



BSI Standards Publication

Plastics — Welding of thermoplastics — Specification of welding procedures

National foreword

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English Version

**Plastics - Welding of thermoplastics - Specification of
 welding procedures**

Plastiques - Soudage des matériaux thermoplastiques -
 Spécification de modes opératoires de soudage

Kunststoffe - Schweißen von thermoplastischen
 Kunststoffen - Anforderungen an Schweißverfahren

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European foreword

This document (CEN/TS 16892:2015) has been prepared by Technical Committee CEN/TC 249 "Plastics", the secretariat of which is held by NBN.

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1 Scope

This Technical Specification provides guidance for the minimum content of welding procedure specifications for the following welding processes:

- hot gas welding: round nozzle, high speed nozzle, wedge;
- extrusion welding;
- heated tool welding: butt, socket, wedge;
- solvent welding: socket;
- electrofusion welding: socket, saddle.

This Technical Specification applies to the welding of the following products and semi-finished products made of thermoplastic materials:

- sheet;
- pipe;
- fittings;
- lining membrane.

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 ISO 6947, *Welding and allied processes - Welding positions (ISO 6947)*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

welding procedure

specified course of action to be followed in making a weld, including the welding process(es), reference to materials, welding consumable preparation, preheating (if necessary), method and control of welding and necessary equipment to be used

3.2

welding process

technique characterized by the method of softening to obtain permanent assembly

3.3

welding procedure specification

document that has been qualified and provides the required variables of the welding procedure to ensure repeatability during production welding

3.4

work instruction

simplified welding procedure specification (WPS), suitable for direct application