

# JIS

JAPANESE  
INDUSTRIAL  
STANDARD

Translated and Published by  
Japanese Standards Association

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JIS Z 3609-2 : 2021

(JLWA/JSA)

**Friction stir spot welding — Aluminium  
— Part 2: Quality requirements, welding  
procedures and welding personnel**

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ICS 25.160.01 ; 25.160.10

Reference number : JIS Z 3609-2 : 2021 (E)

Date of Establishment: 2021-09-21

Date of Public Notice in Official Gazette: 2021-09-21

Investigated by: Japanese Industrial Standards Committee

Standards Board for ISO area

Technical Committee on Metal and Inorganic Materials

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JIS Z 3609-2 : 2021, First English edition published in 2022-03

Translated and published by: Japanese Standards Association  
Mita MT Building, 3-13-12, Mita, Minato-ku, Tokyo, 108-0073 JAPAN

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In the event of any doubts arising as to the contents,  
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Printed in Japan

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## Foreword

This Japanese Industrial Standard has been established by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee according to the proposal for establishment of Japanese Industrial Standard submitted by Japan Light Metal Welding Association (JLWA)/Japanese Standards Association (JSA) with a draft being attached, based on the provision of Article 12, paragraph (1) of the Industrial Standardization Act.

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**JIS Z 3609** series consists of the following 2 parts under the general title *Friction stir spot welding — Aluminium —*:

*Part 1: Vocabulary and welding processes*

*Part 2: Quality requirements, welding procedures and welding personnel*

# Friction stir spot welding — Aluminium — Part 2 : Quality requirements, welding procedures and welding personnel

## Introduction

This Japanese Industrial Standard has been prepared based on **ISO 18785-3 : 2018**, Edition 1, and **ISO 18785-4 : 2018**, Edition 1 and **ISO 18785-5 : 2018**, Edition 1, with some modifications of the technical contents.

The dotted underlines indicate changes from the corresponding International Standards. A list of modifications with the explanations is given in Annex J.

## 1 Scope

This Standard specifies quality requirements, welding procedure specification and its qualification, and qualification of welding personnel for friction stir spot welding (FSSW) process to be applied for aluminium and its alloys.

It specifies quality requirements related to FSSW but does not assign characteristic values to any specific semi-finished or finished product.

**NOTE** The International Standards corresponding to this Standard and the symbol of degree of correspondence are as follows.

ISO 18785-3 : 2018 *Friction stir spot welding — Aluminium — Part 3 : Qualification of welding personnel*

ISO 18785-4 : 2018 *Friction stir spot welding — Aluminium — Part 4 : Specification and qualification of welding procedures*

ISO 18785-5 : 2018 *Friction stir spot welding — Aluminium — Part 5 : Quality and inspection requirements* (Overall evaluation: MOD)

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standards and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21-1**.

## 2 Normative references

Part or all of the provisions of the following standards, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

JIS Z 2305 *Non-destructive testing — Qualification and certification of NDT personnel*

**NOTE** Normative reference in the corresponding International Standard : ISO 9712 *Non-destructive testing — Qualification and certification of NDT personnel*