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**Welding for aerospace applications —  
Qualification test for welders and  
welding operators — Fusion welding  
of metallic components**

*Soudage pour applications aérospatiales — Épreuve de  
qualification pour soudeurs et opérateurs — Soudage par fusion des  
composants métalliques*



Reference number  
ISO 24394:2018(E)



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# Contents

Page

<b>Foreword</b>	<b>v</b>
<b>Introduction</b>	<b>vii</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 Qualification test requirements</b>	<b>3</b>
4.1 General	3
4.1.1 Specific to the welder qualification test	3
4.1.2 Specific to the welding operator qualification test	3
4.2 Welding processes	4
4.3 Welding positions	4
4.4 Product types/semi-finished products applicable to welder qualification tests	5
4.5 Material groups	12
4.6 Material thickness	13
4.6.1 Butt weld material thickness	13
4.6.2 Fillet weld material thickness	13
4.6.3 Casting repair material thickness	13
4.7 Special qualification tests	13
4.7.1 General requirements	13
4.7.2 Special qualification tests for welders	13
4.7.3 Special qualification tests for welding operators	14
4.8 Designation for qualification test	14
4.8.1 Welder qualification test	14
4.8.2 Welding operator qualification test	15
<b>5 Conditions required for welder and welding operator qualification tests</b>	<b>15</b>
5.1 Physical requirements for welder and welding operator	15
5.2 Person responsible for welder and welding operator qualification tests	16
<b>6 Performing the welder and welding operator qualification test</b>	<b>16</b>
6.1 Practical qualification test	16
6.1.1 General requirements	16
6.1.2 Specific requirements for the welder qualification test	16
6.2 Theory test	17
<b>7 Test pieces</b>	<b>17</b>
<b>8 Examination and testing</b>	<b>20</b>
8.1 General	20
8.2 Visual and dimensional examination	21
8.3 Surface imperfection detection	21
8.4 Radiographic examination	21
8.5 Metallographic examinations	22
8.6 Bend test	22
8.7 Fracture surface examination	22
<b>9 Acceptance criteria</b>	<b>22</b>
<b>10 Qualification test certificate and documentation</b>	<b>22</b>
<b>11 Period of validity of the qualification</b>	<b>23</b>
<b>12 Requalification test</b>	<b>23</b>
<b>Annex A (normative) Test piece acceptance criteria</b>	<b>24</b>
<b>Annex B (normative) Welder/welding operator qualification test record according to ISO 24394</b>	<b>31</b>

<b>Annex C (informative) Welder qualification test certificate .....</b>	<b>32</b>
<b>Annex D (informative) Welding operator qualification test certificate .....</b>	<b>33</b>
<b>Annex E (informative) Guidelines for the theory test .....</b>	<b>35</b>
<b>Bibliography .....</b>	<b>39</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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 14, *Welding and brazing in aerospace*.

Any feedback, question or request for official interpretation related to any aspect of this document should be directed to the Secretariat of ISO/TC 44/SC 14 via your national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html). Official interpretations, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

This second edition cancels and replaces the first edition (ISO 24394:2008). It also incorporates the Amendment ISO 24394:2008/Amd 1:2012. The main changes compared to the previous edition are:

- the terms welding equipment operator and automatic welding have been introduced as [3.4](#) and [3.12](#);
- old subclause 4.1.3 has been moved to [4.1](#);
- requirements in [4.4](#) have been refined;
- Tables 1 to 4 have been created to present the ranges of qualification for welding positions for every test piece;
- in [4.5](#), material group F has been introduced;
- the header of [4.6](#) has been changed and new subclause [4.6.3](#) has been created;
- in [4.6.1](#) and [4.6.2](#), the qualification of thickness ranges has been clarified;
- requirements in [5.1](#) have been changed;
- a bullet list has been added to [6.1.1](#);
- in [6.2](#), a new requirement has been introduced that the theory test shall be documented;
- references to EN 462 series for radiographic images have been deleted;

- [Clause 9](#) has been reworded to clearly state that only the features created by welding shall be assessed for TP6;
- [Clause 10](#) has been changed so that if a welder/welding operator needs vision correction, it shall be noted on the test certificate;
- in Tables A.1 to A.4, new material group F has been included;
- the document has been editorially revised.