

Standards ISO 25239

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Friction Stir Welding – Aluminium, 5 parts:

- FSW vocabulary
- Design of joints
- Qualification of operators
- Specification of welding procedures
- Quality inspection requirements

- **Final published version**
- **Sapa Technology have been involved in development work**

- **Defines important terminology (in english, french and german)**
- **Possible to use independent of material**

- **Definition of different type of joints:**
 - Butt joint**
 - Lap joint**
 - T-joint**
 - etc..**

- **Replaces EN 1418 Welding operators**
- **Extent of testing**
- **Knowledge**
- **Example of test certificate**

- **Replaces ISO 15614-2**
- **Length/size of test specimens and welds**
- **Extent of testing**
- **Minimum requirements:**
 - **Bend testing**
 - **Tensile strength**
 - **etc...**
- **Qualification range**
- **Example of pWPS**

”More general” requirements for production

- **Personnel (both qualified operators and personal for testing)**
- **Machine maintenance**
- **Validity of WPS (rules for redoing WPS if big changes performed)**
- **References how to test**
- **Annex A quantified Imperfections and acceptance levels.**