



NSAI
Standards

Irish Standard
I.S. EN ISO 9692-2:1998

Welding and allied processes - Joint preparation - Part 2: Submerged arc welding of steels (ISO 9692-2:1998)

I.S. EN ISO 9692-2:1998

Incorporating amendments/corrigenda issued since publication:

EN ISO 9692-2:1998/AC:1999

The National Standards Authority of Ireland (NSAI) produces the following categories of formal documents:

I.S. xxx: Irish Standard – national specification based on the consensus of an expert panel and subject to public consultation.

S.R. xxx: Standard Recommendation - recommendation based on the consensus of an expert panel and subject to public consultation.

SWiFT xxx: A rapidly developed recommendatory document based on the consensus of the participants of an NSAI workshop.

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EN ISO 9692-2:1998

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Údarás um Chaighdeáin Náisiúnta na hÉireann

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

I.S. EN ISO 9692-2:1998

EN ISO 9692-2:1998/AC

July 1999
Juillet 1999
Juli 1999

English version
Version Française
Deutsche Fassung

Welding and allied processes - Joint preparation - Part 2: Submerged arc
welding of steels (ISO 9692-2:1998)

Soudage et techniques connexes -
Préparation de joints - Partie 2: Soudage à
l'arc sous flux en poudre des aciers (ISO
9692-2:1998)

Schweißen und verwandte Verfahren -
Schweißnahtvorbereitung - Teil 2:
Unterpulverschweißen von Stahl (ISO
9692-2:1998)

This corrigendum becomes effective on 14 July 1999 for incorporation in the three official language versions of the EN.

Ce corrigendum prendra effet le 14 juillet 1999 pour incorporation dans les trois versions linguistiques officielles de l'EN.

Die Berichtigung tritt am 14. Juli 1999 zur Einarbeitung in die drei offiziellen Sprachfassungen der EN in Kraft.



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

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

I.S. EN ISO 9692-2:1998

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EN ISO 9692-2:1998/AC:1999

In the English version :

In the foreword, in the first paragraph, the text should read :

“The text of the International standard ISO 9692-2:1998 has been prepared by...”

In the German version :

In the foreword, the third paragraph should be deleted.

In the English, French and German versions, the following text should be added after the second paragraph :

English version :

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association. This European Standard is considered to be a supporting standard to those application and product standards which in themselves support an essential safety requirement of a New Approach Directive and which make reference to this European Standard.

French version :

La présente Norme Européenne a été élaborée dans le cadre d'un mandat donné au CEN par la Commission Européenne et l'Association Européenne de Libre Echange. Cette Norme Européenne est considérée comme une norme de support pour d'autres normes d'application ou de produit qui viennent elles-mêmes à l'appui d'une exigence essentielle de sécurité d'une directive Nouvelle Approche, et qui citeront cette Norme Européenne en référence normative.

German version :

Diese Europäische Norm wurde im Rahmen eines Mandates, das dem CEN von der Europäischen Kommission und der Europäischen Freihandelszone erteilt wurde, erarbeitet. Diese Europäische Norm wird als eine unterstützende Norm zu anderen Anwendungs- und Produktnormen betrachtet, die selbst eine grundlegende Sicherheitsanforderung einer Richtlinie der Neuen Konzeption unterstützen und auf die vorliegende Europäische Norm normativ verweisen.

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

I.S. EN ISO 9692-2:1998

EN ISO 9692-2

April 1998

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Descriptors: see ISO document

English version

Welding and allied processes - Joint preparation - Part 2:
Submerged arc welding of steels (ISO 9692-2:1998)

Soudage et techniques connexes - Préparation de joints -
Partie 2: Soudage à l'arc sous flux en poudre des aciers
(ISO 9692-2:1998)

Schweißen und verwandte Verfahren -
Schweißnahtvorbereitung - Teil 2: Unterpulverschweißen
von Stahl (ISO 9692-2:1998)

This European Standard was approved by CEN on 26 January 1998.

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

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EN ISO 9692-2:1998

Corrected 98-08-06

Foreword

The text of the International Standard ISO 2503:1998 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 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 month of October 1998, and conflicting national standards shall be withdrawn at the latest by October 1998.

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.

Endorsement notice

The text of the International Standard ISO 9692-2:1998 has been approved by CEN as a European Standard without any modification.

NOTE: Normative references to International Standards are listed in annex ZA (normative).

Annex ZA (normative)**Normative references to international publications
with their relevant European publications**

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN</u>	<u>Year</u>
ISO 2553	1992	Welded, brazed and soldered joints - Symbolic representation on drawings	EN 22553	1994
ISO 6947	1990	Welds - Working positions - Definitions of angles of slope and rotation	EN ISO 6947	1997

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I.S. EN ISO 9692-2:1998
**INTERNATIONAL
STANDARD**

**ISO
9692-2**

First edition
1998-04-01

**Welding and allied processes — Joint
preparation —**

Part 2:
Submerged arc welding of steels

*Soudage et techniques connexes — Préparation de joints —
Partie 2: Soudage à l'arc sous flux en poudre des aciers*



Reference number
ISO 9692-2:1998(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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 9692-2 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 7, *Representation and terms*.

ISO 9692 consists of the following parts, under the general title *Welding and allied processes — Joint preparation*.

- *Part 1: Metal arc welding of steel with covered electrode (currently ISO 9692:1992)*
- *Part 2: Submerged arc welding of steels*
- *Part 3: Manual welding of aluminium and its alloys*

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Introduction

The intention of this International Standard is to use it as an addition to ISO 9692:1992 (which is to become ISO 9692-1, see Foreword) *Metal-arc welding with covered electrode, gas-shielded metal-arc welding and gas welding — Joint preparations for steel*. It follows similar rules and the same layout. Therefore, the introduction given in ISO 9692 also applies.

I.S. EN ISO 9692-2:1998

Welding and allied processes — Joint preparation —

Part 2:

Submerged arc welding of steels

1 Scope

This part of ISO 9692 applies to types of joint preparation for submerged arc welding with one wire electrode (process 121 according to ISO 4063) on steel.

This part of ISO 9692 covers only the welding positions PA and PB according to ISO 6947. In case PC is used, special preparation will be necessary.

It applies to fully penetrated welds. For partly penetrated welds, types of joint preparation, shapes and dimensions may differ from the listed proposals if they are specified in the relevant application standard or agreed by parties concerned.

If the root is welded by a different arc welding process (see ISO 4063), the joint preparation according to ISO 9692 should be taken into account.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards listed below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 2553 : 1992, *Welded, brazed and soldered joints — Symbolic representation on drawings*.

ISO 3834-1 : 1994, *Quality requirements for welding — Fusion welding of metallic materials — Part 1: Guidelines for selection and use*.

ISO 3834-2 : 1994, *Quality requirements for welding — Fusion welding of metallic materials — Part 2: Comprehensive quality requirements*.

ISO 3834-3 : 1994, *Quality requirements for welding — Fusion welding of metallic materials — Part 3: Standards quality requirements*.

ISO 3834-4 : 1994, *Quality requirements for welding — Fusion welding of metallic materials — Part 4: Elementary quality requirements*.

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