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**Welding and allied processes — Welding  
positions**

*Soudage et techniques connexes — Positions de soudage*





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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

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 6947 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 7, *Representation and terms*.

This third edition cancels and replaces the second edition (ISO 6947:1990), which has been technically revised.

Requests for official interpretations of any aspect of this International Standard should be directed to the Secretariat of ISO/TC 44/SC 7 via your national standards body. A complete listing of these bodies can be found at [www.iso.org](http://www.iso.org).

## Introduction

This International Standard provides positions for standard discrete test piece orientation PA, PB, H-L045, etc. that have been specified in this International Standard since the first edition (ISO 6947:1980).

In this revision, positions are defined for production welding. These positions are flat, horizontal, vertical, and overhead. Unlike testing positions, these positions are contiguous.

The direction of welding is an essential parameter for determining the welding position, e.g. up or down.

The welding position is not dependent on the geometrical arrangement of the joint, e.g. butt or fillet joint, or that of the semi-finished product. Welds of all types and in all directions are covered.

The main positions have been given symbols which can easily be used for designation purposes; these symbols were chosen independently of possible meaningful abbreviations, i.e. they are not derived from any particular language.

The relationship between testing positions and production welding positions is specified elsewhere, e.g. in ISO 9606<sup>[1]</sup> or ISO 15614<sup>[2]</sup>.

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# Welding and allied processes — Welding positions

## 1 Scope

This International Standard defines welding positions for testing and production, for butt and fillet welds, in all product forms.

Annex A gives examples of the limits of the slope of a weld axis and the rotation of the weld face about the weld axis for welding positions in production welds.

Annex B provides a comparison of International, European and US designations.

## 2 Terms and definitions

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

### 2.1

#### welding position

position of a weld in space, which is defined relative to the slope of the axis and rotation of the face of the weld relative to the horizontal plane

### 2.2

#### main welding position

welding position, designated PA, PB, PC, PD, PE, PF or PG

NOTE For PA, PB, PC, PD and PE, see Figure 1.

### 2.3

#### slope

*S*

angle of the axis of the weld relative to the main welding position

### 2.4

#### rotation

*R*

angle of the face of the weld relative to the main welding position

### 2.5

#### inclined angle

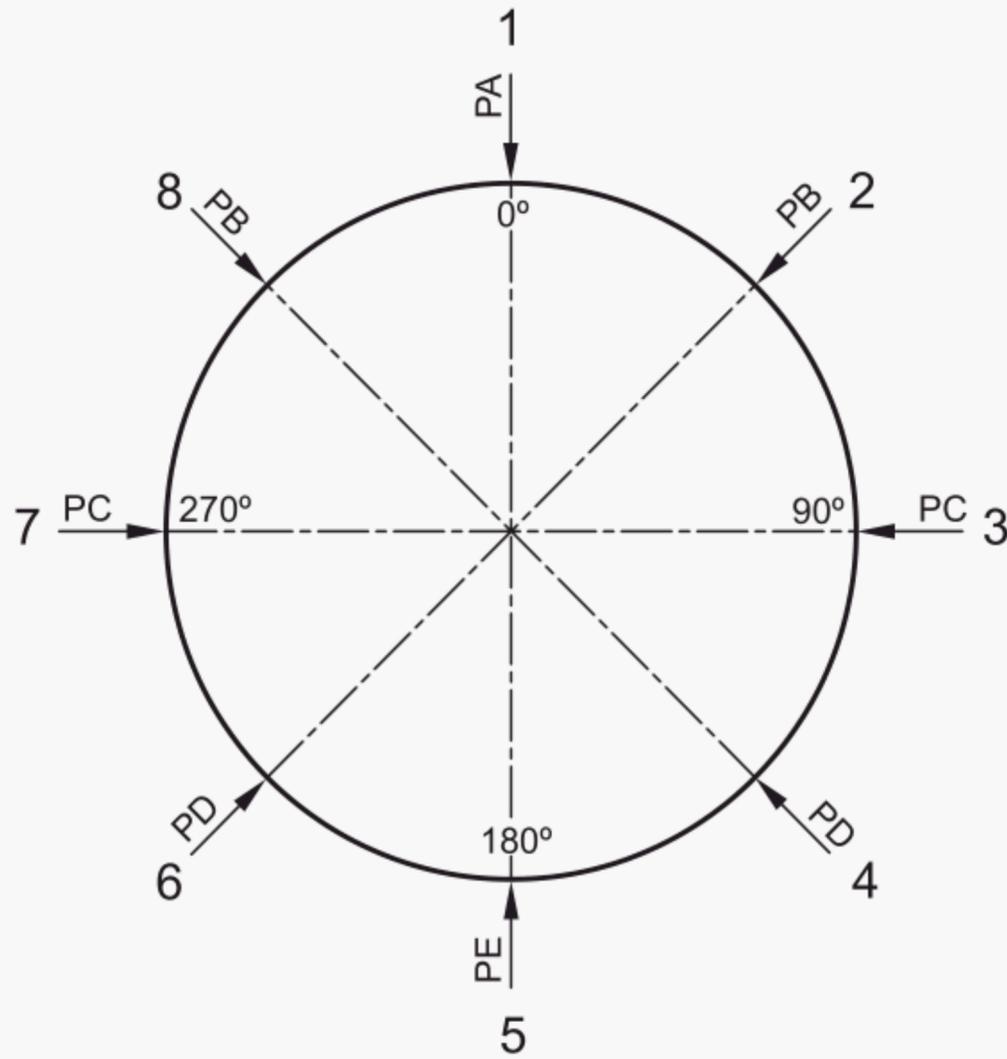
*L*

angle of the axis of the pipe

## 3 Welding positions

### 3.1 Main welding positions

The main welding positions are illustrated in Figure 1 with examples of their application for butt and fillet welds in Figure 2.

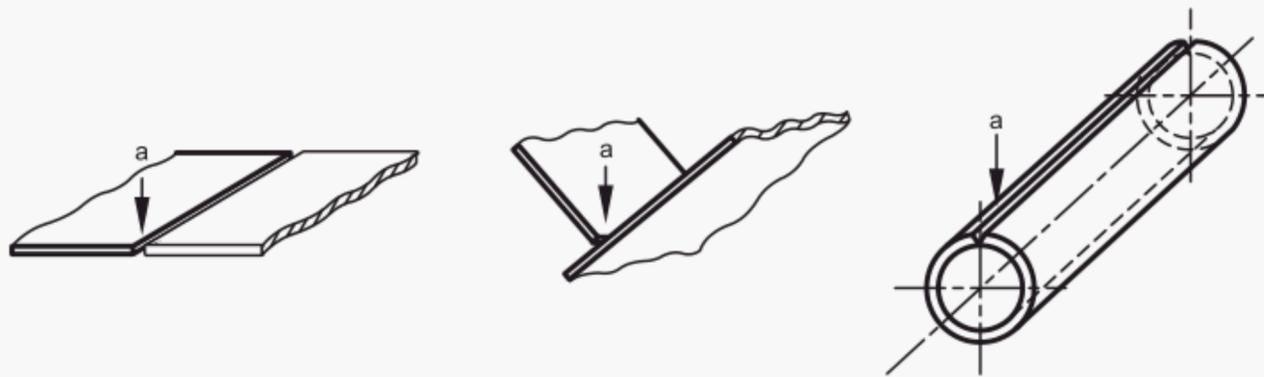


**Key**

1	flat	4 and 6	horizontal overhead
2 and 8	horizontal vertical	5	overhead
3 and 7	horizontal		

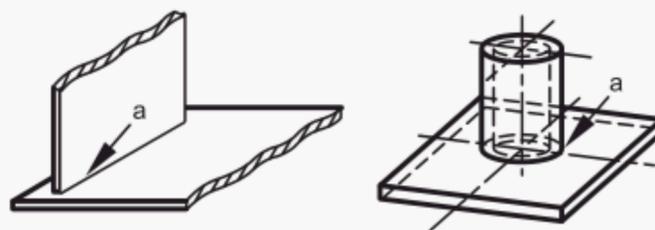
**Figure 1 — Main welding positions**

Examples of main welding positions for butt and fillet welds are illustrated in Figure 2.



a Arrow shows welding position.

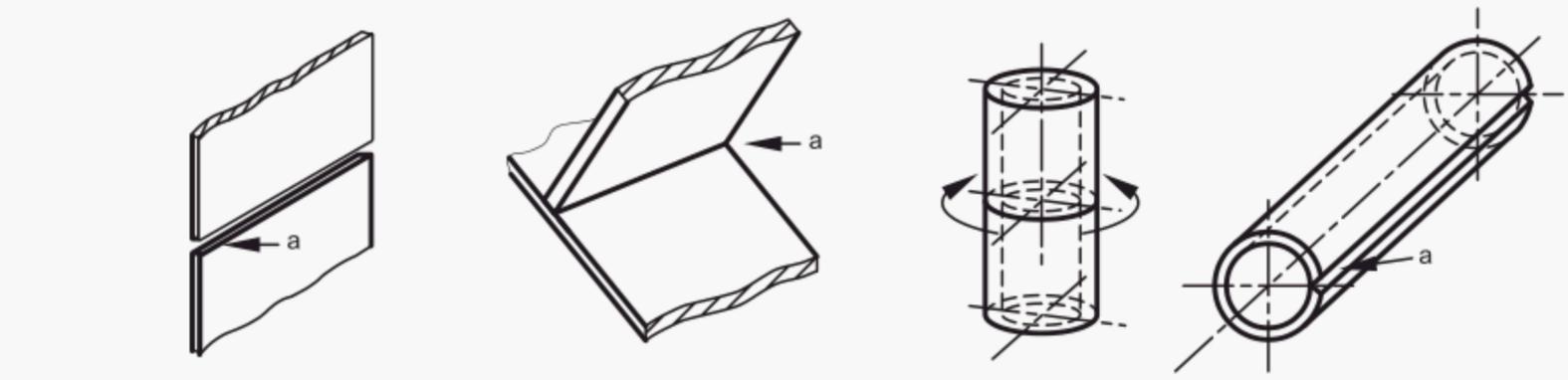
**a) PA: flat position**



a Arrow shows welding position.

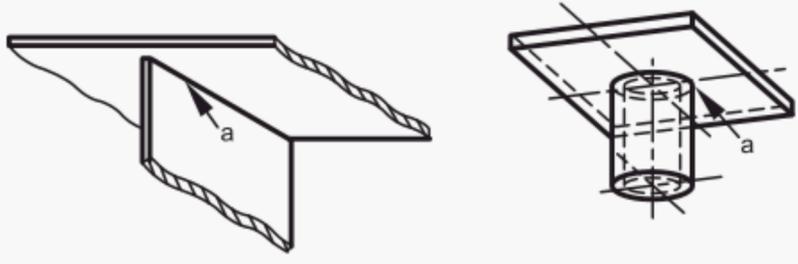
**b) PB: horizontal vertical position**

**Figure 2 — Examples of main welding positions (continued)**



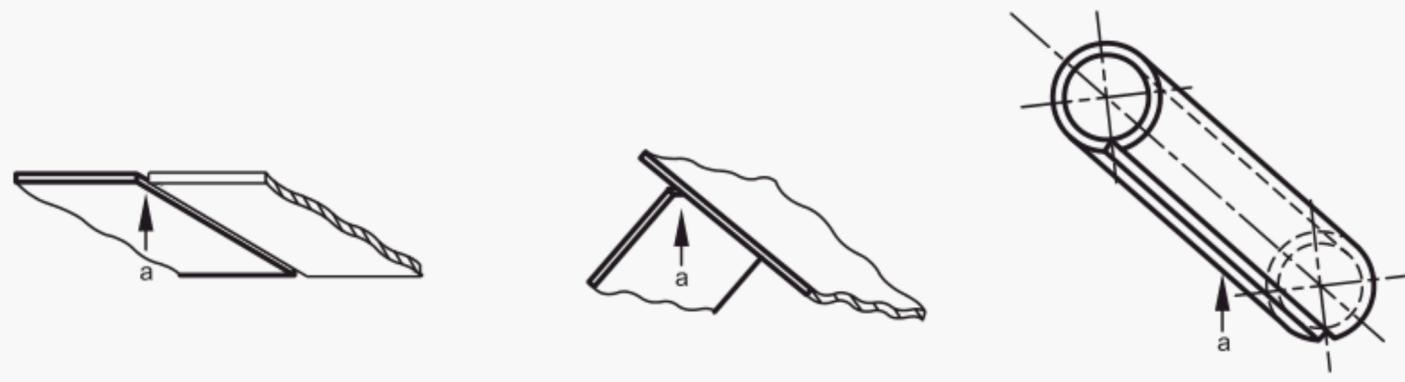
a Arrow shows welding position.

**c) PC: horizontal position**



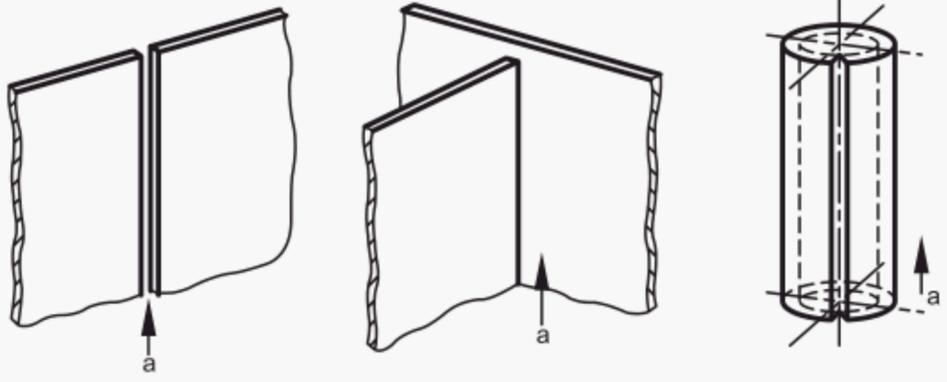
a Arrow shows welding position.

**d) PD: horizontal overhead position**



a Arrow shows welding position.

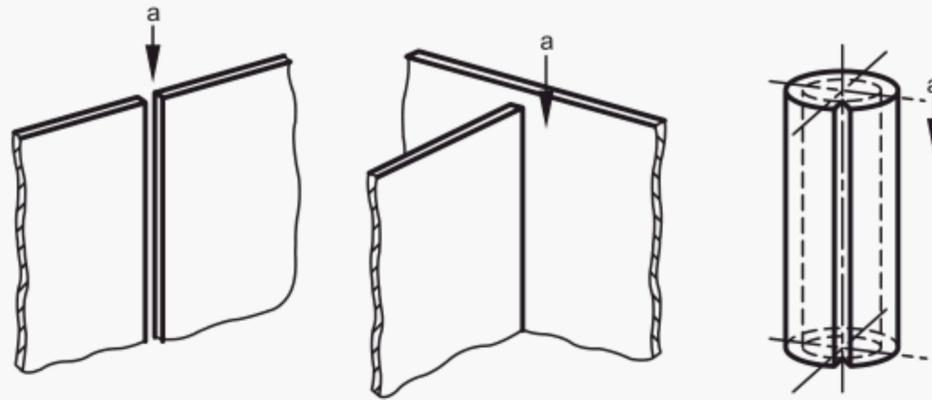
**e) PE: overhead position**



a Arrow shows weld progression or direction.

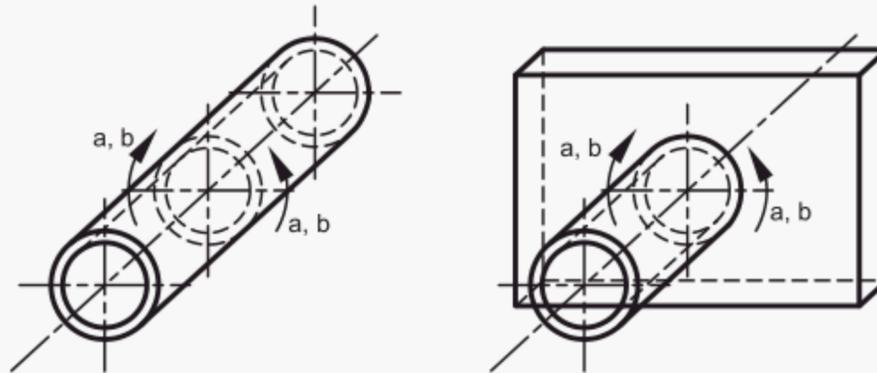
**f) PF: vertical up position**

**Figure 2 — Examples of main welding positions (continued)**



a Arrow shows weld progression or direction.

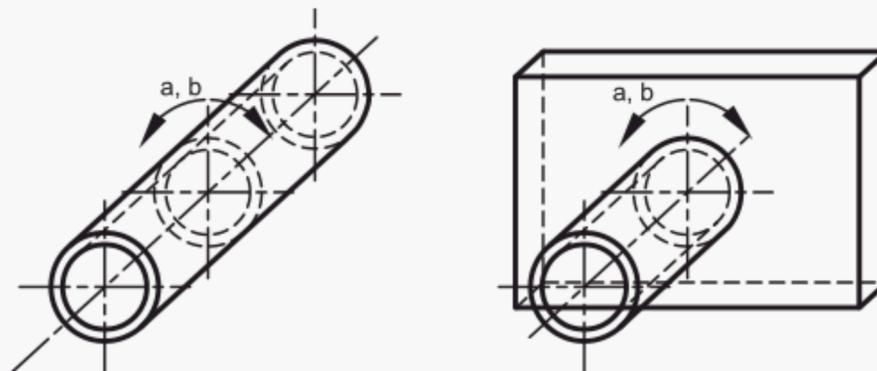
**g) PG: vertical down position**



a Arrow shows weld progression or direction.

b For special purposes, e. g. testing of welders; this position is regarded as a main position.

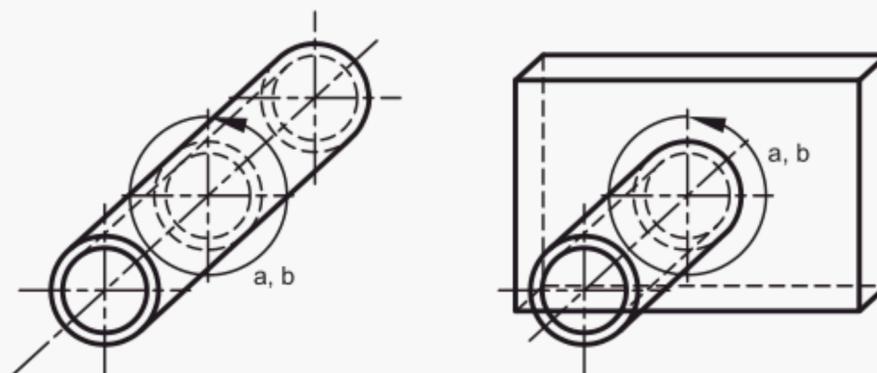
**h) PH: pipe position for welding upwards**



a Arrow shows weld progression or direction.

b For special purposes, e. g. testing of welders; this position is regarded as a main position.

**i) PJ: pipe position for welding downwards**



a Arrow shows weld progression or direction.

b For special purposes, e. g. testing of welders; this position is regarded as a main position.

**j) PK: pipe position for orbital welding**

**Figure 2 — Examples of main welding positions**

### 3.2 Welding positions for production

Main welding positions can be used in other standards, e.g. ISO 9606<sup>[1]</sup>, ISO 15614<sup>[2]</sup>, to define the orientation of welds in production welding after qualifying in one of the main welding positions PA, PB, H-L045, etc. Slope and rotation ranges for welding positions in production are given in Table 1 for butt welds and in Table 2 for fillet welds (see also examples in Annex A).

NOTE For asymmetric tolerances, plus means revolving the weld surface towards the main welding position PA and minus towards the main welding position PE.

**Table 1 — Slope and rotation ranges for welding positions in production butt welds**

Welding position	Main welding position	Slope <i>S</i>	Rotation <i>R</i>
Flat	PA	±15°	±30°
Horizontal	PC	±15°	+60° -10°
Overhead	PE	±80°	±80°
Vertical	PF, PG	+75° -10°	±100° ±180°

**Table 2 — Slope and rotation ranges for welding positions in production fillet welds**

Welding position	Main welding position	Slope <i>S</i>	Rotation <i>R</i>
Flat	PA	±15°	±30°
Horizontal vertical	PB	±15°	+15° -10°
Horizontal	PC	±15°	+35° -10°
Horizontal overhead	PD	±80°	+35° -10°
Overhead	PE	±80°	±35°
Vertical	PF, PG	+75° -10°	±100° ±180°

### 3.3 Welding positions for testing

Welding positions used during welding of a test piece shall not exceed ±5° in slope and ±10° in rotation from the main welding position.

## 4 Designation

Main welding positions shall be designated by the appropriate symbol in accordance with Figures 1 and 2 (see Example 1). The symbol for the main welding position may be supplemented by the values for slope and rotation, given in three digits (see Example 2).

For circumferential welds in pipes with inclined axes, the indication of slope and rotation shall be simplified in accordance with Figures 1 and 2 (see Examples 3 and 4).

## ISO 6947:2011(E)

EXAMPLE 1 The main welding position “horizontal vertical” (PB) shall be designated as follows:

**PB**

EXAMPLE 2 The main welding position “horizontal vertical” (PB), with slope of 15° and rotation of 10°, shall be designated as follows:

**PB 015-010**

EXAMPLE 3 The welding position on pipes with inclined axes, with welding direction “welding up” (H) and an inclined angle of 30°, shall be designated as follows:

**H-L030**

EXAMPLE 4 The welding position on pipes with inclined axes, with welding direction “welding down” (J) and an inclined angle of 60°, shall be designated as follows:

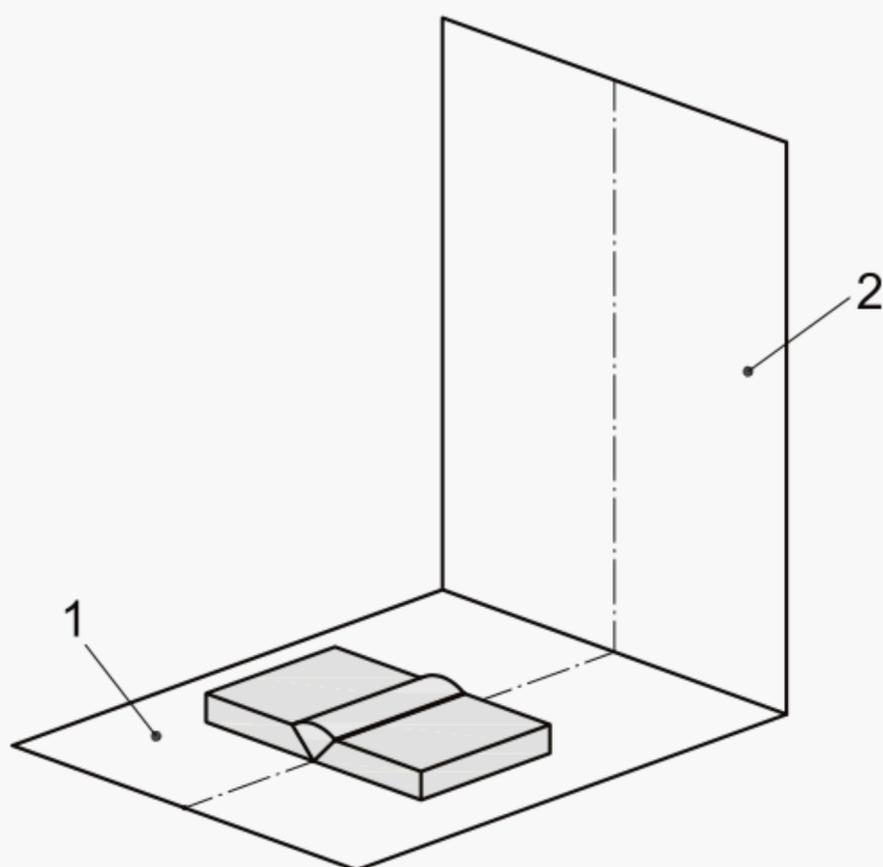
**J-L060**

## Annex A (informative)

### Limits of the slope of a weld axis and the rotation of the weld face about the weld axis for welding positions in production welds

This annex describes, through a series of sketches, the limits of the slope of a weld axis and the rotation of the weld face about the weld axis for welding positions in production welds (see 3.2 and Tables 1 and 2).

Figures A.1 to A.15 show sketches for butt welds and Figures A.16 to A.21 show sketches for fillet welds.



#### Key

- 1 horizontal plane
- 2 vertical plane

Figure A.1 — Main welding position (PA)

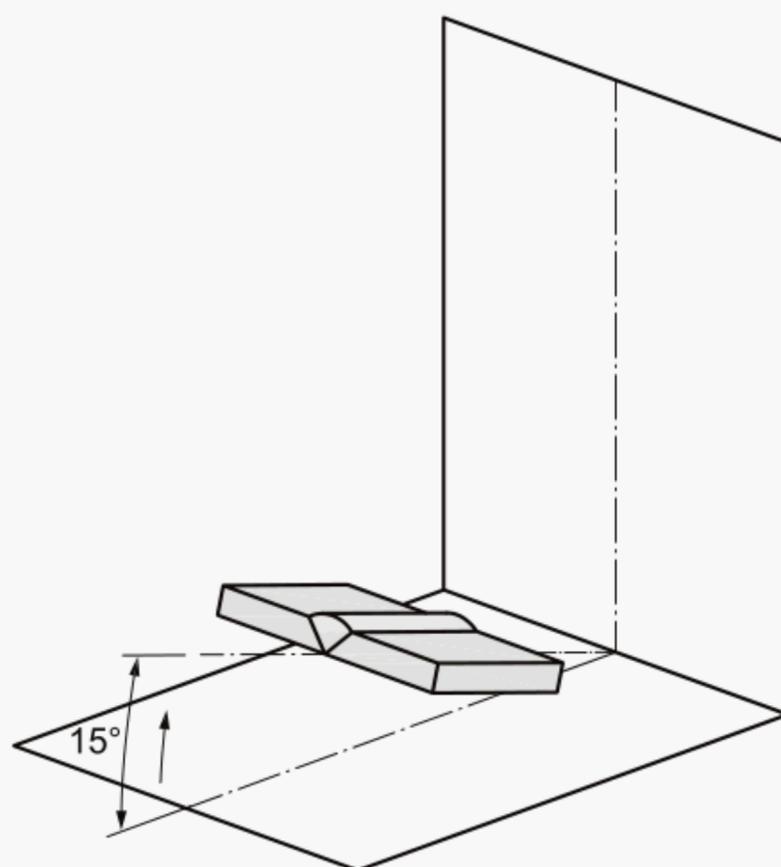


Figure A.2 — Flat position (PA) slope limit

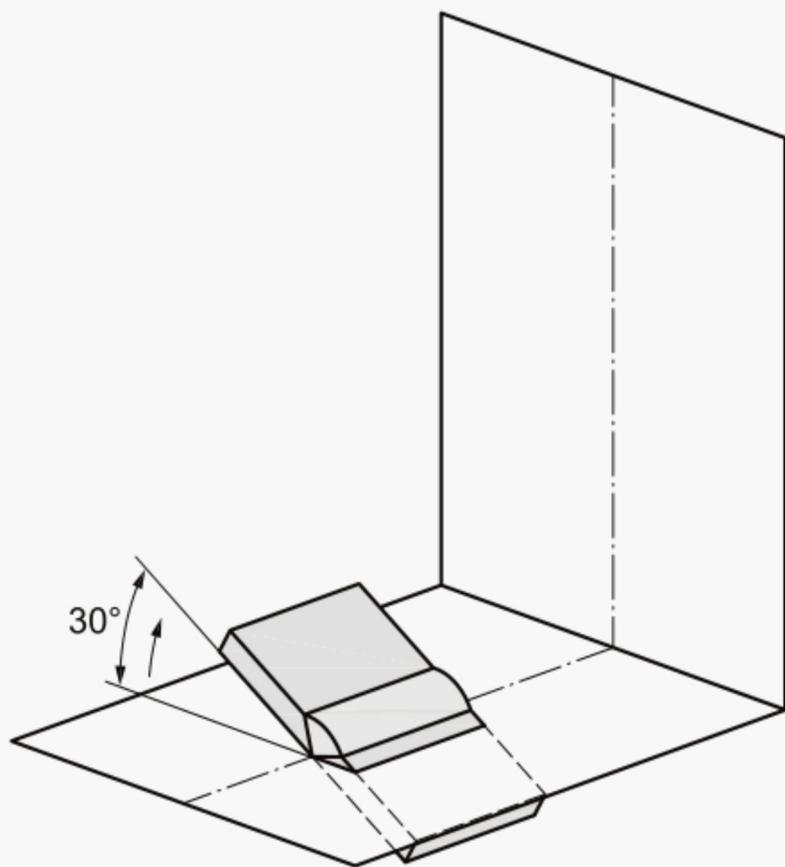


Figure A.3 — Flat position (PA) rotation limit

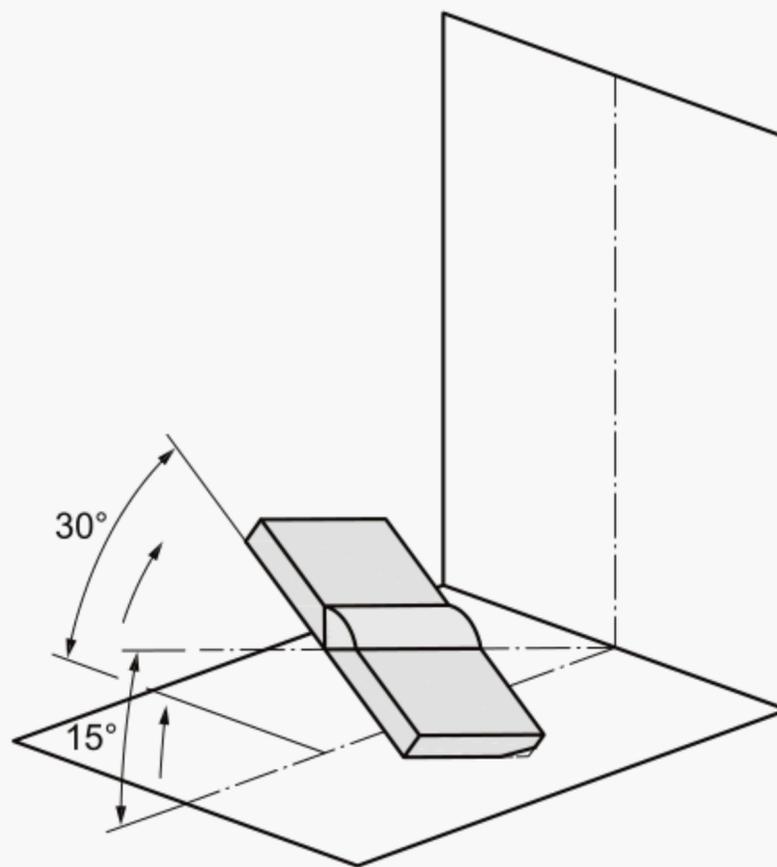


Figure A.4 — Flat position (PA) slope limit and rotation limit

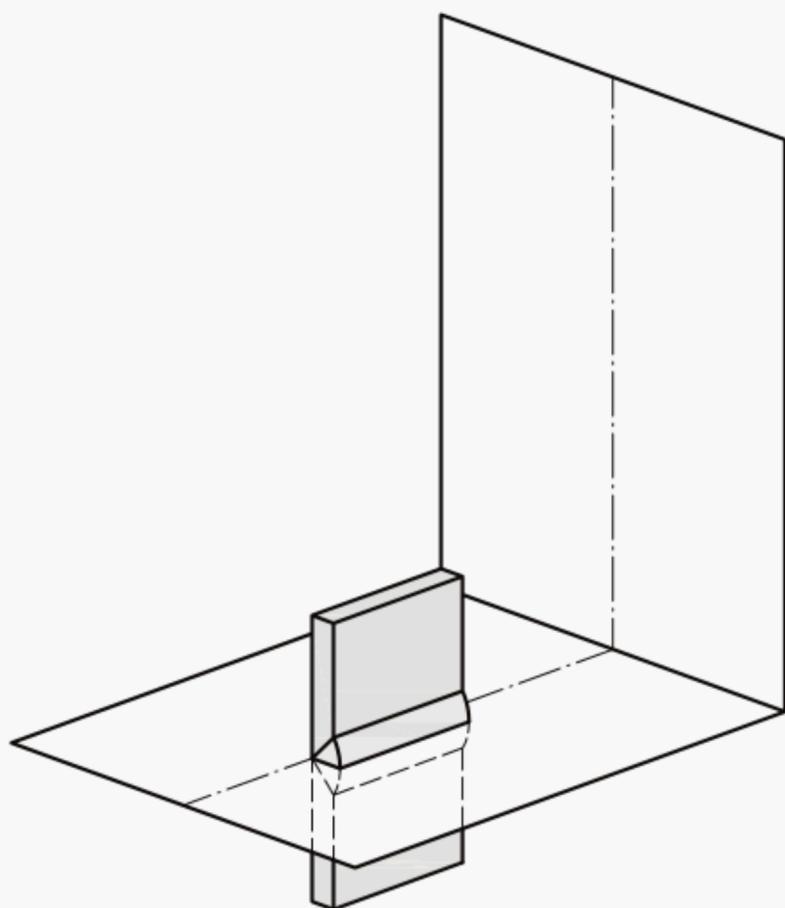


Figure A.5 — Main welding position (PC)

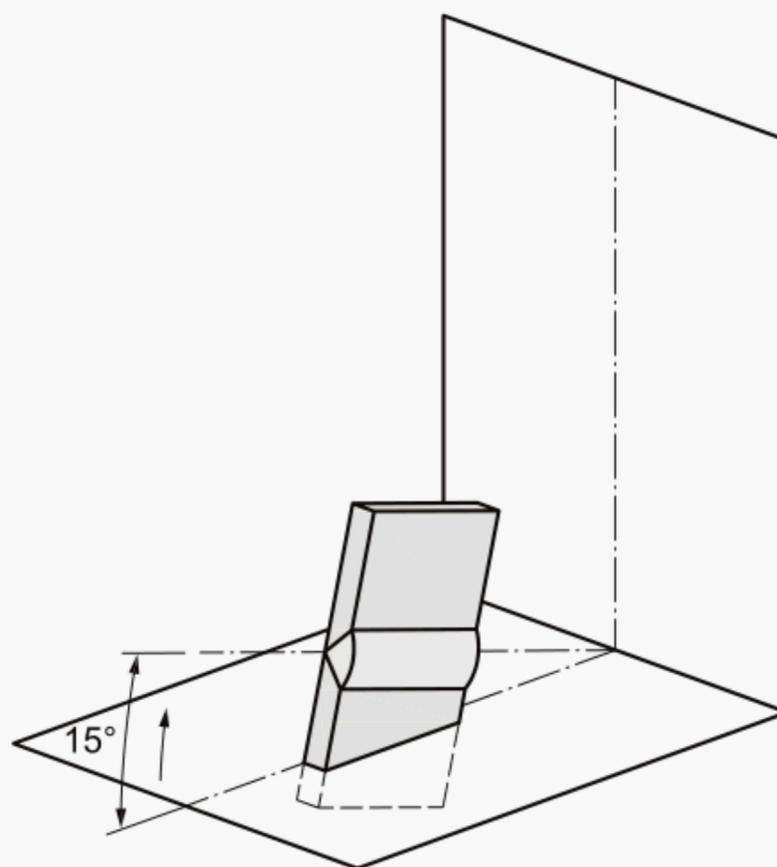


Figure A.6 — Horizontal position (PC) slope limit

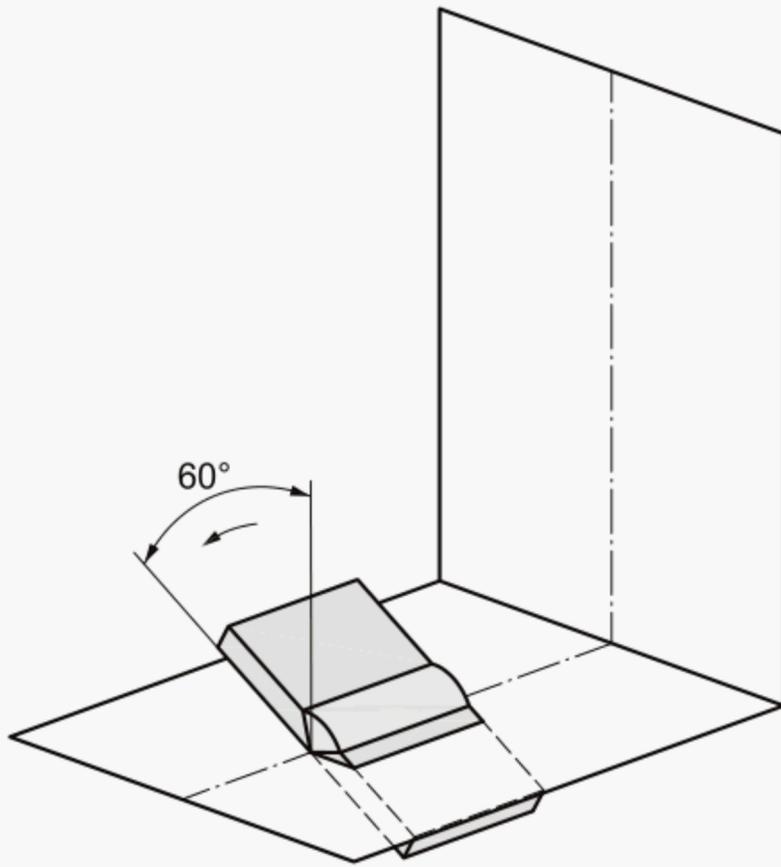


Figure A.7 — Horizontal position (PC)  
rotation limit (+60°)

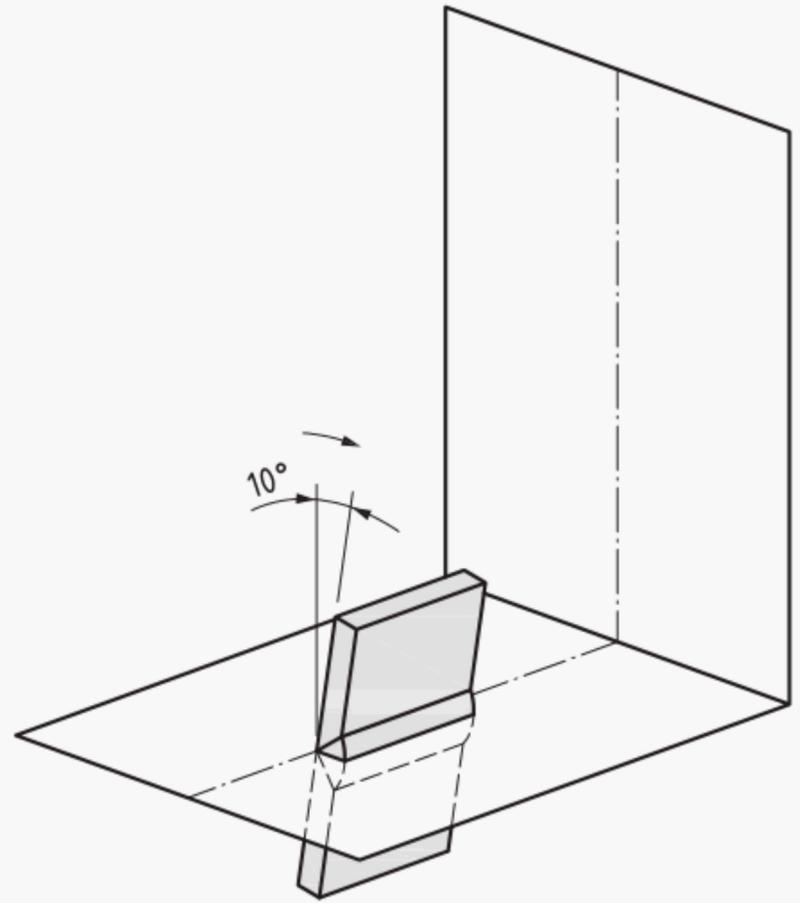


Figure A.8 — Horizontal position (PC)  
rotation limit (-10°)

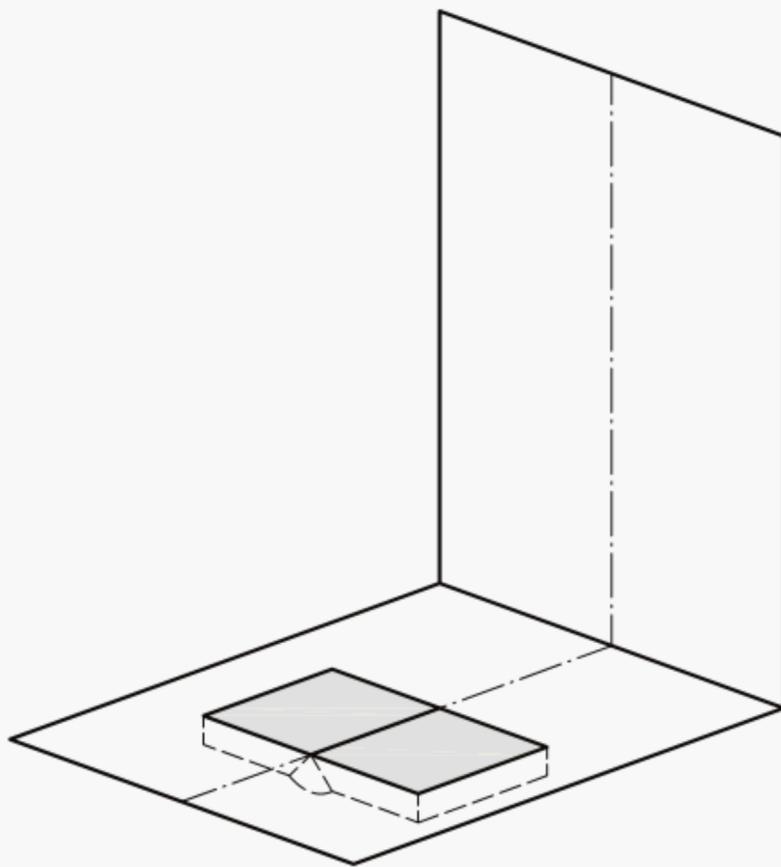


Figure A.9 — Main welding position (PE)

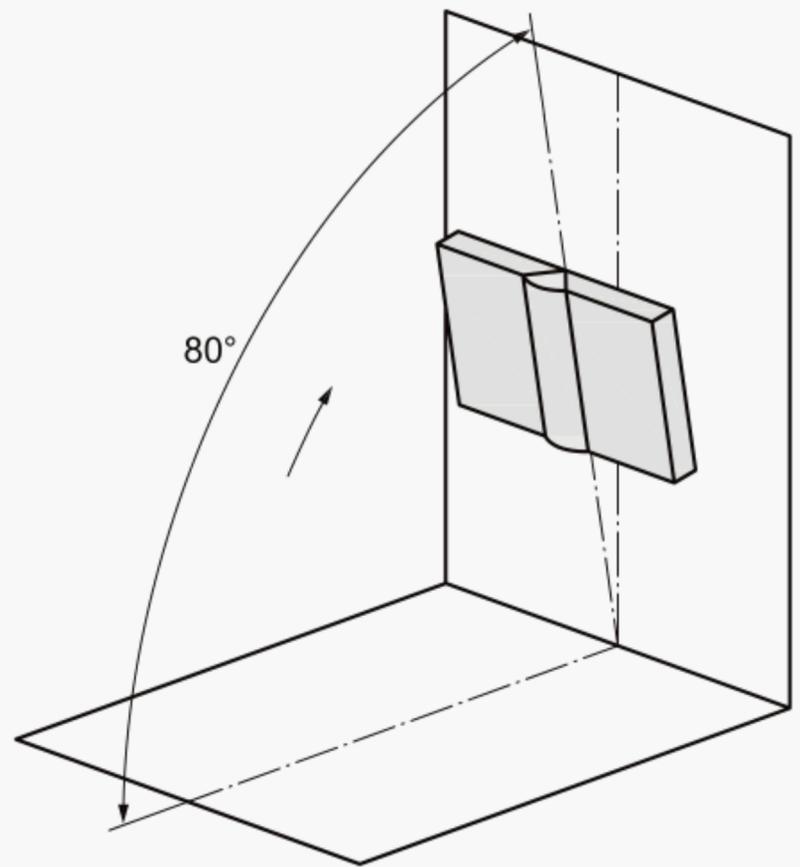


Figure A.10 — Overhead position (PE) slope limit

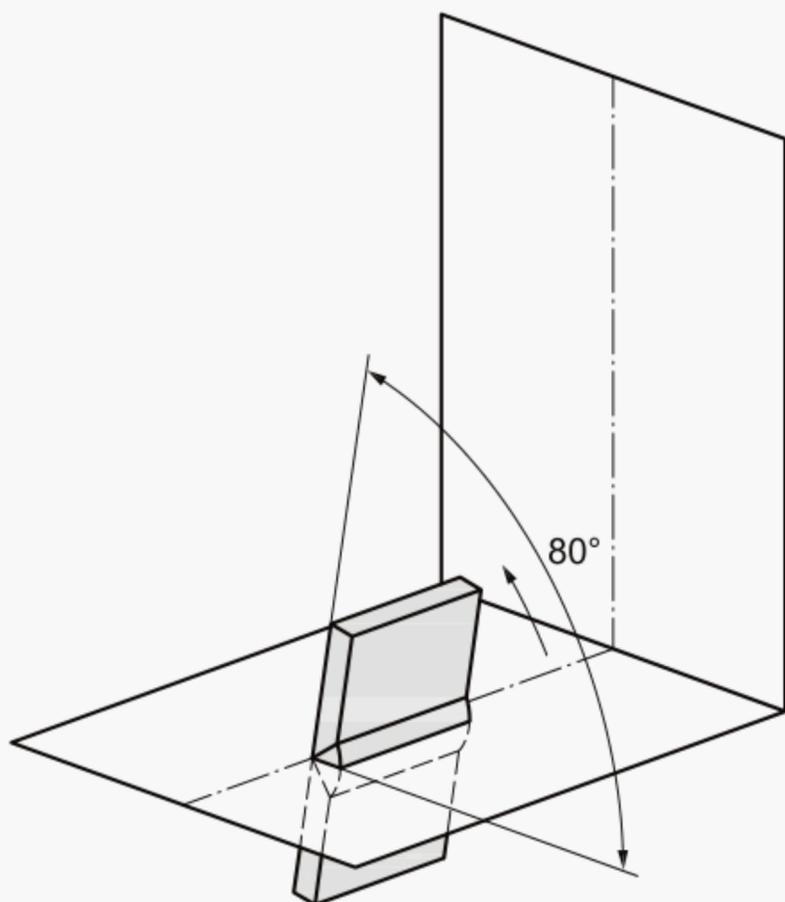


Figure A.11 — Overhead position (PE) rotation limit

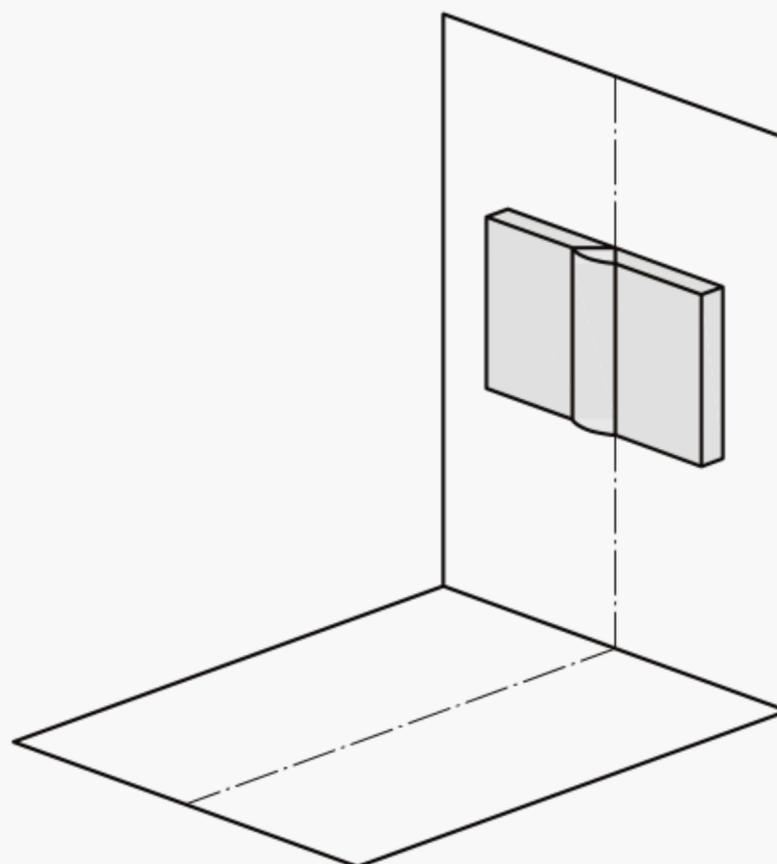


Figure A.12 — Main welding position (PF, PG)

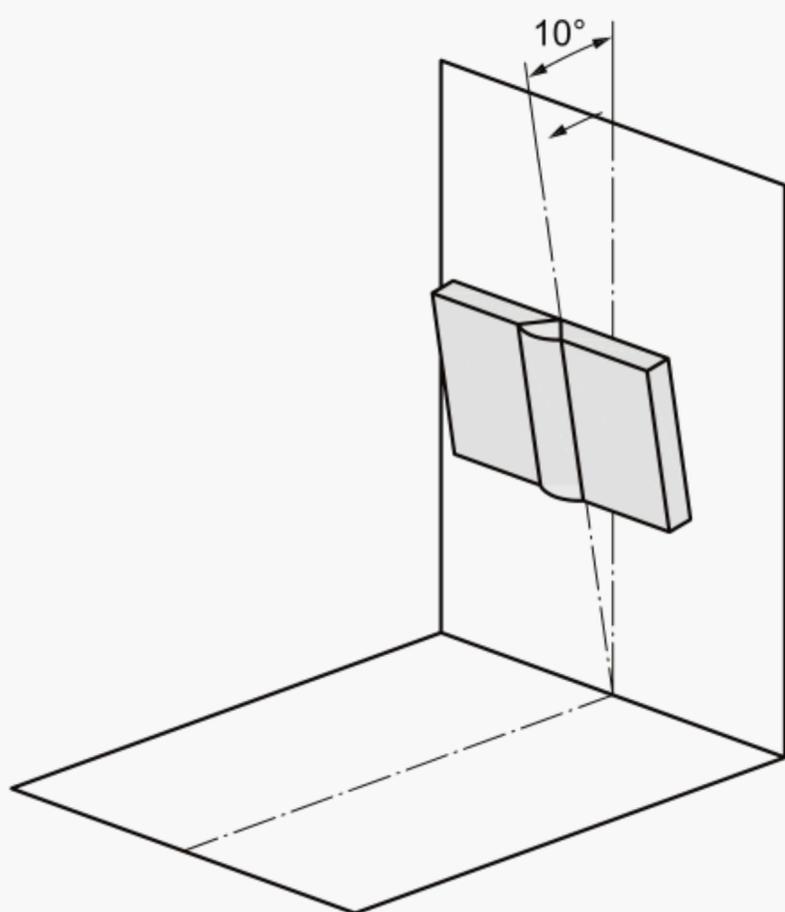


Figure A.13 — Welding position (PF, PG) slope limit

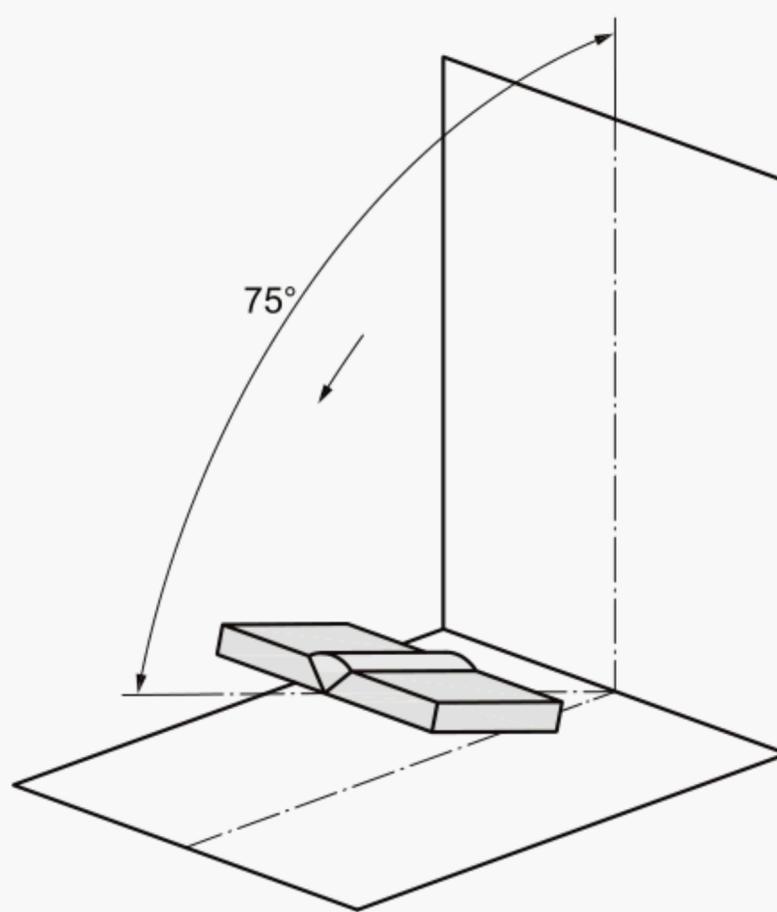


Figure A.14 — Welding position (PF, PG) slope limit

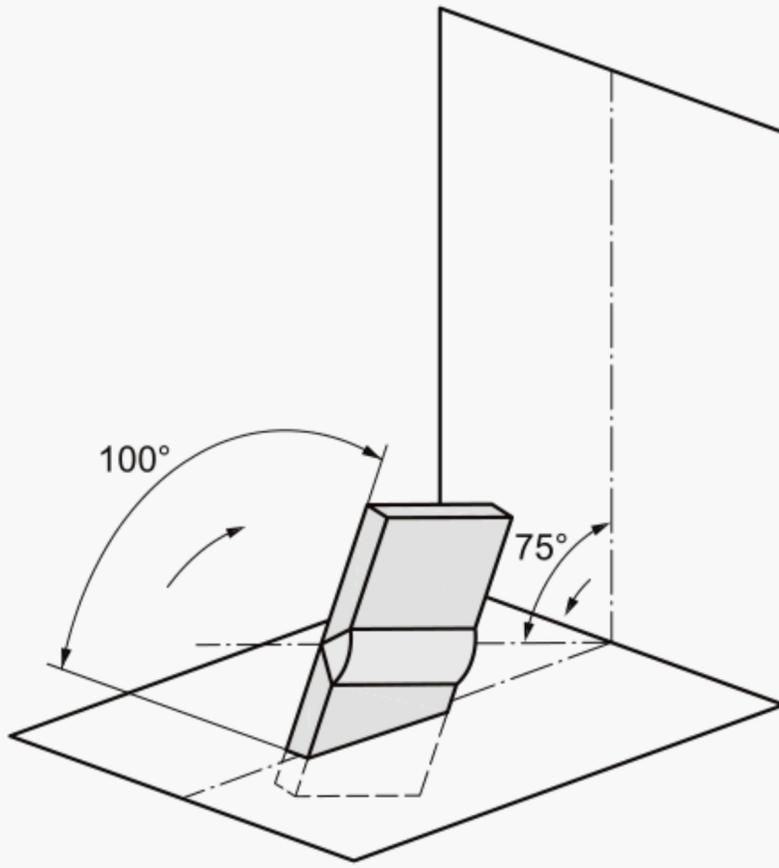


Figure A.15 — Welding position (PF, PG) slope limit and rotation limit

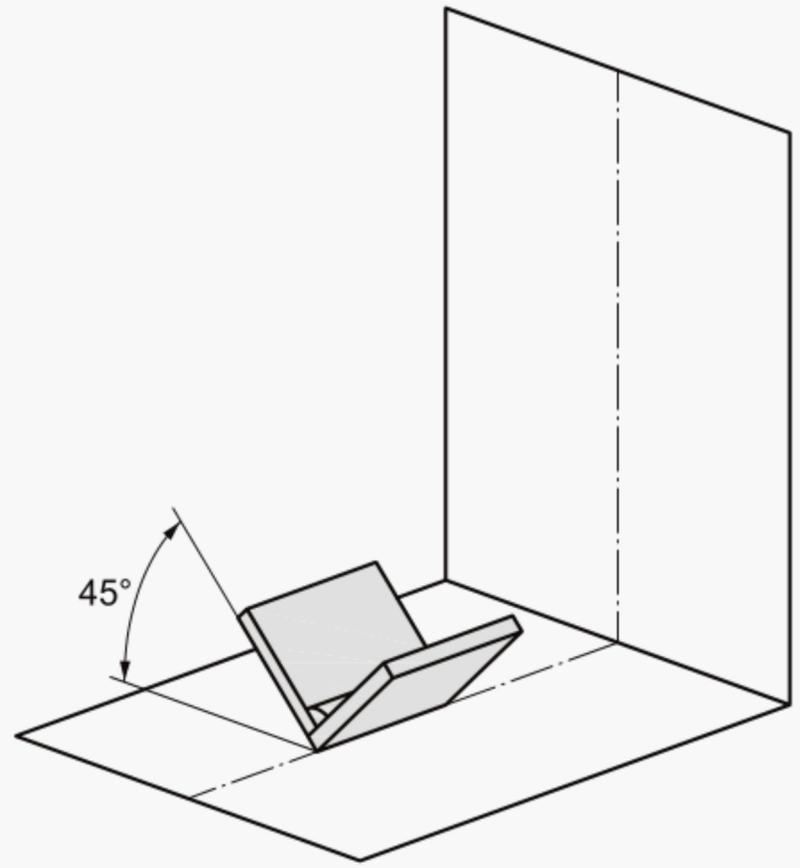


Figure A.16 — Main welding position (PA)

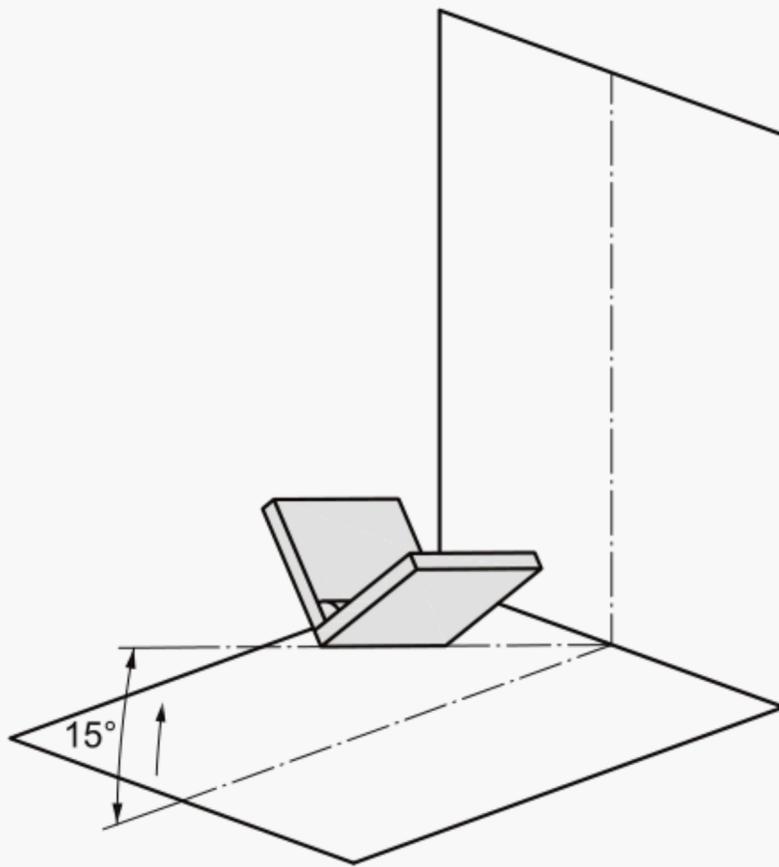


Figure A.17 — Welding position (PA) slope limit

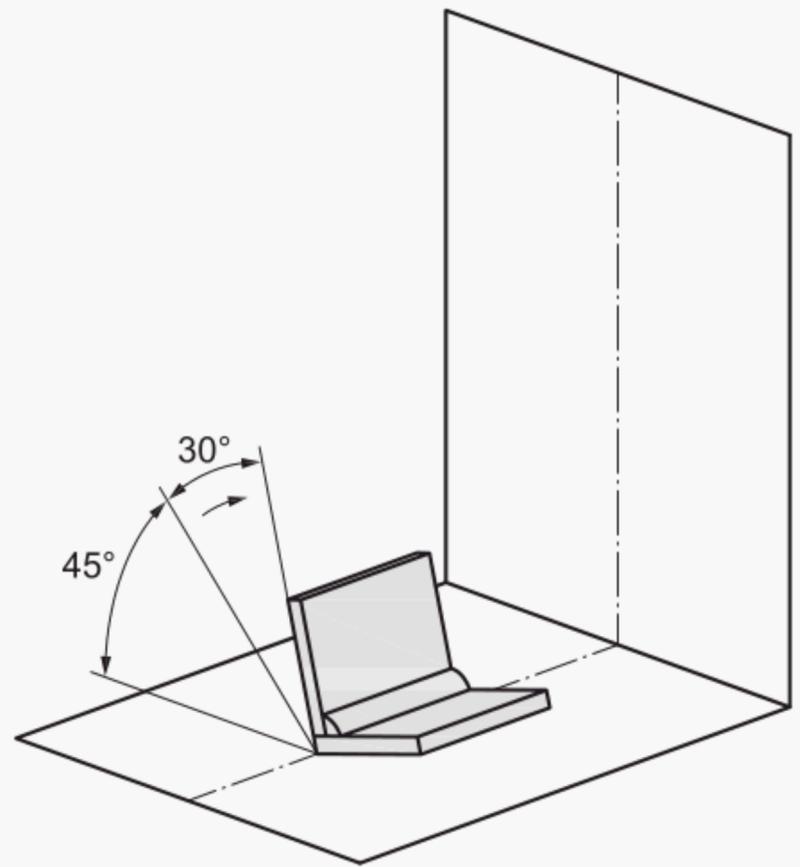


Figure A.18 — Welding position (PA) rotation limit

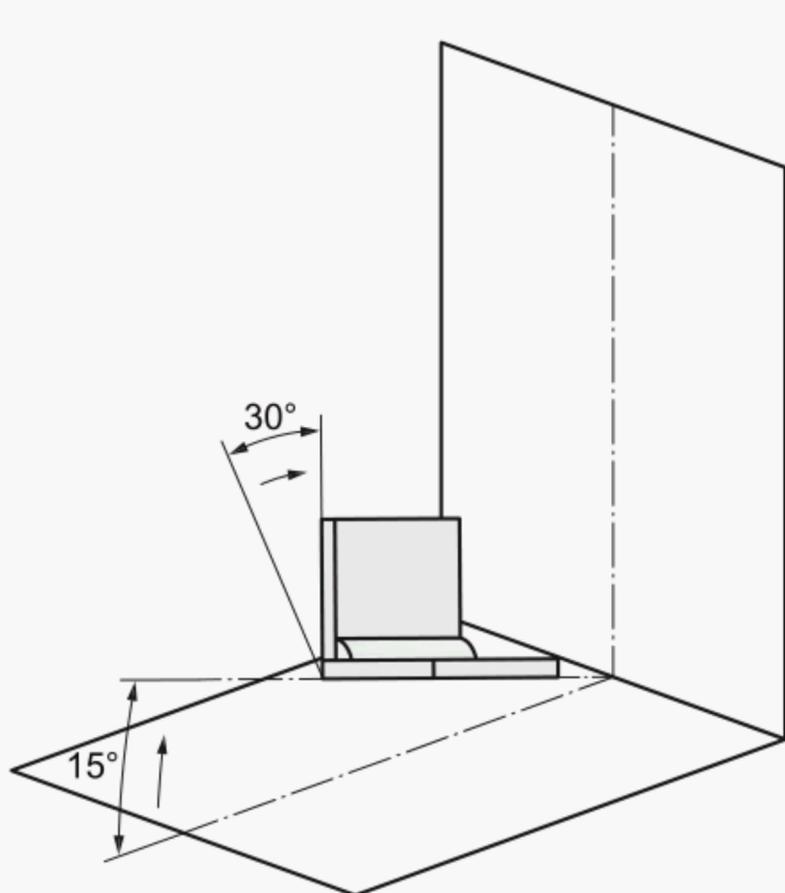


Figure A.19 — Welding position (PA) slope limit and rotation limit

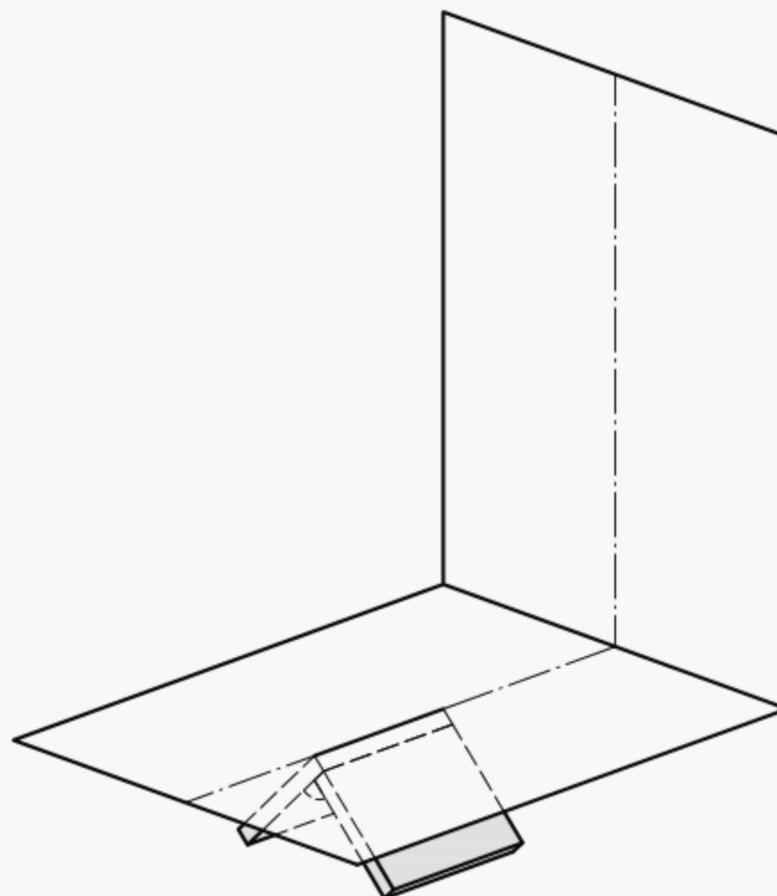


Figure A.20 — Main welding position (PE)

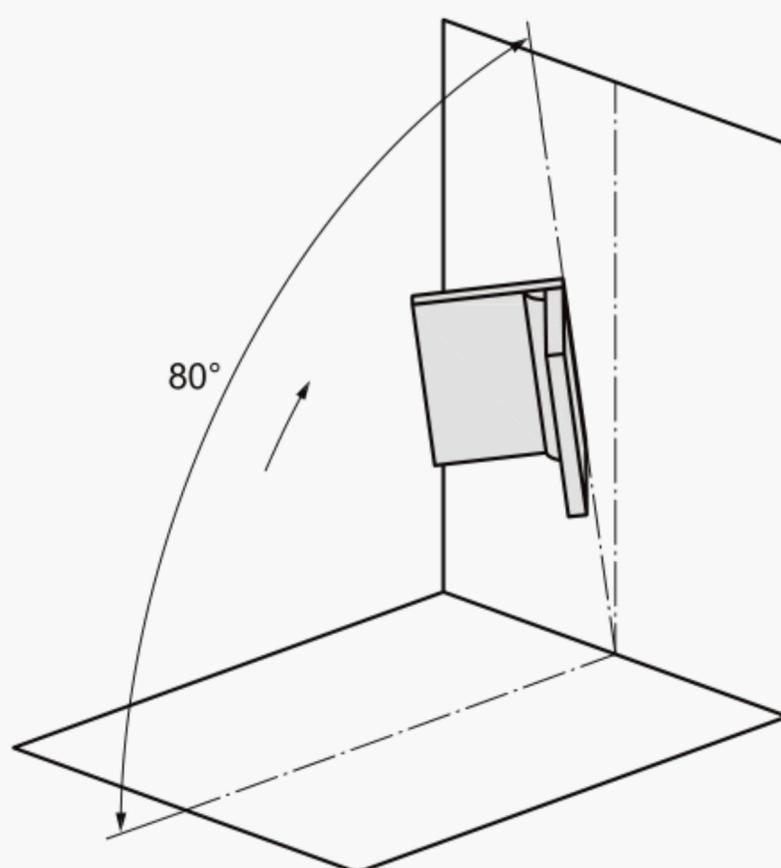


Figure A.21 — Overhead welding position (PE) slope limit

**Annex B**  
(informative)

**Comparison of international, European and US designations**

Table B.1 provides a comparison between the common welding positions shown in this International Standard and the joint orientations shown in AWS A3.0<sup>[4]</sup> and ASME Section IX<sup>[3]</sup>.

NOTE This annex is based on CEN/TR 14633<sup>[5]</sup>.

**Table B.1 — Comparison of international, European and US designations for working and welding positions**

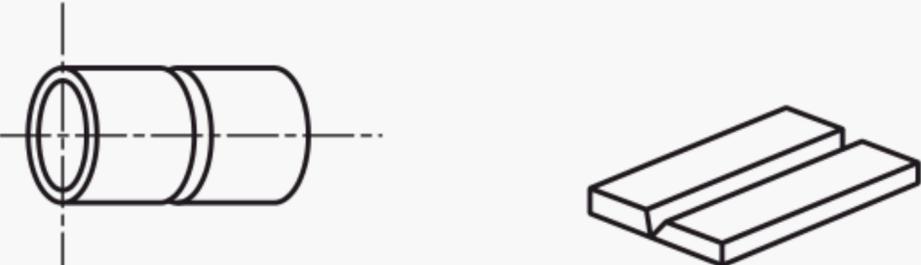
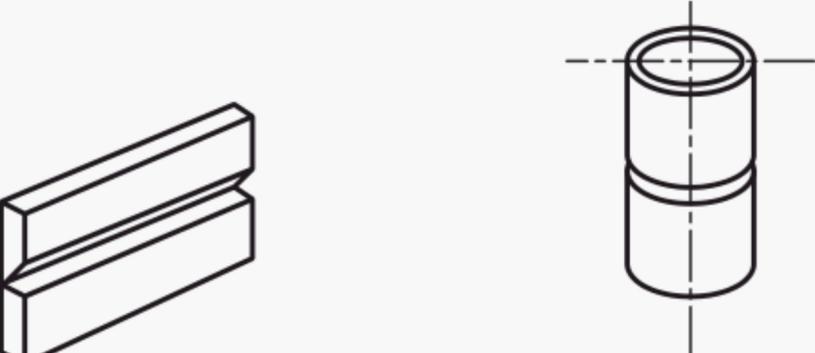
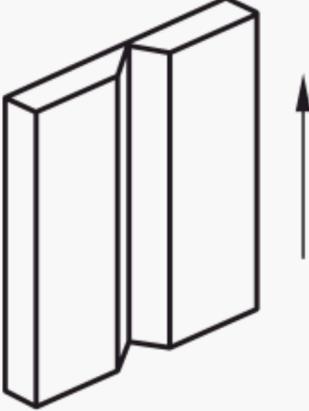
Illustration	Welding position according to AWS A3.0 <sup>[4]</sup> ASME Section IX <sup>[3]</sup>	Welding position according to this International Standard
 <p>flat position (pipe rotating)</p> <p>flat position</p>	1G	PA
 <p>horizontal position</p> <p>horizontal position</p>	2G	PC
 <p>vertical up position</p>	3G uphill	PF

Table B.1 (continued)

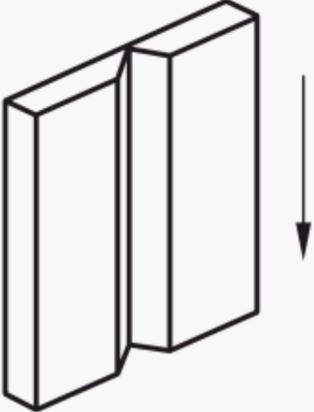
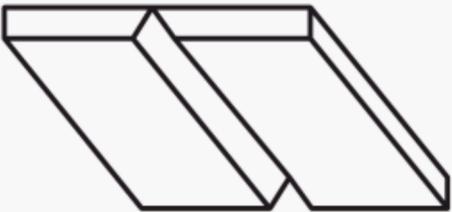
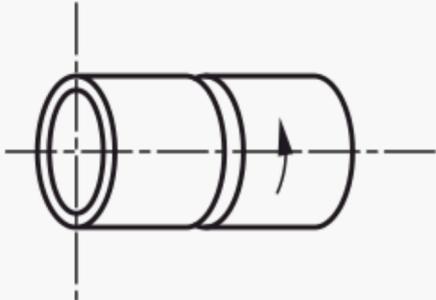
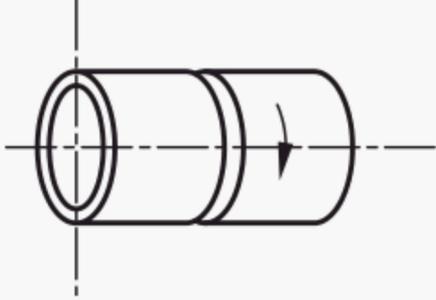
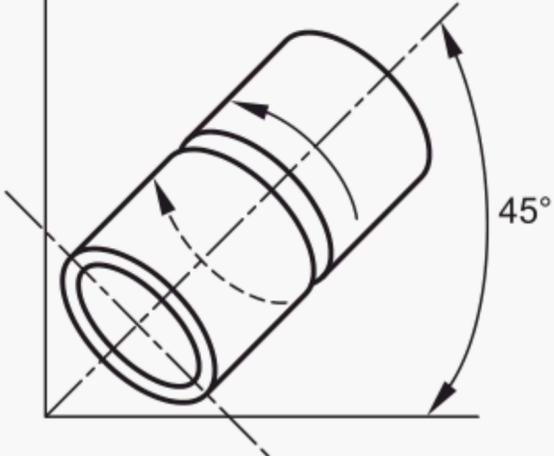
Illustration	Welding position according to AWS A3.0 <sup>[4]</sup> ASME Section IX <sup>[3]</sup>	Welding position according to this International Standard
 <p data-bbox="549 993 863 1031">vertical down position</p>	3G downhill	PG
 <p data-bbox="576 1287 836 1325">overhead position</p>	4G	PE
 <p data-bbox="485 1669 921 1708">vertical up position (pipe fixed)</p>	5G uphill	PH
 <p data-bbox="485 2058 921 2096">vertical down position (pipe fixed)</p>	5G downhill	PJ
 <p data-bbox="378 2601 1034 2640">inclined position (pipe fixed) welding upwards</p>	6G uphill	H-L045

Table B.1 (continued)

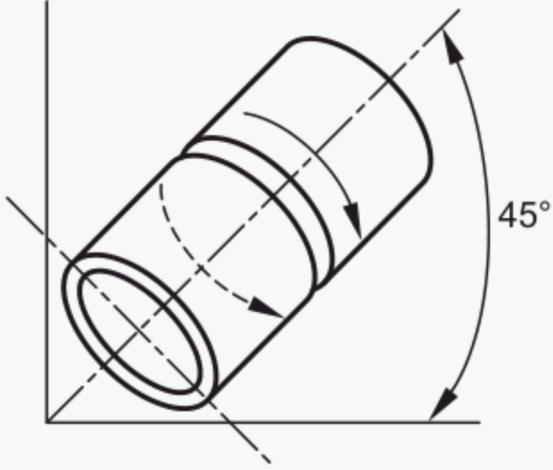
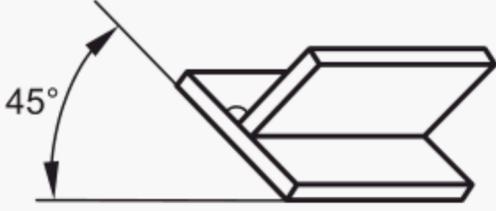
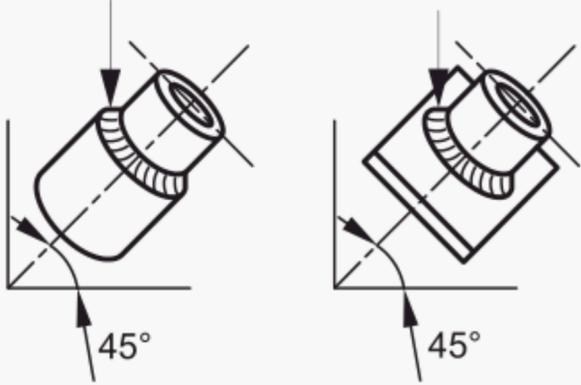
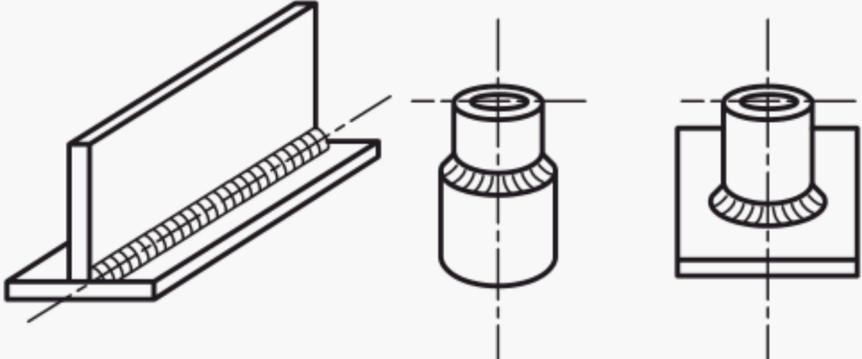
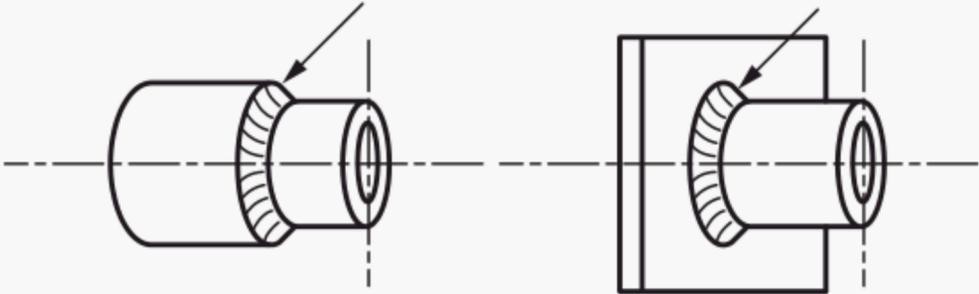
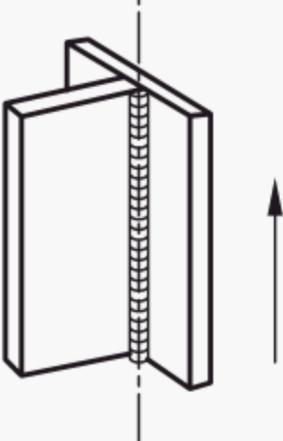
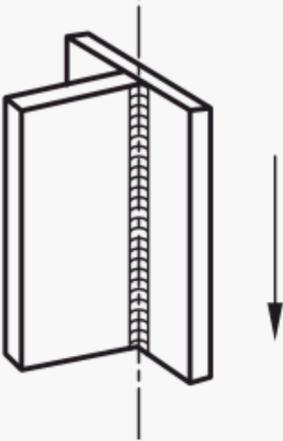
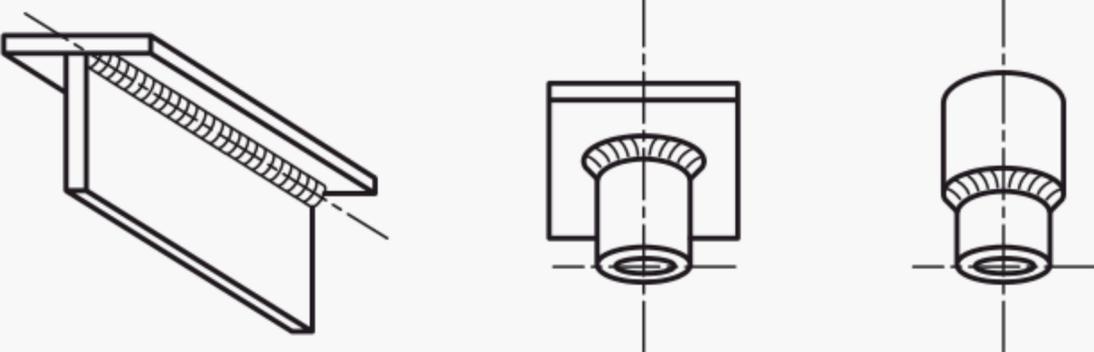
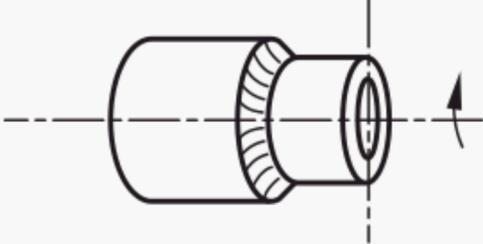
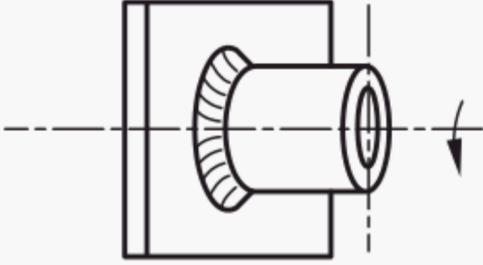
Illustration	Welding position according to AWS A3.0 <sup>[4]</sup> ASME Section IX <sup>[3]</sup>	Welding position according to this International Standard
 <p>inclined position (pipe fixed) welding downwards</p>	6G downhill	J-L045
 <p>flat position</p>	1F	PA
 <p>flat position (pipe rotating)</p>	1FR	PA
 <p>horizontal vertical position</p>	2F	PB
 <p>horizontal vertical position (pipe rotated)</p>	2FR	PB

Table B.1 (continued)

Illustration	Welding position according to AWS A3.0 <sup>[4]</sup> ASME Section IX <sup>[3]</sup>	Welding position according to this International Standard
 <p data-bbox="570 1023 840 1061">vertical up position</p>	3F uphill	PF
 <p data-bbox="570 1552 840 1590">vertical down position</p>	3F downhill	PG
 <p data-bbox="506 1984 910 2022">horizontal overhead position</p>	4F	PD
 <p data-bbox="485 2307 925 2346">vertical up position (pipe fixed)</p>	5F uphill	PH
 <p data-bbox="485 2651 925 2690">vertical down position (pipe fixed)</p>	5F downhill	PJ

## Bibliography

- [1] ISO 9606 (all parts), *Approval testing of welders — Fusion welding*
- [2] ISO 15614 (all parts), *Specification and qualification of welding procedures for metallic materials — Welding procedure test*
- [3] ASME Section IX, *ASME boiler and pressure vessel code — Section IX: Welding and brazing qualifications*
- [4] AWS A3.0, *Standard welding terms and definitions including terms for adhesive bonding, brazing, soldering, thermal cutting, and thermal spraying*
- [5] CEN/TR 14633, *Welding — Working positions — Comparison of current international, European and US designations*

