



**International
Standard**

ISO 9692-2

**Welding and allied processes —
Joint preparation —**

**Part 2:
Submerged arc welding of steels**

*Soudage et techniques connexes — Préparation de joints —
Partie 2: Soudage à l'arc sous flux en poudre des aciers*

**Second edition
2024-02**

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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

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Foreword

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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 document 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).

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 7, *Representation and terms*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 9692-2:1998), of which it constitutes a minor revision. The changes are as follows:

- [Clause 1](#), fourth paragraph revised and moved to the Introduction;
- ISO 2553, ISO 6947 and ISO 9692-1 moved from [Clause 2](#) to the Bibliography;
- alignment in [Clause 5](#) of the note explaining the reference numbers in [Tables 1](#) and [2](#) with the corresponding text in ISO 9692-3;
- modification of the reference numbers in [Tables 1](#) and [2](#) in accordance with the latest version of ISO 2553 and reordering of the lines of the tables in ascending order of the new reference numbers.

A list of all parts in the ISO 9692 series can be found on the ISO website.

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>.

Introduction

This document is intended to be used alongside ISO 9692-1. It follows similar rules and the same layout. Therefore, the introduction given in ISO 9692-1 also applies.

ISO 9692-1 specifies joint preparations for other arc welding processes (see ISO 4063), which are applicable when the root is not welded by submerged arc welding.

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Welding and allied processes — Joint preparation —

Part 2: Submerged arc welding of steels

1 Scope

This document applies to types of joint preparation for submerged arc welding with one wire electrode (process 121 according to ISO 4063) on steel.

This document covers only the welding positions PA and PB according to ISO 6947. If PC is used, special preparation is necessary.

This document applies to fully penetrated welds. For partly penetrated welds, types of joint preparation, shapes and dimensions can differ from the listed proposals if they are specified in the relevant application standard or agreed by the parties concerned.

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 15609-1, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 1: Arc welding*

3 Terms and definitions

No terms and definitions are listed in this document.

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/>

4 Materials

Joint preparations recommended in this document are suitable for all types of weldable steel.

5 Types of joint preparation

The recommended types of joint preparation and dimensions are specified in [Table 1](#) and [Table 2](#).

The root gaps referred to in this document are those gaps presented after tack welding, if used.

This document gives no dimensions or type of possibly used backing materials. Root runs may also be used as backing. They may influence the quality requirements for welding (according to the relevant part of the ISO 3834 series) and the preparation as given in [Table 1](#) and [Table 2](#). They shall be part of the welding procedure specification in accordance with ISO 15609-1.

According to the application standard or agreement between contracting parties, it can be necessary to grind the slag before welding the next run.

The reference numbers in [Tables 1](#) and [2](#) have been determined in accordance with the following scheme:

- the first digit corresponds with the number of the table (e.g. digit 1 for [Table 1](#) with joint preparation for butt welds, welded from one side);
- the second digit or numerical group corresponds with the number in ISO 2553 (e.g. digit 1 for square butt weld as given in ISO 2553:2019, Table 1);
- the third indication, expressed by a letter, covers the variants of joint preparations.

EXAMPLE Joint preparation for a butt weld, welded from one side (1), finished for single-V butt weld (2):

1.2

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Table 1 — Joint preparations for butt welds, welded from one side

Dimensions in millimetres

Weld					Joint preparation					Welding position (in accordance with ISO 6947)	Remarks
Ref. no.	Work-piece thickness t	Designation	Symbol (in accordance with ISO 2553)	Illustration	Cross section	Angle α, β	Gap b Radius R	Thick-ness of root face c	Depth of preparation h		
1.1	$3 \leq t \leq 12$	Square butt weld				—	$b \leq 0,5 t$ max. 5	—	—	PA	With backing minimal thickness for backing: 5 mm or 0,5 t
1.2	$10 \leq t \leq 20$	Single-V butt weld				$30^\circ \leq \alpha \leq 50^\circ$	$4 \leq b \leq 8$	$c \leq 2$	—	PA	With backing minimal thickness for backing: 5 mm or 0,5 t
1.2.2	$t > 12$	Single-V butt weld with V root				$60^\circ \leq \alpha \leq 70^\circ$ $4^\circ \leq \beta \leq 10^\circ$	$1 \leq b \leq 4$	$0 \leq c \leq 3$	$4 \leq h \leq 6$	PA	Root run welded with optional welding process
1.2.6	$t \geq 12$	Single-U butt weld with V root				$60^\circ \leq \alpha \leq 70^\circ$ $4^\circ \leq \beta \leq 10^\circ$	$1 \leq b \leq 4$ $5 \leq R \leq 10$	$0 \leq c \leq 3$	$4 \leq h \leq 6$	PA	Root run welded with optional welding process

Table 1 (continued)

Weld						Joint preparation				Welding position (in accordance with ISO 6947)	Remarks
Ref. no.	Work-piece thickness t	Designation	Symbol (in accordance with ISO 2553)	Illustration	Cross section	Angle α, β	Gap b Radius R	Thick-ness of root face c	Depth of preparation h		
1.4	$3 \leq t \leq 16$	Single-bevel butt welded				$30^\circ \leq \beta \leq 50^\circ$	$1 \leq b \leq 4$	$c \leq 2$	—	PA PB	With backing minimal thickness for backing: 5 mm or $0,5 t$
1.6	$t \geq 30$	Single-U butt weld				$4^\circ \leq \beta \leq 10^\circ$	$1 \leq b \leq 4$ $5 \leq R \leq 10$	$2 \leq c \leq 3$	—	PA	With backing minimal thickness for backing: 5 mm or $0,5 t$

Table 1 (continued)

Weld						Joint preparation				Welding position (in accordance with ISO 6947)	Remarks
Ref. no.	Work-piece thickness t	Designation	Symbol (in accordance with ISO 2553)	Illustration	Cross section	Angle α, β	Gap b Radius R	Thick-ness of root face c	Depth of preparation h		
1.7	$t \geq 16$	Single-I butt weld				$4^\circ \leq \beta \leq 10^\circ$	$2 \leq b \leq 4$ $5 \leq R \leq 10$	$2 \leq c \leq 3$	—	PA PB	With backing minimal thickness for backing: 5 mm or 0,5 t
1.17	$t > 20$	Steep-flanked single-V butt weld				$4^\circ \leq \beta \leq 10^\circ$	$10 \leq b \leq 25$	—	—	PA	With backing minimal thickness for backing: 5 mm or 0,5 t
1.18	$t \geq 16$	Steep-flanked single-bevel butt weld				$8^\circ \leq \beta \leq 10^\circ$	$5 \leq b \leq 15$	—	—	PA PB	With backing minimal thickness for backing: 5 mm or 0,5 t

Table 2 — Joint preparations for butt welds, welded from both sides

Dimensions in millimetres

Weld			Joint preparation						Welding position (in accordance with ISO 6947)	Remarks
Ref. no.	Work-piece thickness t	Designation	Symbol (in accordance with ISO 2553)	Illustration	Cross section	Angle	Gap b	Thick-ness of root face c	Depth of preparation h	
2.1	$3 \leq t \leq 20$	Square butt weld				—	$b \leq 2$	—	—	Width of gap shall be kept within small tolerances
2.1.2	$10 \leq t \leq 20$	Single-V butt weld with square butt weld				$60^\circ \leq \alpha \leq 80^\circ$	$b \leq 4$	$5 \leq c \leq 15$	—	Root run may be welded by another fusion welding process
2.2.3 A	$10 \leq t \leq 35$	Single-V butt weld with broad root face and backing run				$30^\circ \leq \alpha \leq 60^\circ$	$b \leq 4$	$4 \leq c \leq 10$	—	Root run may be welded by another fusion welding process
2.3.3	$t \geq 16$	Double-V butt weld with broad root face				$30^\circ \leq \alpha \leq 70^\circ$	$b \leq 4$	$4 \leq c \leq 10$	$h_1 \approx h_2$	—

Table 2 (continued)

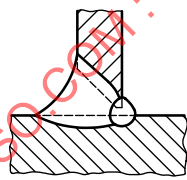
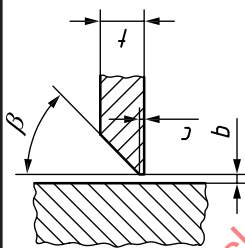
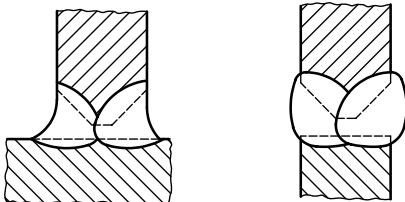
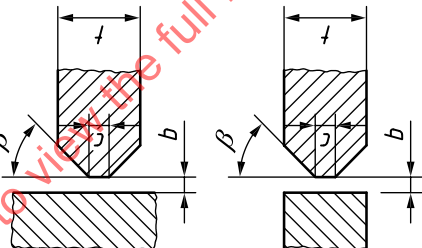
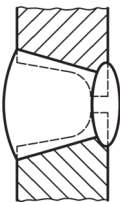
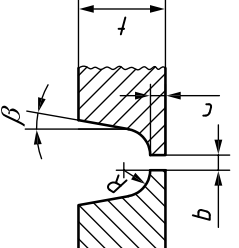
Weld				Joint preparation						Welding position (in accordance with ISO 6947)	Remarks
Ref. no.	Work-piece thickness t	Designation	Symbol (in accordance with ISO 2553)	Illustration	Cross section	Angle α, β	Gap b Radius R	Thick-ness of root face c	Depth of preparation h		
2.4 A	$t < 12$	Single-bevel butt weld with backing run				$30^\circ \leq \beta \leq 50^\circ$	$b \leq 4$	$c \leq 2$	—	PA PB	Root run may be necessary
2.5.5	$t \geq 12$	Double-bevel butt weld with broad root face				$30^\circ \leq \beta \leq 50^\circ$	$b \leq 4$	$4 \leq c \leq 10$	—	PA PB	This type of joint preparation can also be produced asymmetrically in a similar manner to the asymmetrical double-V butt weld Root run may be necessary
2.6 A	$t \geq 30$	Single-U butt weld with backing run				$5^\circ \leq \beta \leq 10^\circ$	$b \leq 4$ $5 \leq R \leq 10$	$4 \leq c \leq 10$	—	PA	

Table 2 (continued)

Weld			Joint preparation						Welding position (in accordance with ISO 6947)	Remarks
Ref. no.	Work-piece thickness t	Designation	Symbol (in accordance with ISO 2553)	Illustration	Cross section	Angle α, β	Gap b Radius R	Thick-ness of root face c	Depth of preparation h	
2.6.6	$t \geq 50$	Double-U butt weld				$5^\circ \leq \beta \leq 10^\circ$	$b \leq 4$ $5 \leq R \leq 10$	$4 \leq c \leq 10$	$h = 0,5 (t - c)$	PA This type of joint preparation can also be produced asymmetrically in a similar manner to the asymmetrical double-V butt weld
2.7 A	$t \geq 20$	Single-J butt weld with backing run				$5^\circ \leq \beta \leq 10^\circ$	$b \leq 4$ $5 \leq R \leq 10$	$4 \leq c \leq 10$	—	PA PB Root run may be necessary
2.7.7 A	$t \leq 30$	Double-J butt weld				$5^\circ \leq \beta \leq 10^\circ$	$b \leq 4$ $5 \leq R \leq 10$	$2 \leq c \leq 7$	—	PA PB This type of joint preparation can also be produced asymmetrically in a similar manner to the asymmetrical double-V butt weld Root run may be necessary