

AWS B2.2/B2.2M:2016
An American National Standard

Specification for Brazing Procedure and Performance Qualification



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An American National Standard

Approved by the
American National Standards Institute
August 5, 2016

Specification for Brazing Procedure and Performance Qualification

4th Edition

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Prepared by the
American Welding Society (AWS) B2 Committee on Procedure and Performance Qualification

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This specification provides the requirements for qualification of brazing procedure specifications, brazers, and brazing operators for manual, mechanized, and automatic brazing. The brazing processes included are torch brazing, furnace brazing, diffusion brazing, resistance brazing, dip brazing, infrared brazing, and induction brazing. Base metals, brazing filler metals, brazing fluxes, brazing atmospheres, and brazing joint clearances are also included.



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Foreword

This foreword is not part of this standard but is included for informational purposes only.

This specification originated in the B2A Subcommittee on Brazing Qualification. The B2A Subcommittee was formed in the early 1980s in order to explicitly address the unique requirements of brazing procedure and brazing performance qualification outside the spectrum of B2.1/B2.1M, *Specification for Welding Procedure and Performance Qualification*.

This is the fourth edition of AWS B2.2/B2.2M, *Specification for Brazing Procedure and Performance Qualification*. AWS B2.2/B2.2M was first published in 1985. AWS B2.2-85, *Standard for Brazing Procedure and Performance Qualification*, was revised in 1991 and 2010.

The welding terms used in this specification shall be interpreted in accordance with the definitions given in the latest edition of AWS A3.0M/A3.0, *Standard Welding Terms and Definitions, Including Terms for Adhesive Bonding, Brazing, Soldering, Thermal Cutting, and Thermal Spraying*. The application of brazing symbols shall conform to the requirements of AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Examination*.

A vertical line in the margin or underlined text in clauses, tables, or figures indicates an editorial or technical change from the 2010 edition.

Comments and suggestions for the improvement of this standard are welcome. They should be sent to the Secretary, AWS B2 Committee on Procedure and Performance Qualification, American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

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