

---

---

**Quality requirements for fusion welding  
of metallic materials —**

**Part 4:  
Elementary quality requirements**

*Exigences de qualité en soudage par fusion des matériaux  
métalliques —*

*Partie 4: Exigences de qualité élémentaire*



**PDF disclaimer**

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

© ISO 2005

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Case postale 56 • CH-1211 Geneva 20  
Tel. + 41 22 749 01 11  
Fax + 41 22 749 09 47  
E-mail [copyright@iso.org](mailto:copyright@iso.org)  
Web [www.iso.org](http://www.iso.org)

Published in Switzerland

**Contents**

Page

<b>Foreword</b> .....	<b>iv</b>
<b>1 Scope</b> .....	<b>1</b>
<b>2 Normative references</b> .....	<b>1</b>
<b>3 Terms and definitions</b> .....	<b>1</b>
<b>4 Use of this part of ISO 3834</b> .....	<b>1</b>
<b>5 Review of requirements and technical review</b> .....	<b>1</b>
<b>6 Sub-contracting</b> .....	<b>2</b>
<b>7 Welding personnel</b> .....	<b>2</b>
<b>8 Inspection and testing personnel</b> .....	<b>2</b>
<b>9 Equipment</b> .....	<b>2</b>
<b>10 Welding and related activities</b> .....	<b>3</b>
<b>11 Welding consumables</b> .....	<b>3</b>
<b>12 Inspection and testing</b> .....	<b>3</b>
<b>13 Non-conformance and corrective actions</b> .....	<b>3</b>
<b>14 Quality records</b> .....	<b>3</b>

## 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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. 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.

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.

ISO 3834-4 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Unification of requirements in the field of metal welding*.

This second edition cancels and replaces the first edition (ISO 3834-4:1984), which has been technically revised.

ISO 3834 consists of the following parts, under the general title *Quality requirements for fusion welding of metallic materials*:

- *Part 1: Criteria for the selection of the appropriate level of quality requirements*
- *Part 2: Comprehensive quality requirements*
- *Part 3: Standard quality requirements*
- *Part 4: Elementary quality requirements*
- *Part 5: Documents with which it is necessary to conform to claim conformity to the quality requirements of ISO 3834-2, ISO 3834-3 or ISO 3834-4*

NOTE A Technical Report ISO/TR 3834-6, *Quality requirements for fusion welding of metallic materials — Part 6: Guidance on implementing ISO 3834* is being prepared.

Requests for official interpretations of any aspect of this part of ISO 3834 should be directed to the Secretariat of ISO/TC 44/SC 10 via your national standards body, a complete listing which can be found at <http://www.iso.org>.

# Quality requirements for fusion welding of metallic materials —

## Part 4: Elementary quality requirements

### 1 Scope

This part of ISO 3834 defines elementary quality requirements for fusion welding of metallic materials both in workshops and at field installation sites.

### 2 Normative references

The following referenced documents are indispensable for the application 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 3834-1, *Quality requirements for fusion welding of metallic materials — Part 1: Guidelines for the selection of the appropriate level of quality requirements*

ISO 3834-5:2005, *Quality requirements for fusion welding of metallic materials — Part 5: Documents with which it is necessary to conform to claim conformity to the quality requirements of ISO 3834-2, ISO 3834-3 or ISO 3834-4*

### 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 3834-1 apply.

### 4 Use of this part of ISO 3834

For general information on the use of this part of ISO 3834, ISO 3834-1 shall be used.

In order to fulfil the quality requirements given in this part of ISO 3834, the conformity to relevant documents given in ISO 3834-5 shall be verified.

The requirements contained within this part of ISO 3834 shall be adopted in full.

### 5 Review of requirements and technical review

The manufacturer shall review the contractual requirements and any other requirements, together with any technical data provided by the purchaser or in-house data when the construction is designed by the manufacturer. The manufacturer shall establish that all information necessary to carry out the manufacturing operations is complete and available prior to the commencement of the work. The manufacturer shall affirm its capability to meet all requirements and shall ensure adequate planning of all quality-related activities.

The review of requirements is carried out by the manufacturer to verify that the work content is within its capability to perform, that sufficient resources are available to achieve delivery schedules and that documentation is clear and unambiguous. The manufacturer shall ensure that any variations between the contract and any previous quotation are identified and the purchaser notified of any programme, cost or engineering changes that may result.

## **6 Sub-contracting**

When a manufacturer intends to use sub-contracted services or activities (e.g. welding, inspection, non-destructive testing), information necessary to meet applicable requirements shall be supplied by the manufacturer to the sub-contractor. The sub-contractor shall provide such records and documentation of his work as may be specified by the manufacturer.

A sub-contractor shall work under the order and responsibility of the manufacturer and shall fully comply with the relevant requirements of this part of ISO 3834. The manufacturer shall ensure that the sub-contractor can comply with the quality requirements as specified.

## **7 Welding personnel**

### **7.1 General**

The manufacturer shall provide sufficient supervision of the welding production in order to assure that the welding is carried out in a manner compatible with good workmanship.

### **7.2 Welders and welding operators**

Welders and welding operators shall be qualified by an appropriate test.

The ISO documents to which it is required to conform to fulfil the quality requirements are specified in ISO 3834-5:2005, Table 1, for arc welding, electron beam welding, laser beam welding and gas welding, and in ISO 3834-5:2005, Table 10, for other fusion welding processes.

## **8 Inspection and testing personnel**

### **8.1 General**

The manufacturer shall carry out all inspection and testing as specified.

### **8.2 Non-destructive testing personnel**

The non-destructive testing personnel shall be qualified. For visual testing, a qualification test may not be required. When a qualification test is not required, competence shall be verified by the manufacturer.

The ISO documents to which it is required to conform to fulfil the quality requirements are specified in ISO 3834-5:2005, Table 3, for arc welding, electron beam welding, laser beam welding and gas welding, and in ISO 3834-5:2005, Table 10, for other fusion welding processes.

## **9 Equipment**

Welding equipment shall be available and maintained in proper working order.

## **10 Welding and related activities**

Welding shall be performed in accordance with an appropriate welding technique.

## **11 Welding consumables**

The manufacturer shall ensure that appropriate welding consumables are stored and used in accordance with the supplier's recommendations.

## **12 Inspection and testing**

The manufacturer shall carry out all inspection and testing as specified.

## **13 Non-conformance and corrective actions**

Measures shall be implemented to control items or activities which do not conform to specified requirements in order to prevent their inadvertent acceptance. Measures shall also be implemented to ensure that conditions adverse to quality of the welded construction are promptly identified and corrected.

## **14 Quality records**

Quality records shall be retained for a minimum period of five years in the absence of any other specified requirements.

