

PD CEN/TS 16892:2015



BSI Standards Publication

# Plastics — Welding of thermoplastics — Specification of welding procedures

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**National foreword**

This Published Document is the UK implementation of CEN/TS 16892:2015.

The UK participation in its preparation was entrusted to Technical Committee PRI/80, Welding thermoplastics.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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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 - Anforderung von Schweißverfahren

This Technical Specification (CEN/TS) was approved by CEN on 13 November 2015 for provisional application.

The period of validity of this CEN/TS is limited initially to three years. After two years the members of CEN will be requested to submit their comments, particularly on the question whether the CEN/TS can be converted into a European Standard.

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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.

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

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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 consumables, 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**

##### **WPS**

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