
**Brazing for aerospace applications —
Qualification test for brazers and
brazing operators — Brazing of
metallic components**

*Brasage fort pour applications aérospatiales — Épreuve de
qualification des braseurs et des opérateurs braseurs — Brasage fort
des composants métalliques*





COPYRIGHT PROTECTED DOCUMENT

© ISO 2022

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

Contents

	Page
Foreword.....	v
Introduction.....	vi
1 Scope.....	1
2 Normative references.....	1
3 Terms and definitions.....	1
4 Requirements for the brazing coordinator.....	3
5 Conditions required for brazer and brazing operator qualification tests.....	3
6 Qualification test requirements.....	3
6.1 Brazing processes.....	3
6.2 Material.....	4
6.3 Material thickness.....	4
6.4 Brazing position.....	4
6.5 Filler material.....	4
7 Special qualification tests.....	5
7.1 General requirements.....	5
7.2 Special qualification tests for brazers.....	5
7.3 Special qualification tests for brazing operators.....	5
8 Designation for qualification test.....	5
9 Performing the brazer and brazing operator qualification test.....	6
9.1 General.....	6
9.2 Theory test.....	6
9.3 Practical testing.....	6
9.3.1 General.....	6
9.3.2 Brazer.....	6
9.3.3 Brazing operator.....	7
9.3.4 Test pieces.....	7
10 Examination and testing.....	8
10.1 General.....	8
10.2 Visual and dimensional examination.....	9
10.3 Peel test.....	9
10.4 Radiographic examination.....	9
10.5 Metallographic examination.....	9
11 Acceptance criteria.....	10
11.1 General.....	10
11.2 Brazer qualification test.....	10
11.3 Brazing operator qualification test.....	10
12 Qualification test certificate.....	10
13 Period of validity of the qualification.....	10
14 Requalification test.....	11
Annex A (informative) Brazer qualification test record in accordance with this document.....	12
Annex B (informative) Brazing operator qualification test record in accordance with this document.....	13
Annex C (informative) Brazer qualification test certificate.....	14
Annex D (informative) Brazing operator qualification test certificate.....	15
Annex E (informative) Guidelines for the theory test.....	17