

This Help Guide is for general reference ONLY and all standards should be checked for issue and validation before commencing on any qualification processes.

Orbital Service UK Ltd can not be held responsible for any errors made following this guidance.

BS EN ISO #				
Standard	Main Aim	Description	Comments	Who
1011-3:2018	Setting Up Qualification	Welding - Recommendations for weld of metallic materials	This standard sets out the requirements that a company/welding section should adhere to if they want weld testing to run smoothly.	Customer/Company
15614-1:2017	WPS Qualification	Specification and qualification of welding procedures for metallic materials - welding procedure test arc welding of nickel and nickel alloys	The welder/welding engineer/Quality engineer have to create a WPS that is up to the 15614 standard. (Example template within standard). When the welder uses this WPS to do his weld test (14732) the WPS becomes a WPQR - Welding procedure quality record form. Outside Qualified Weld Inspector to witness welding of samples To be tested.	Customer/Company with help from Orbital Service UK Ltd
15614-5:2024	WPS Qualification	Welding of titanium & zirconium and their alloys	As above.	As above.
15614-8:2016	WPS Qualification	Welding of Tubes to tube-plate joints	As above.	As above.
14732:2013	Operator Qualification	Welding personnel - Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials	Qualification is based on the WPS in accordance with the relevant section in BS EN ISO15614:2017. Sample test pieces are welded in front of an outside examining body. Sample test pieces are then taken away with a copy of the WPS & the weld program used log file.	Customer/Companies Welder/Operator. Orbital Service UK Ltd can be present for this test, if required.
5817:2014	Samples Qualification	Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections	The outside examiner tests the samples in accordance with this standard. If samples pass, then the WPS (which has to include the weld program details) becomes a WPQR and the welder/operator receives their BS EN ISO14732:2013 certification for that part. Certificate has to be confirmed every 6 months by welding engineer or outside examining body. Operator has to be re-tested by outside examining body every 6 years.	Outside Qualified Weld Inspector to witness welding of samples To be tested.