INTERNATIONAL STANDARD

ISO 11745

Second edition
2022-11

Brazing for aerospace applications — Qualification test for brazers and brazing operators — Brazing of metallic components

Brasage fort pour applications aérospatiales — Épreuve de qualification des braseurs et des opérateurs braseurs — Brasage fort des composants métalliques

Reference number
ISO 11745:2022(E)

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Published in Switzerland

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Contents

Page

Foreword ..... **v**
Introduction ..... **vi**
1 Scope **1**
2 Normative references **1**
3 Terms and definitions **1**
4 Requirements for the brazing coordinator **3**
5 Conditions required for brazer and brazing operator qualification tests **3**
6 Qualification test requirements **3**
6.1 Brazing processes 3
6.2 Material 4
6.3 Material thickness 4
6.4 Brazing position 4
6.5 Filler material 4
7 Special qualification tests **5**
7.1 General requirements 5
7.2 Special qualification tests for brazers 5
7.3 Special qualification tests for brazing operators 5
8 Designation for qualification test **5**
9 Performing the brazer and brazing operator qualification test **6**
9.1 General 6
9.2 Theory test 6
9.3 Practical testing 6
9.3.1 General 6
9.3.2 Brazer 6
9.3.3 Brazing operator 7
9.3.4 Test pieces 7
10 Examination and testing **8**
10.1 General 8
10.2 Visual and dimensional examination 9
10.3 Peel test 9
10.4 Radiographic examination 9
10.5 Metallographic examination 9
11 Acceptance criteria **10**
11.1 General 10
11.2 Brazer qualification test 10
11.3 Brazing operator qualification test 10
12 Qualification test certificate **10**
13 Period of validity of the qualification **10**
14 Requalification test **11**
Annex A (informative) **Brazer qualification test record in accordance with this document** **12**
Annex B (informative) **Brazing operator qualification test record in accordance with this document** **13**
Annex C (informative) **Brazer qualification test certificate** **14**
Annex D (informative) **Brazing operator qualification test certificate** **15**
Annex E (informative) **Guidelines for the theory test** **17**

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Bibliography **18**

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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 documents 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).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

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 14, *Welding and brazing in aerospace*.

This second edition cancels and replaces the first edition (ISO 11745:2010), which has been technically revised. It also incorporates the Amendment ISO 11745:2010/Amd 1:2015.

The main changes are as follows:

— Clause 5: visual inspection aligned with ISO 24394;

— designation for filler material added;

— editorial revisions.

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.

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Introduction

The application of this document ensures that a qualification test can be carried out in accordance with a standard test specification on standard test pieces under standard conditions. A brazer or brazing operator qualification test properly passed in accordance with this document ensures that the brazer or brazing operator concerned has proved possession of at least the minimum degree of manual skills and technical knowledge demanded by the state of the art.

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Brazing for aerospace applications — Qualification test for brazers and brazing operators — Brazing of metallic components

1 Scope

This document specifies a qualification test for brazers engaged in manual brazing of parts and brazing operators in aerospace construction.

NOTE Success in the test is an essential precondition for the qualification of brazers and brazing operators in new production and repair work in aerospace. However, brazing equipment operators need not be qualified in accordance with this document.

This document does not apply to general brazing applications covered by ISO 13585.

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 18279:2003, *Brazing — Imperfections in brazed joints*

ISO 18490, *Non-destructive testing — Evaluation of vision acuity of NDT personnel*

EN 4179, *Aerospace series — Qualification and approval of personnel for non-destructive testing*

EN 12799, *Brazing — Non-destructive examination of brazed joints*

EN 13134, *Brazing — Procedure approval*

ANSI/AWS B2.2, *Brazing procedure and performance qualification*

NAS 410, *NAS certification & qualification of nondestructive test personnel*

3 Terms and definitions

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

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at https://www.electropedia.org/

3.1
brazer
person who performs the brazing in a manual operation, guides the heating means, ensures the introduction of the brazing filler material and verifies the braze joint configuration specified by the design

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3.2
brazing operator
person who prepares the joint and sets up brazing equipment and thereby has a direct influence on the brazed joint quality

Note 1 to entry: Examples of brazing equipment are furnaces, salt baths and induction equipment.

3.3
brazing equipment operator
person who only operates automatic brazing equipment and has no direct influence on the brazed joint quality

Note 1 to entry: Examples of automatic brazing equipment are furnaces, salt baths and induction equipment that require no brazing operator intervention during the thermal process.

3.4
examiner
person who has been appointed to verify conformity to the applicable standard

Note 1 to entry: In certain cases, an external independent examiner can be required.

[SOURCE: ISO/TR 25901-1:2016, 2.5.29, modified — Definition revised.]

3.5
examining body
organization that has been appointed to verify conformity to the applicable standard

Note 1 to entry: In certain cases, an external independent examining body can be required.

[SOURCE: ISO/TR 25901-1:2016, 2.5.30, modified — Definition revised.]

3.6
design authority
engineering authority
organization that has the responsibility for the structural integrity or maintenance of airworthiness of the hardware and conformity to all relevant documents

Note 1 to entry: In the case of a welded product, the design authority is usually the organization that has responsibility for the engineering definition of the product. Examples of engineering definitions include drawings, 3D models and specifications for manufacturing.

[SOURCE: ISO 24394:2018, 3.8, modified — Definition revised and note to entry added.]

3.7
braze assembly
assembly of parts to be brazed with regard to fit-up procedures

Note 1 to entry: Fit-up procedures can include precleaning and application of brazing filler material, stop-off material or flux.

3.8
brazing coordinator
person responsible for and competent to perform brazing coordination

Note 1 to entry: Different brazing coordinators can be required for different tasks.

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