

**Guideline**

**F-10**

**CLAP**

**FORM N°X132**

**Version : 1**

**Directive 2014/68/EU**

**Adopted by WGP :** 15/03/2016

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**Directive References:** Article 2 (13)

Annex I § 3.1.2

**Subject:** ESR on manufacturing – Approach for the approval of permanent joining procedures

**Question:** In the absence of harmonized standards, what approach is to be followed for the approval of permanent joining procedures?

**Answer:** In the absence of harmonized standards, the manufacturer shall refer to an existing document (draft standard candidate for harmonization, professional document, guide, recognised third party/notified body document, company document) or shall establish a specific document.

Such a document shall define at least:

- Essential variables for the procedure that may affect the properties of the permanent joining;
- Inspection and testing to be carried out for the qualification of the procedure;
- Acceptance criteria;
- Range of validity.

NOTE: The directive states that “the properties of permanent joints must meet the minimum properties specified for the materials to be joined unless other relevant property values are specifically taken into account in the design calculations”.

See also Guideline F-01 (CLAP X123).

For welding, see Guideline F-12 (CLAP X133).