2:2021**

*Incorporating amendments/corrigenda/National Annexes issued since publication:*

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NSAI  
1 Swift Square,  
Northwood, Santry  
Dublin 9

T +353 1 807 3800  
F +353 1 807 3838  
E standards@nsai.ie  
W NSAI.ie

Sales:  
T +353 1 857 6730  
F +353 1 857 6729  
W standards.ie

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## National Foreword

I.S. EN ISO 13919-2:2021 is the adopted Irish version of the European Document EN ISO 13919-2:2021, Electron and laser-beam welded joints - Requirements and recommendations on quality levels for imperfections - Part 2: Aluminium, magnesium and their alloys and pure copper (ISO 13919-2:2021)

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**EUROPEAN STANDARD**  
**NORME EUROPÉENNE**  
**EUROPÄISCHE NORM**

**EN ISO 13919-2**

February 2021

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Supersedes EN ISO 13919-2:2001

English Version

**Electron and laser-beam welded joints - Requirements and  
recommendations on quality levels for imperfections - Part  
2: Aluminium, magnesium and their alloys and pure  
copper (ISO 13919-2:2021)**

Assemblages soudés par faisceau d'électrons et par  
faisceau laser - Exigences et recommandations sur les  
niveaux de qualité des défauts - Partie 2: Aluminium,  
magnésium et leurs alliages et cuivre pur (ISO 13919-  
2:2021)

Elektronen- und Laserstrahl-Schweißverbindungen -  
Anforderungen und Empfehlungen für  
Bewertungsgruppen für Unregelmäßigkeiten - Teil 2:  
Aluminium, Magnesium und ihre Legierungen und  
reines Kupfer (ISO 13919-2:2021)

This European Standard was approved by CEN on 9 February 2021.

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 CEN-CENELEC Management Centre 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 CEN-CENELEC Management Centre has the same status as the official versions.

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**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

**EN ISO 13919-2:2021 (E)**

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## **European foreword**

This document (EN ISO 13919-2:2021) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" 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 August 2021, and conflicting national standards shall be withdrawn at the latest by August 2021.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 13919-2:2001.

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

## **Endorsement notice**

The text of ISO 13919-2:2021 has been approved by CEN as EN ISO 13919-2:2021 without any modification.

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# INTERNATIONAL STANDARD

ISO  
13919-2

Second edition  
2021-01

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## Electron and laser-beam welded joints — Requirements and recommendations on quality levels for imperfections —

### Part 2: Aluminium, magnesium and their alloys and pure copper

*Assemblages soudés par faisceau d'électrons et par faisceau laser —  
Exigences et recommandations sur les niveaux de qualité des  
défauts —*

*Partie 2: Aluminium, magnésium et leurs alliages et cuivre pur*



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**ISO 13919-2:2021(E)**



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CH-1214 Vernier, Geneva  
Phone: +41 22 749 01 11  
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Website: [www.iso.org](http://www.iso.org)

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## ISO 13919-2:2021(E)

### 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](http://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](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

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](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Quality management in the field of welding*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 13919-2:2001), which has been technically revised.

The main changes compared to the previous edition are as follows:

- [Clause 2](#) has been updated;
- reference to ISO 6520-1 has been added to bring the document in line with ISO 5817.

A list of all parts in the ISO 13919 series can be found on the ISO website.

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](http://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>.

## Introduction

This document is intended to be used as a reference in drafting application codes and/or other application standards. It contains a simplified selection of laser and electron beam welding imperfections based on the designations given in ISO 6520-1.

Some imperfections described in ISO 6520-1 have been used directly and some have been grouped together. The basic numerical referencing system from ISO 6520-1 has been used.

The purpose of this document is to define the dimensions of typical imperfections which can be expected in normal fabrication. It can be used within a quality system for the production of welded joints. It provides three sets of dimensional values from which a selection can be made for a particular application. The quality level necessary in each case is defined by the application standard or the responsible designer in conjunction with the manufacturer, user and/or other parties concerned. The quality level is expected to be prescribed prior to the start of production, preferably at the enquiry or order stage. For special purposes, additional details can be prescribed.

The quality levels given in this document provide basic reference data and are not specifically related to any particular application. They refer to the types of welded joint in fabrication and not to the complete product or component itself. Therefore, it is possible that different quality levels are applied to individual welded joints in the same product or component.

It would normally be expected that, for a particular welded joint, the dimensional limits for imperfections can all be covered by specifying one quality level. In some cases, it can be necessary to specify different quality levels for different imperfections in the same welded joint.

The choice of quality level for any application is expected to take account of design considerations, subsequent processing (e.g. surfacing), mode of stressing (e.g. static, dynamic), service conditions (e.g. temperature, environment) and consequences of failure. Economic factors are also important and are intended to include not only the cost of welding, but also of inspection, test and repair.

Although this document includes types of imperfection relevant to the beam welding processes given in the Scope, only those which are applicable to the process and application in question need to be considered.

Imperfections are quoted in terms of their actual dimensions, and their detection and evaluation can require the use of one or more methods of non-destructive testing. The detection and sizing of imperfections are dependent on the inspection methods and the extent of testing specified in the application standard or contract.

This document does not address the methods used for the detection of imperfections.

The values given for imperfections are for welds produced using normal welding practice. More stringent requirements as stated in quality level B can include additional manufacturing processes, e.g. grinding, dressing.



# Electron and laser-beam welded joints — Requirements and recommendations on quality levels for imperfections —

## Part 2:

## Aluminium, magnesium and their alloys and pure copper

### 1 Scope

This document gives guidance on levels of imperfections in electron and laser beam welded joints in aluminium, magnesium and their alloys and pure copper. Three levels are given in such a way as to permit application for a wide range of welded fabrications. The levels refer to production quality and not to the fitness-for-purpose of the product manufactured.

This document applies to electron and laser beam welding of:

- aluminium and its alloys;
- magnesium and its alloys;
- pure copper (e.g. Cu-ETP1 CW003A, Cu-ETP CW004A, Cu-FRHC CW005A, Cu-FRTP CW006A, Cu-OF1 CW007A, Cu-OF CW008A, Cu-OFE CW009A, Cu-PHC CW020A, Cu-HCP CW021A, Cu-PHCE CW022A, Cu-DLP CW023A, Cu-DHP CW024A);
- all types of welds welded with or without additional filler wire;
- materials equal to or above 0,5 mm thickness for electron and laser beam welding.

When significant deviations from the joint geometries and dimensions stated in this document are present in the welded product, it is necessary to evaluate to what extent the provisions of this document can apply.

NOTE For circular welds, a lower quality level can be specified for the fade-out zone.

Metallurgical aspects, e.g. grain size, hardness, hydrogen embrittlement (pure copper) are not covered by this document.

This document is directly applicable to visual examination of welds and does not include details of recommended methods of detection or sizing by other non-destructive means. There are difficulties in using these limits to establish appropriate criteria applicable to non-destructive testing methods, such as ultrasonic, radiographic and penetrant testing, and they can need to be supplemented by requirements for inspection, examination and testing.

### 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 10042, *Welding — Arc-welded joints in aluminium and its alloys — Quality levels for imperfections*

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