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**Brazing — Imperfections in brazed joints**

*Brasage fort — Défauts dans les assemblages réalisés par brasage fort*

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## Foreword

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The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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.

ISO 18279 was prepared by the European Committee for Standardization (CEN) in collaboration with Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 12, *Soldering and brazing materials*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Throughout the text of this document, read “...this European Standard...” to mean “...this International Standard...”.

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## Foreword

This document (EN ISO 18279:2003) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

This European Standard EN ISO 18279:2003 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2004 and conflicting national standards shall be withdrawn at the latest by June 2004.

Annexes A and B are informative.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland and the United Kingdom.

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## Introduction

Brazed joints usually contain imperfections of various types, some of which will be detrimental in almost every case but others may be detrimental or harmless, depending entirely on the service requirements of the joint in question. Therefore it will frequently be necessary to classify the imperfections in a brazed joint and then try to assess the significance of their effects on the behaviour of the joint in service. The classification is, relatively, easy and Table 1 describes the imperfections that most commonly occur. The assessment of significance is not easy (see also Annex A).

For welded joints, there has been extensive work carried out for many years on the significance of imperfections in service but such work has not been carried out on brazed joints. Moreover the work on welded joints is only rarely relevant to brazed joints, mainly because of differences in geometry and stressing. Therefore this standard cannot give definitive quality levels for brazed joints. These can only be produced as experience is gained from industrial applications. However, Annex B gives some suggestions for quality levels for general applications, which may be of help where detailed information is not available. It has to be emphasized that the use of quality levels can only be successful if the imperfections that are relevant to the application of the brazed joint are determined.

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## 1 Scope

This European Standard details a classification of imperfections that can occur in brazing joints. In addition guidance is provided on quality levels and suggested limits for imperfections are detailed.

For requirements not covered by this standard, reference is to be made to other sources, e.g. statutory regulations, codes of practice and technical delivery conditions.

No information is given on how imperfections are to be assessed in individual cases because this depends on the requirements for the particular brazed joint. These imperfections are not always detectable by the use of non-destructive testing alone.

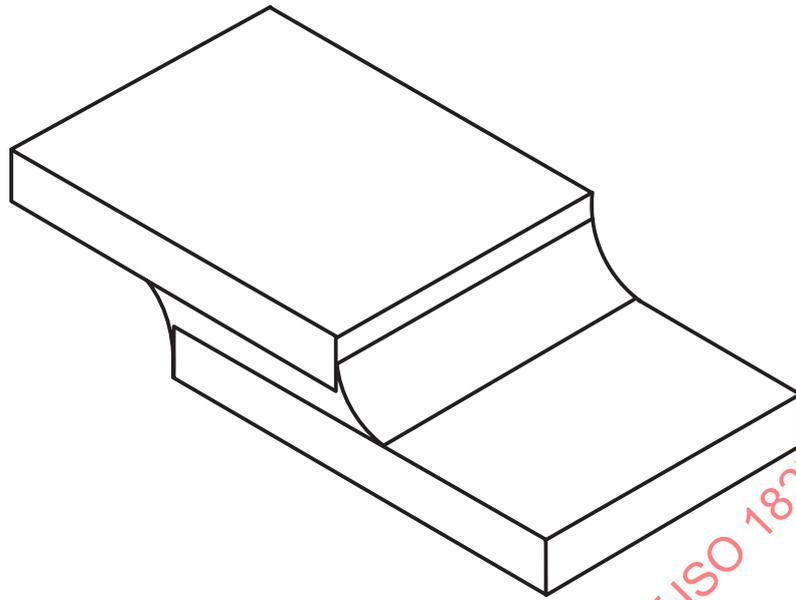
The standard covers only imperfections that can occur in connection with brazing without the effect of any additional service loads. Only the type, shape and position of such imperfections are covered; no indication is given of the conditions of occurrence or causes.

For requirements for brazed joints which are relevant and essential to the particular function of the component, reference should be made to the relevant documentation, e.g. manufacturing documents or procedure sheets.

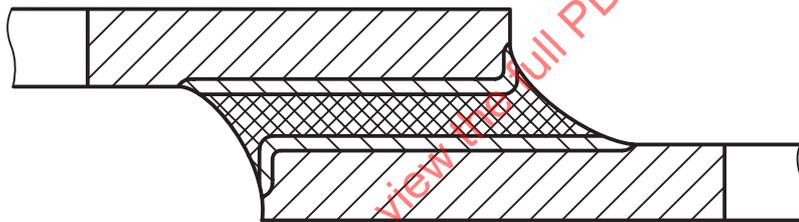
**NOTE** It is important that these requirements be precisely prescribed and that compliance with them be verifiable. Compliance may be established by testing either the brazed assembly itself or a test piece produced under comparable conditions. The requirements should be established and fully documented before any classification is undertaken.

This European Standard does not lay down requirements for acceptance levels for imperfections since these will differ very markedly, depending on the application, but it does suggest some quality levels which may be of value in the absence of more detailed information.

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a) Simple brazed assembly



**Key**



Parent material



Parent material affected by brazing (heat affected zone (HAZ))



Diffusion-transition zone



Braze metal

NOTE Extent of HAZ will vary with materials and brazing process.

b) Section through assembly in a)

**Figure 1 — Schematic of brazed assembly**

**2 Terms and definitions**

For the purposes of this European Standard the areas of a brazed assembly are defined as shown schematically in Figure 1. In addition the following term and definition apply.

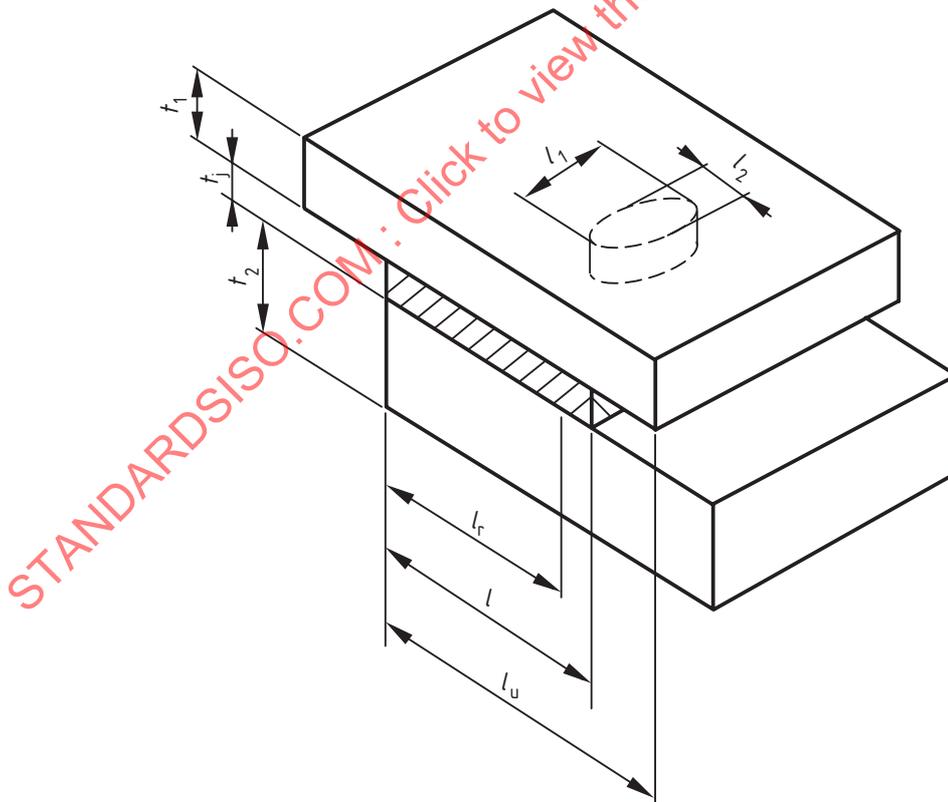
## 2.1 imperfections

irregularities in the brazed joint, deviations from the intended relative positions of the parts joined by brazing and from the intended shape of the brazed component, where such deviations are dependent on the brazing

## 3 Symbols

The following symbols are used:

- $l$  length of the brazed overlap;
- $l_r$  required brazed length;
- $l_u$  length of overlap before brazing;
- $l_{1,2}$  dimensions of the brazed imperfection;
- $t_j$  thickness of brazed joint;
- $t_{1,2}$  wall or plate thickness or thicknesses.



NOTE This figure illustrates a planar imperfection.

Figure 2 — Symbols used for dimensions

## 4 Classification

### 4.1 General

The imperfections are classified into six groups as follows:

- group I Cracks;
- group II Cavities;
- group III Solid inclusions;
- group IV Bonding imperfections;
- group V Shape and size imperfections;
- group VI Miscellaneous imperfections.

Imperfections are identified by designations.

A further distinction can be made between the external and internal imperfections that may occur in brazed joints.

### 4.2 External imperfections

External imperfections in brazed joints include:

- underfill;
- cracks;
- surface-breaking porosity;
- incomplete fillet;
- overlap;
- localized melting;
- rough surface of seam;
- flux seepage;
- discoloration;
- spatter;
- residual flux;
- surface erosion of parent material.

### 4.3 Internal imperfections

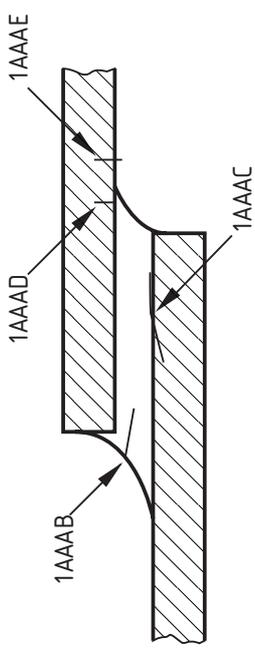
Internal imperfections in brazed joints include:

- cracks;
- filling imperfections;

- solid inclusions;
- gas entrapment;
- flux inclusion;
- lack of fusion;
- excessive alloying of filler material and parent material (sometimes called erosion).

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Table 1 — Classification of imperfections

Designation	Description	Remarks	Drawing
<b>I Cracks</b>			
1A <sup>a</sup> AAA	crack	Limited separation of the material, predominantly two-dimensional extension. A crack may be longitudinal or transverse	
1A <sup>a</sup> AAB		It can lie in one or more of the following :	
1A <sup>a</sup> AAC		in the braze metal	
1A <sup>a</sup> AAD		at the interface and including the diffusion zone	
1A <sup>a</sup> AEE		In the HAZ in the unaffected parent material	
<sup>a</sup> - In the case of an intergranular crack, change this second symbol 'A' to the symbol 'F'. - In the case of a transgranular crack, change this second symbol 'A' to the symbol 'H'.			

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Table 1 — Classification of imperfections (continued)

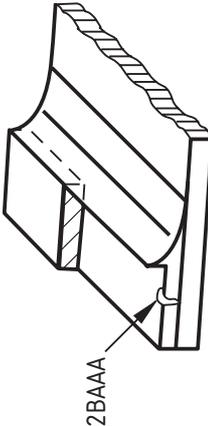
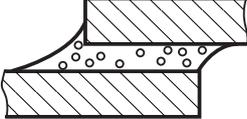
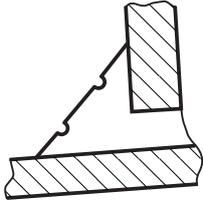
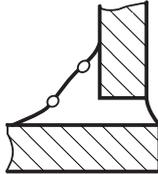
Designation	Description	Remarks	Drawing
<b>II Cavities</b>			
2AAAA	cavity		
2BAAA	gas cavity	Gas-filled cavity	
2BGAA 2BGGA 2BGMA 2BGHA	gas pore	Spheroidal gas inclusion. It can occur as : uniformly distributed porosity localized (clustered) porosity linear porosity	
2LIAA	large gas pockets	Large voids may be the width of the joint with elongated shape	

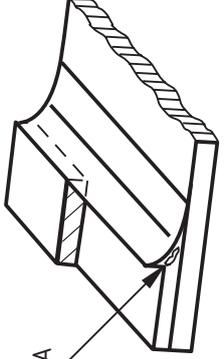
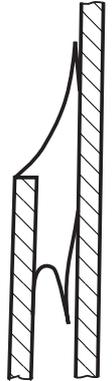
Table 1 — Classification of imperfections (continued)

Designation	Description	Remarks	Drawing
2BALF <sup>b</sup>	surface pore	Gas pore breaking the surface.	
2MGAF <sup>b</sup>	surface bubble	Gas pore near the surface which results in swelling	

<sup>b</sup> These imperfections often occur together.

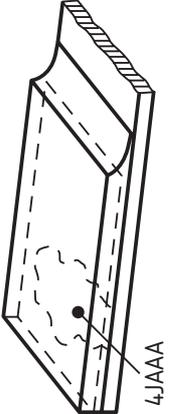
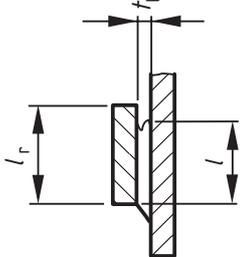
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Table 1 — Classification of imperfections (continued)

Designation	Description	Remarks	Drawing
<b>III. Solid inclusions</b>			
3A AAA	solid inclusion	Inclusion of foreign metal or non-metallic particles in the braze metal May be possible to divide into : oxide inclusion metallic inclusion flux inclusion	
3D AAA			
3F AAA			
3C AAA			
<b>IV Bonding imperfections</b>			
4B AAA	bonding imperfection	No bonding or inadequate bonding between the braze metal and the parent material	

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Table 1 — Classification of imperfections (continued)

Designation	Description	Remarks	Drawing
4JAAA	filling imperfection	Incomplete filling of the gap	 <p>4JAAA</p>
4CAAA	incomplete penetration	The braze metal has failed to flow through the required length of the joint	 <p>The arrow indicates the direction of flow through the joint.</p>

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Table 1 — Classification of imperfections (continued)

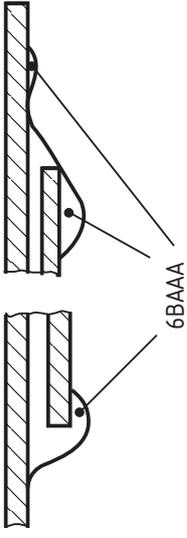
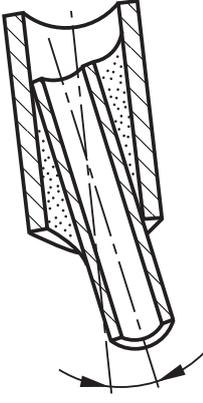
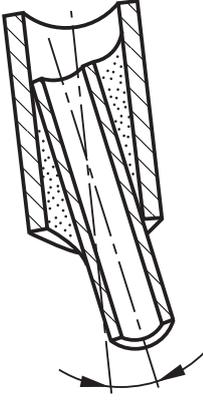
Designation	Description	Remarks	Drawing
<b>V Shape and size imperfections</b>			
6BAAA	excess braze metal	Braze metal has spilled over onto parent material solidifying as a bead or a thick layer	
5AAAA	imperfect shape	Departure from the prescribed shape of the brazed joint	
5EIAA	linear misalignment (linear offset)	The components are parallel but offset	
5EJAA	angular misalignment	The components form an angle deviating from the required value.	
5BAAA	distortion	Unwanted change in the shape of the brazed assembly	

Table 1 — Classification of imperfections (continued)

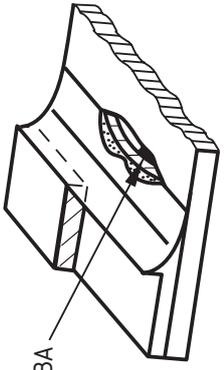
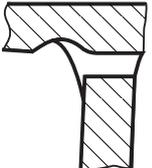
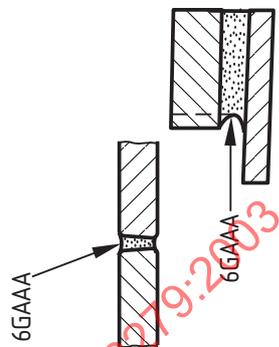
Designation	Description	Remarks	Drawing
5FABA	localized melting (or melt-through)	Through-going hole in the brazed joint or next to it	
7NABD	fused parent material surface	Fused surface of the brazed assembly in the region of the joint	
7OABP	erosion by filler metal	Erosive damage to the surface of the brazed assembly.	
6GAAA	recessed braze metal (recessed fillet)	<p>The surface of the braze metal in the brazed joint is below the required dimension</p> <p>The surface of the braze metal has sunk below the surface of the parent material</p>	

Table 1 — Classification of imperfections (continued)

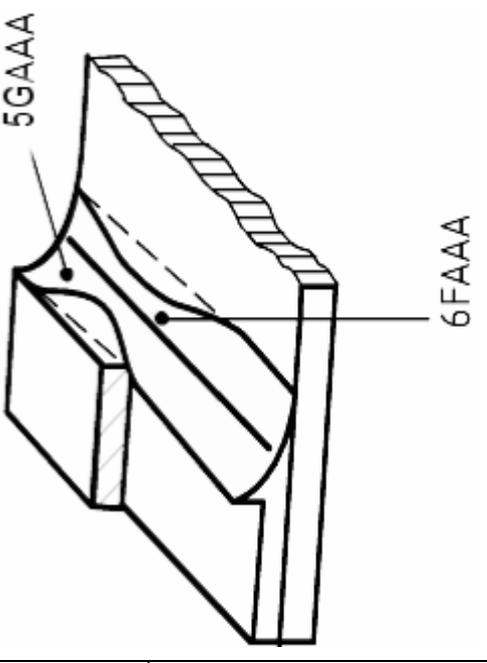
Designation	Description	Remarks	Drawing
5HAAA	rough surface	Irregular solidification, liquation, etc.	
6FAAA	insufficient fillet	Fillet below specified size has formed	
5GAAA	irregular fillet	Appearance of fillet variable	
<b>VI Miscellaneous imperfections</b>			
7AAAA	miscellaneous imperfection	Imperfection that cannot be classified into groups I to V of this table.	

Table 1 — Classification of imperfections (continued)

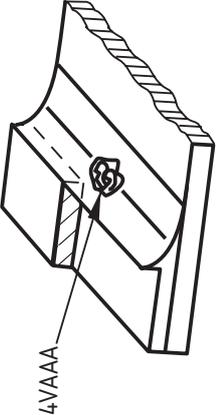
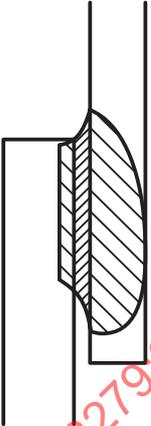
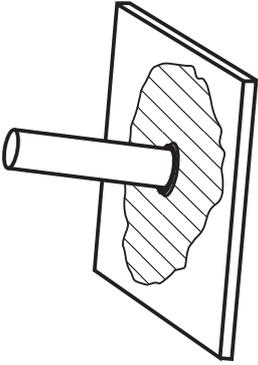
Designation	Description	Remarks	Drawing
4VAAA	flux seepage	Emergence of flux residues at surface pores	
7CAAA	spatter	Drops of braze metal adhering to the surface of the brazed assembly.	
7SAAA	discoloration/oxidation	Oxidation/flux action/deposition of volatilized filler metal or parent material on the surface.	
7UAAC	excessive alloying of parent and filler materials	Associated with excess of heat, time and/or filler materials	
9FAAA	flux residue	Flux that has not been removed	

Table 1 — Classification of imperfections (continued)

Designation	Description	Remarks	Drawing
7QAAA	excessive braze metal flow	excessive braze metal flow	
9KAAA	etch marking	Reaction with flux on the parent material surface	

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## Annex A (informative)

### Guidelines for practical evaluation of imperfections

Before undertaking an evaluation of imperfections, there is a crucial need for a carefully detailed review of all the relevant factors to avoid subsequent expensive errors. Although not specifically within the scope of this standard, this review also needs to cover the requirements for applicable test methods, e.g. those in EN 12797 and EN 12799.

It is essential to recognize the importance of carrying out a realistic view of relevant imperfections, e.g. if the brazed assembly needs to hold a high internal vacuum, gas pores do not play an important role as long as the assembly is leak-proof. This applies equally to the choice of tests to prove the suggested imperfections. They have to be selected taking into account the requirements in service. The primary requirements have always to be borne in mind and given priority.

In brazing, imperfections typically found in welds do not occur. Furthermore, the occurrence of imperfections in brazing often has a different importance than it has in welding. As an example of this, in general terms a fill proportion of about 60 % in a brazed tube joint is sufficient in a large range of applications. As a consequence of factors such as these, in certain instances it will be necessary to carry out a realistic choice of tests on actual-sized brazed assemblies. A consequence of this is that extraordinary testing may at best be merely a waste of money and at worst dangerously misleading.

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## Annex B (informative)

### Evaluation

The evaluation of brazed joints should account for each imperfection in table 1, the actual joint being assigned to one of three quality levels with the symbol B, C or D (see table B.1). Joints should be examined after the application of any post braze cleaning process.

**Table B .1 — Quality levels for brazed joint imperfections**

Level symbol	Quality level
D	Moderate
C	Intermediate
B	Stringent

The three quality levels are arbitrarily identified as D, C and B and are intended to cover the majority of practical applications. Level symbol A is intended to relate to especially stringent applications and for these the limits for imperfections are to be established for the specific application.

Where necessary, requirements may be more precisely defined. Combination of imperfections should be considered when setting the levels required.

It is permitted to specify that certain imperfections be in compliance with a different quality level, this being stated in the relevant documentation.

Assignment to a particular quality level should also take account of the component material and design, the brazing manufacturing methods used, the service conditions and the performance of the joint in service.

Suggested limits for imperfections are given in table B.2

Extreme caution should be exercised in implementing the suggested limits for imperfections detailed in table B.2, particularly for existing designs that have proved satisfactory in service. Joint re-design may be found necessary to meet these limits but the need to do so should be seriously questioned if service experience has been satisfactory with the current design and standards of work.

Table B.2 — Suggested limits for imperfections

Designation	Description	Suggested limits for imperfections for quality levels		
		Moderate D	Intermediate C	Stringent B
I Cracks				
1AAAA	crack	Permissible where component function is not adversely affected	Not permissible	Not permissible
1AAAB				
1AAAC				
1AAAD				
1AAAE				
II Cavities				
2AAAA	cavity			
2BAAA	gas cavity	Max. 40 % of the projected area.	Max. 30 % of the projected area.	Max. 20 % of the projected area.
2BGAA	gas pore	Max. 40 % of the projected area.	Max. 30 % of the projected area.	Max. 20 % of the projected area.
2BGGA		Max. permissible pore diameter or pore area may be defined for special applications	Max. permissible pore diameter or pore area may be defined for special applications	Max. permissible pore diameter or pore area may be defined for special applications
2BGMA				
2BGHA				

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Table B.2 — Suggested limits for imperfections (continued)

Designation	Description	Suggested limits for imperfections for quality levels		
		Moderate D	Intermediate C	Stringent B
2LIAA	large gas pockets	Max. 40 % of the projected area. Max. permissible pore diameter or pore area may be defined for special applications	Max. 30 % of the projected area. Max. permissible pore diameter or pore area may be defined for special applications	Max. 20 % of the projected area. Max. permissible pore diameter or pore area may be defined for special applications
2BALF	surface pore	Permissible where component function is not adversely affected	Max. 20 % of the projected area permissible where component function is not adversely affected	Not permissible
2MGAF	surface bubble	Permissible	Permissible	Not permissible
III Solid inclusions				
3AAAA	solid inclusion	Max. 40 % of the projected area.	Max. 30 % of the projected area.	Max. 20 % of the projected area.
3DAAA		Max. permissible diameter or area of solid inclusion may be defined for special applications	Max. permissible diameter or area of solid inclusion may be defined for special applications	Max. permissible diameter or area of solid inclusion may be defined for special applications
3FAAA				
3CAAA				