



Heat treatment of welded and flame-cut parts

**WN
9 66 65-02**

Replacement for
edition 2008-11

1 Range of application and purpose:

This standard applies to heat treatment of welded and flame-cut parts ensuring a constant, defined and good quality.

The purpose of this standard is to avoid and to remove internal tensions influencing the dimensional accuracy of the workpiece during and after machining, even after a longer period of time.

It is mandatory to adhere to the cooling rates defined in this works standard.

The heat treatment is to be specified in the drawing and to be confirmed by the supplier.

2 Heat treatment specifications for stress relieving:

- Running-in into the annealing furnace at a temperature of max. 50°C
- Heating up with a rate of max. 50°/ h
- Annealing temperature: 600°C
- Exposure time for wall thicknesses ≤ 50 mm: 2h
- Exposure time for wall thicknesses > 50 mm: 4h
- Cooling rate: max. 50°/ h
- Furnace temperature on removal < 150°C

Drawing note: „Stress relieved according to works standard 9 66 65-02 “

3 Documentation:

Details regarding furnace operation, annealing temperatures and heating-up and cooling rates are to be documented and to be delivered to SW in writing.

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Modifications

In comparison with works standard 9 66 65-02:2008-11 the following has been modified:

- a) The works standard now includes flame-cut parts.
- b) The drawing note „Stress relieved according to works standard 9 66 65-02“ has been fixed.

Former Editions:

Works standard 9 66 65-02: 2007-05, 2008-11