ICS 25.160.01 SLOVENSKÁ TECHNICKÁ NORMA Január 2026

STN	**Zváračský personál Schvaľovacie skúšky operátorov tavného zvárania a zoraďovačov odporového zvárania pre plnomechanizované a automatizované zváranie kovových materiálov (ISO 14732: 2025)**	**STN EN ISO 14732 05 0708**

Welding personnel - Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials (ISO 14732:2025)

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 12/25

Obsahuje: EN ISO 14732:2025, ISO 14732:2025

Oznámením tejto normy sa ruší
STN EN ISO 14732 (05 0708) z februára 2014

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 14732

July 2025

ICS 25.160.01 Supersedes EN ISO 14732:2013

English Version

Welding personnel - Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials (ISO 14732:2025)

Personnel en soudage - Épreuve de qualification des opérateurs soudeurs et des régleurs en soudage pour le soudage mécanisé et le soudage automatique des matériaux métalliques (ISO 14732:2025)

Schweißpersonal - Prüfung von Bedienern und Einrichtern zum mechanischen und automatischen Schweißen von metallischen Werkstoffen (ISO 14732:2025)

This European Standard was approved by CEN on 9 June 2025.

This European Standard was corrected and reissued by the CEN-CENELEC Management Centre on 03 September 2025.

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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Ref. No. EN ISO 14732:2025 E

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European foreword

This document (EN ISO 14732:2025) 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 AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2026, and conflicting national standards shall be withdrawn at the latest by January 2026.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 14732:2013.

This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

For the relationship with EU Legislation, see informative Annex ZA and ZB, which is an integral part of this document.

Any feedback and questions on this document should be directed to the users’ national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

Endorsement notice

The text of ISO 14732:2025 has been approved by CEN as EN ISO 14732:2025 without any modification.

Annex ZA
(informative)

Relationship between this European Standard and the Essential Requirements of EU Directive 2014/68/EU (PED) aimed to be covered

This European Standard has been prepared under a Commission's standardization request M/601 "Mandate to CEN for standardization in the field of Pressure equipment" to provide one voluntary means of conforming to Essential Requirements of Directive 2014/68/EU "Pressure equipment".

Once this standard is cited in the Official Journal of the European Union under that Directive 2014/68/EU, compliance with the normative clauses of this standard given in Table ZA.1 and application of the edition of the normatively referenced standards as given in Table ZA.2 confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding Essential Requirements of that Directive2014/68/EU, and associated EFTA regulations.

Table ZA.1 — Correspondence between this European Standard and Directive2014/68/EU (PED)

Essential Requirements of Directive 2014/68/EU (PED)	Clause(s)/sub-clause(s) of this EN	Remarks/Notes
3.1.2, paragraphs 3, 4 and 5	4, 5, 6.1, 6.3 a), 6.3 b), 7	Permanent joining – personnel qualification. For pressure equipment in categories II, III and IV the examiner/examining body is a competent third party.
	6.3 c)	Revalidation route 6.3.c) is not permitted for the categories II, III and IV products

Table ZA.2 — Normative references from Clause 2 of this document and their corresponding European publications

Column 1 Reference in Clause 2	Column 2 International Standard Edition	Column 3 Title	Column 4 Corresponding European Standard Edition
ISO 4063:2023	ISO 4063:2023	Welding, brazing, soldering and cutting — Nomenclature of processes and reference numbers	EN ISO 4063:2023
ISO 9606-1	ISO 9606-1:2012 ISO 9606-1:2012/Cor1:2012 ISO 9606-1:2012/Cor2:2013	Qualification testing of welders — Fusion welding — Part 1: Steels	EN ISO 9606-1:2017

Column 1 Reference in Clause 2	Column 2 International Standard Edition	Column 3 Title	Column 4 Corresponding European Standard Edition
ISO 9606-2	ISO 9606-2:2004	Qualification test of welders — Fusion welding — Part 2: Aluminium and aluminium alloys	EN ISO 9606-2:2004
ISO 9606-3	ISO 9606-3:1999	Approval testing of welders — Fusion welding — Part 3: Copper and copper alloys	EN ISO 9606-3:1999
ISO 9606-4	ISO 9606-4:1999	Approval testing of welders — Fusion welding — Part 4: Nickel and nickel alloys	EN ISO 9606-4:1999
ISO 9606-5	ISO 9606-5:2000	Approval testing of welders — Fusion welding — Part 5: Titanium and titanium alloys, zirconium and zirconium alloys	EN ISO 9606-5:2000
ISO 14555	ISO 14555:2017	Welding — Arc stud welding of metallic materials	EN ISO 14555:2017
ISO 15609-1	ISO 15609-1:2019	Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 1: Arc welding	EN ISO 15609-1:2019
ISO 15609-3	ISO 15609-3:2004	Specification and qualification of welding procedures for metallic materials - Welding procedures specification - Part 3: Electron beam welding	EN ISO 15609-3:2004
ISO 15609-4	ISO 15609-4:2009	Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 4:	EN ISO 15609-4:2009

Column 1 Reference in Clause 2	Column 2 International Standard Edition	Column 3 Title	Column 4 Corresponding European Standard Edition
		Laser beam welding	
ISO 15609-5	ISO 15609-5:2011	Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 5: Resistance welding	EN ISO 15609-5:2011
ISO 15609-6	ISO 15609-6:2013	Specification and qualification of welding procedures for metallic materials – Welding procedure specification – Part 6: Laser-arc hybrid welding	EN ISO 15609-6:2013
ISO 15613	ISO 15613:2004	Specification and qualification of welding procedures for metallic materials — Qualification based on pre-production welding test	EN ISO 15613:2004
ISO 15614-1	ISO 15614-1:2017 ISO 15614-1:2017/Amd 1:2019	Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys	EN ISO 15614-1:2017 EN ISO 15614-1:2017/A1:2019
ISO 15614-2	ISO 15614-2:2005 ISO 15614-2:2005/Cor 2:2009	Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 2: Arc welding of aluminium and its alloys	EN ISO 15614-2:2005 EN ISO 15614-2:2005/AC:2009
ISO 15614-5	ISO 15614-5:2004	Specification and qualification of welding procedures	EN ISO 15614-5:2004

Column 1 Reference in Clause 2	Column 2 International Standard Edition	Column 3 Title	Column 4 Corresponding European Standard Edition
		for metallic materials - Welding procedure test - Part 5: Arc welding of titanium, zirconium and their alloys	
ISO 15614-6	ISO 15614-6:2006	Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 6: Arc and gas welding of copper and its alloys	EN ISO 15614-6:2006
ISO 15614-7	ISO 15614-7:2016	Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 7: Overlay welding	EN ISO 15614-7:2019
ISO 15614-8	ISO 15614-8:2016	Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 8: Welding of tubes to tube-plate joints	EN ISO 15614-8:2016
ISO 15614-11	ISO 15614-11:2002	Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 11: Electron and laser beam welding	EN ISO 15614-11:2002
ISO 15614-12	ISO 15614-12:2021	Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 12: Spot, seam and projection welding	EN ISO 15614-12:2021
ISO 15614-13	ISO 15614-13:2021	Specification and	EN ISO 15614-13:2021

Column 1 Reference in Clause 2	Column 2 International Standard Edition	Column 3 Title	Column 4 Corresponding European Standard Edition
		qualification of welding procedures for metallic materials - Welding procedure test - Part 13: Upset (resistance butt) and flash welding	
ISO 15614-14	ISO 15614-14:2013	Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 14: Laser-arc hybrid welding of steels, nickel and nickel alloys	EN ISO 15614-14:2013
ISO/TR 25901-1	ISO/TR 25901-1:2016	Welding and allied processes — Vocabulary — Part 1: General terms	None For applicable standard edition see Column 2
ISO 25901-2	ISO 25901-2:2022	Welding and allied processes — Vocabulary — Part 2: Health and safety	EN ISO 25901-2:2023
ISO/TR 25901-3	ISO/TR 25901-3:2016	Welding and allied processes — Vocabulary — Part 3: welding processes	None For applicable standard edition see Column 2
ISO/TR 25901-4	ISO/TR 25901-4:2016	Welding and allied processes — Vocabulary — Part 4: Arc welding	None For applicable standard edition see Column 2

The documents listed in the Column 1 of Table ZA.2, in whole or in part, are normatively referenced in this document, i.e. are indispensable for its application. The achievement of the presumption of conformity is subject to the application of the edition of Standards as listed in Column 4 or, if no European Standard Edition exists, the International Standard Edition given in Column 2 of Table ZA.2.

WARNING 1 — Presumption of conformity stays valid only as long as a reference to this European Standard is maintained in the list published in the Official Journal of the European Union. Users of this standard should consult frequently the latest list published in the Official Journal of the European Union.

WARNING 2 — Other Union legislation may be applicable to the product(s) falling within the scope of this standard.

Annex ZB
(informative)

Relationship between this European Standard and the Essential Requirements of EU Directive 2014/29/EU (SPVD) aimed to be covered

This European Standard has been prepared under a Commission's standardization request M/602 "Mandate to CEN for standardization in the field of Simple pressure vessels" to provide one voluntary means of conforming to Essential Requirements of the New Approach simple pressure vessels Directive 2014/29/EU.

Once this standard is cited in the Official Journal of the European Union under that Directive 2014/29/EU compliance with the normative clauses of this standard given in Table ZB.1 and application of the edition of the normatively referenced standards as given in Table ZA.2 confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding Essential Requirements of that Directive2014/29/EU, and associated EFTA regulations.

Table ZB.1 — Correspondence between this European Standard and Annex I of the Directive2014/29/EU (SPVD)

Essential Requirements of Directive 2014/29/EU (SPVD)	Clause(s)/sub-clause(s) of this EN	Remarks/Notes
3.2, paragraph 2	4, 5, 6.1, 6.3 a), 6.3 b), 7	For welds on pressurized parts of simple pressure vessels, the examiner/examining body is a notified body.

WARNING 1 — Presumption of conformity stays valid only as long as a reference to this European Standard is maintained in the list published in the Official Journal of the European Union. Users of this standard should consult frequently the latest list published in the Official Journal of the European Union.

WARNING 2 — Other Union legislation may be applicable to the product(s) falling within the scope of this standard.

International Standard

ISO 14732

Welding personnel — Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials

Personnel en soudage — Épreuve de qualification des opérateurs soudeurs et des régleurs en soudage pour le soudage mécanisé et le soudage automatique des matériaux métalliques

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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

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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.

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 document 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).

ISO draws attention to the possibility that the implementation of this document may involve the use of (a) patent(s). ISO takes no position concerning the evidence, validity or applicability of any claimed patent rights in respect thereof. As of the date of publication of this document, ISO had not received notice of (a) patent(s) which may be required to implement this document. However, implementers are cautioned that this may not represent the latest information, which may be obtained from the patent database available at www.iso.org/patents. ISO shall not be held responsible for identifying any or all such patent rights.

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 11, *Qualification requirements for welding and allied processes personnel*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 14732:2013), which has been technically revised.

The main changes are as follows:

— introduction has been revised to exclude reference to application standards;

— scope clarifies that the standard does not apply to personnel who do not control or adjust welding parameters; or are not involved in the setup of welding equipment;

— scope is now limited to metallic materials per the title;

— scope references ISO 25239-3 and ISO 18785-3, respectively for friction stir and friction stir spot welding;

— normative references in Clause 2 have been updated;

— terms and definitions in Clause 3 have been updated and re-ordered

— Clause 4 has been significantly revised and variables and range of qualification are now in a new Clause 5;

— Clause 6 (previously Clause 5) has been revised

— Annexes A and B have been updated

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html. Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: https://committee.iso.org/sites/tc44/home/interpretation.html.

Introduction

This document is intended to provide the basis for the mutual recognition by examining bodies of qualification related to the competence of welding operators and weld setters in the various fields of application.

The welding operator's or weld setter's ability and job knowledge continue to be approved only if the welding operators or weld setters are working with reasonable continuity on welding work within the extent of qualification. However, a functional knowledge test is mandatory.

It is presumed that the welding operator or weld setter has received training or has industrial practice within the range of qualification.

All new qualifications should be in accordance with this document from the date of issue.

At the end of its period of validity, the existing and valid qualification testing of welding operators and weld setters in accordance with the requirements of a national standard can be revalidated in accordance with this document. The new range of qualification will be interpreted in accordance with the requirements of this document.

International Standard **ISO 14732:2025(en)**

Welding personnel — Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials

1 Scope

This document specifies requirements for qualification of welding operators and weld setters for mechanized and automatic welding of metallic materials.

This document does not apply to personnel who:

— do not control or adjust welding parameters;

— are not involved in the setup of welding equipment.

Qualification of welding operators and weld setters for friction stir welding and friction stir spot welding are covered by ISO 25239-3 and ISO 18785-3, respectively.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3834-2, *Quality requirements for fusion welding of metallic materials — Part 2: Comprehensive quality requirements*

ISO 3834-3, *Quality requirements for fusion welding of metallic materials — Part 3: Standard quality requirements*

ISO 4063:2023, *Welding, brazing, soldering and cutting — Nomenclature of processes and reference numbers*

ISO 9606-1, *Qualification testing of welders — Fusion welding — Part 1: Steels*

ISO 9606-2, *Qualification test of welders — Fusion welding — Part 2: Aluminium and aluminium alloys*

ISO 9606-3, *Approval testing of welders — Fusion welding — Part 3: Copper and copper alloys*

ISO 9606-4, *Approval testing of welders — Fusion welding — Part 4: Nickel and nickel alloys*

ISO 9606-5, *Approval testing of welders — Fusion welding — Part 5: Titanium and titanium alloys, zirconium and zirconium alloys*

ISO 14555, *Welding — Arc stud welding of metallic materials*

ISO 15609-1, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 1: Arc welding*

ISO 15609-2, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 2: Gas welding*

ISO 15609-3, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 3: Electron beam welding*

ISO 15609-4, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 4: Laser beam welding*

ISO 15609-5, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 5: Resistance welding*

ISO 15609-6, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 6: Laser-arc hybrid welding*

ISO 15613, *Specification and qualification of welding procedures for metallic materials — Qualification based on pre-production welding test*

ISO 15614-1, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys*

ISO 15614-2, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 2: Arc welding of aluminium and its alloys*

ISO 15614-5, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 5: Arc welding of titanium, zirconium and their alloys*

ISO 15614-6, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 6: Arc and gas welding of copper and its alloys*

ISO 15614-7, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 7: Overlay welding*

ISO 15614-8, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 8: Welding of tubes to tube-plate joints*

ISO 15614-11, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 11: Electron and laser beam welding*

ISO 15614-12, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 12: Spot, seam and projection welding*

ISO 15614-13, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 13: Upset (resistance butt) and flash welding*

ISO 15614-14, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 14: Laser-arc hybrid welding of steels, nickel and nickel alloys*

ISO 25901 (all parts), *Welding and allied processes — Vocabulary*