

Guideline

6/11

CLAP

FORM N°147

Version : 4

Directive 97/23/EC

Keywords :

Permanent joint

Permanent joining procedure

Qualification

Standard

Code

Welding

Directive references:

Annex I § 3.1.2 - 97/23 EC

Article 1 § 2.8 - 97/23 EC

Adopted by WPG: 24/05/2002

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Subject: ESR on manufacturing – Approach for the approval of permanent joining procedures

Question: In the absence of harmonized standards, what approach is to be followed for the approval of permanent joining procedures?

Answer: In the absence of harmonized standards, the manufacturer shall refer to an existing document (draft standard candidate for harmonization, professional document, guide, recognised third party/notified body document, company document) or shall establish a specific document.

Such a document shall define at least:

- Essential variables for the procedure that may affect the properties of the permanent joining;
- Inspection and testing to be carried out for the qualification of the procedure;
- Acceptance criteria;
- Range of validity.

NOTE: The directive states that “the properties of permanent joints must meet the minimum properties specified for the materials to be joined unless other relevant property values are specifically taken into account in the design calculations”.

See also CLAP 78 - Guideline 6/1.

For welding, see CLAP 200 - Guideline 6/12.

Modifications compared to the previous adopted version: Editorial correction on 2004-09-16.