

Template for comments and secretariat observations

Date: 2016-03-20	Document: ISO/CD 15612:2016	Project:
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MB/ NC ¹	Line number	Clause/ Subclause	Paragraph/ Figure/ Table/	Type of comment ²	Comments	Proposed change	Observations of the secretariat
SE		Title		te	If the concept of ISO 15607 is not retained “qualification” shall not be a part of the title.	Delete “qualification”	
SE		Foreword		te	Clarify what shall apply for WPS based on the previous edition ISO 15612: 2004	Amend: “Previous issued WPS’s qualified according to ISO 15612:2004 are still valid ...”	
SE				ge	The concept in the present draft does not reflect the overall concept in the general standard ISO 15607. ISO 15607 describes the steps in welding procedure qualification being pWPS => WPQR => WPS. This is a technical sound concept. If this is not addressed Sweden cannot support the draft for publication See also SE comment on the Introduction.	Amend the draft to reflect the concept in ISO 15607, or retain the present ISO 15612 in full and put the new draft outside the qualification of welding procedures with another designation.	
SE		Introduction		te	Reference to ISO 15607 in the introduction. The concept described in ISO 15607 is based on the manufacturer being able to describe the welding in a (1) pWPS, to be validated with a record of qualification (2) WPQR, which by that gives means to qualify an instruction to the welder as a (3) WPS. If this concept of ISO 15607 is not retained the standard shall not address qualification, and shall not be a part of the series of standard under ISO 15607.	Change/amend the concept according to the requirements in ISO 15607 Re-designate and move the standard out of the system.	
SE		Introduction			Confusion concerning Manufacturer/User and Published/Issued	Amend to clarify	
SE		1		te	The scope shall contain the purpose of the standard, and put the standard in the perspective of the other standards in the same series.	Amend “This international standard specifies how the manufacturer qualifies welding procedures based on welding procedure tests performed by another organisation. This standard specifies one of the routes of welding procedure qualification	

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						described in ISO 15607.” Delete “permits” and amend “specify”	
SE		1		ed	2 nd indent is incomprehensible.	Amend to “... specifies the range of application of welding procedures qualified according to this standard”	
SE		3.1		te	Organization does not need to be restricted. The attempt to describe adds to the confusion. It is not appropriate to address the noted organizations as typical.	Delete note to entry	
SE		3.1		te	The organisation is responsible for the qualification of the WPQR, not the WPS. The manufacturer is always(!) responsible for the instruction to the welder.	Retain the standard welding procedure being the WPQR.	
SE		3.2		te	The manufacturer is unambiguous in welding procedure qualification. Do not introduce new term.	Delete user. Retain manufacturer.	
SE		3.2		te	The “user” (the manufacturer) shall have the possibility to qualify a SWPS based on a WPQR from another organisation.	Amend. “The manufacturer can retain the SWPS from another organisation or qualify the SWPS based on a WPQR from another organisation”	
SE		3.3		te	The SWPS in the concept described in the draft is not qualified.	If the concept of ISO 15607 is not retained in the draft, delete “qualified and” in 3.3.	
SE		4.1	1 st para	te	SWPS shall be based on only a WPQR.	Delete “or more”	
SE		4.1	Last bullet		Not relevant to state testing in the production in a SWPS	Delete non-destructive testing	
SE		4.1		te	The examiner or examining body is responsible for the qualification. Examiner is the one "assigned to verify conformance to the applied standard". Note! One examiner when ISO 15614 is applied and one examiner when ISO 15612 is applied. Could be, but not normally the same examiner. Note!!! Every time “examiner” is mentioned in ISO	Amend “In case the manufacturer qualify the SWPS on the basis of a WPQR from another organisation the examiner shall verify that the WPQR is applicable and cover the pWPS to be qualified to a SWPS”	

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					15612 it refers to the one assigned to verify conformance to ISO 15612.		
SE		4.2		te	In all other standards we are addressing ranges, what is allowed, not limitations. Why is the concept of limitations introduced?	Retain the use of range. Change to state what is allowed. Amend clause title to Qualification of a standard welding procedure specification	
SE		4.2.1		te	Why limit the thickness of the tie has been qualified acc. ISO 15614	Delete 4.2.1	
SE		4.2.2		te	The power source manufacturer shall not be limited.	Delete "Only the power source manufacturer" and start the sentence with "The waveform"	
SE		4.2.2		te	The limitation to power source make is more stringent than for procedure test. On the other hand the draft does not give the range of application concerning heat input. The use of any power source is applicable as long as the range of the heat input is not exceeded.	Amend that "... any power source is applicable as long as the range of the heat input is not exceeded."	
SE		5.1		te	Control of production with qualified procedures but without welding coordination <u>is not acceptable</u> . Welder qualification does not in any way replace welding coordination.	Delete the option to not applying welding coordination using qualified welding procedures.	
SE		5.2.2		te	It is not relevant that a welder or welding operator verifies the qualification of a welding procedure. What is the reason (or added value to the quality control) that one of the welders have the SWPS referenced in the certificate?	Delete 5.2.2	
SE		6		te	How will the information reach the user? What would be the technical reason for the organisation to withdraw the SWPS? What if the organisation goes bankrupt? Is there a technical reason to give the organisation the power to withdraw the SWPS? There are obvious financial reasons for the "organization" to put pressure on the "user". The manufacturer should at least be guaranteed a time period for the application of the SWPS.	Delete clause 6.	

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SE		7	1 st para, last sentence	te	The WPQR on which the SWPS is based on <u>shall be available for the manufacturer</u> ("user"). A certification body will not approve the use of a WPS in production is the WPQR is not available in full. There are also information that could be necessary for the manufacturer to use.	Amend "... for the user."	
SE		7		te	The manufacturer shall be stated on the WPS and hence take full responsibility for the use of the WPS in production.	Amend "The name of the manufacturer that use the SWPS in production shall be stated as manufacturer in the SWPS and take full responsibility for its use."	
SE		7		te	The SWPS shall be in the format of, and qualified by a WPQR according to, an ISO standard.	Amend "The SWPS according to this standard shall be qualified based on a WPQR (according to ISO 15613 or 15614) and be in the format determined by ISO 15609"	

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