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Welding - Post-weld heat treatment parameters for steels (ISO/TR 14745:2015)

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**Welding - Post-weld heat treatment parameters for steels
(ISO/TR 14745:2015)**

Soudage - Paramètres de traitement thermique après
soudage des aciers (ISO/TR 14745:2015)

This Technical Report was approved by CEN on 15 December 2014. It has been drawn up by the Technical Committee CEN/TC 121.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

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Foreword

This document (CEN ISO/TR 14745:2015) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" the secretariat of which is held by DIN.

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Welding — Post-weld heat treatment parameters for steels

*Soudage — Paramètres de traitement thermique après soudage des
aciers*





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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
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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.

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 10, *Unification requirements in the field of metal welding*.

Requests for official interpretations of any aspect of this Technical Report should be directed to the Secretariat of ISO/TC 44/SC 10 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

Welding — Post-weld heat treatment parameters for steels

1 Scope

This Technical Report provides recommendations for post-weld heat treatment (PWHT) of steels with recommendations for holding temperatures and holding times for different materials and material thicknesses. These recommendations are limited to stress relieving for non-alloy steels (groups 1, 2, 3, 4, and 11) and to tempering for Cr-Mo-(Ni) steels (groups 5 and 6) and martensitic stainless steels (group 7.2), and are independent of type of product or location. The recommendations do not supersede any guidance given in material supplier specifications, e. g. thermo-mechanically treated fine-grain steels.

This Technical Report does not specify when PWHT is required. Such requirements are given in product standards, material specifications, or material data sheets.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10052, *Vocabulary of heat treatment terms for ferrous products*

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