

ICS 47.020.30

CCS U55



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 11618.1-2008

Replacing GB/T 11618-1999

**Pipe fittings of copper and copper alloys - Part 1: Fittings of
brazing type**

铜管接头 第1部分：钎焊式管件

Issued on: August 4, 2008

Implemented on: February 1, 2009

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of China**

Table of Contents

- 1 Scope
- 2 Normative references
- 3 Classification and Marking

Foreword

GB/T 11618 "brass fittings" is divided into two parts.

--- Part 1. brazed tube;

--- Part 2. compression fittings. This section GB/T 11618 Part 1. This Part replaces GB/T 11618-1999 "brass fittings." This section compared with the GB/T 11618-1999, the main changes are as follows:

--- Modify the socket connection size. II series of commitments in this section, the outer diameter of the socket to allow deviation by the EC standard BSEN1254- 1.1998 "Part 1 of copper and copper alloy tube. soldering or brazing connected accessories" (in English), materials, connectivity, health Health and other related content with reference to the German standard DVGW W534.1995 "means the fittings and pipe connections" (in English) selected Appropriate national standards.

--- Modify the nominal diameter, extending from DN6mm ~ DN200mm is DN6mm ~ DN300mm.

--- Retained the original standard in fourth gear copper tube outer diameter, in parallel form included for easy selection of marine pipeline. Appendix A of this section is an informative annex. This part is proposed by the China State Shipbuilding Corporation. This part of the National Marine Machinery Standardization Technical Committee piping attachment points Technical Committee. This section is drafted. Tianli Pipe Fittings Co., Ltd., China Shipbuilding Technology and Economy Research Institute, the International Copper Association (China), Shanghai East Zhonghua Shipbuilding (Group) Co., Ltd., Cixi Jinlong Copper & Aluminum Pipe Manufacturing Company, Sheng Linhai City Star Copper Tube Co., Ltd.. The main drafters of this section. Liu Zhichun, Cai Jianping, Sun Jingming, Rover yuan, Liu Qiao Qiao, Yang Jianguo, Huang Wei, Panzhao Xiang. This part of the standard replaces the previous editions are.

--- GB 11618.1 ~ 11618.8-1989, GB/T 11618-1999. Copper Pipe Fittings - Part 1. brazed tube

1 Scope

GB/T 11618.1-2008 is the Chinese national standard on pipe fittings of copper and copper alloys - part 1: fittings of braze welding type, in the field of shipbuilding and marine structures. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 4 August 2008 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 February 2009. Classification: ICS 47.020.30, CCS U55. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

GB/T 11618 in this section specifies the size of the connector brass press GB/T 18033 brazed brass fittings (hereinafter referred to as brazing pipe Member) classification, requirements, test methods, inspection rules, marking, packaging, transportation and storage. This section applies to the nominal pressure not more than 1.6MPa, the nominal diameter of not more than DN300mm, for delivery of domestic water (cold water, Hot water), drinking water, gas and non-corrosive to copper media other brass Road brazed tube design, manufacture and acceptance.

2 Normative references

The following documents contain provisions which, through reference

GB/T 11618 in this section constitute provisions of this section. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest versions apply to this section.

GB/T 191 Packaging - Pictorial signs (GB/T 191-2008, ISO 780.1997, MOD)

GB/T 1176-1987 Cast Copper Alloys conditions (neq ISO 1338. 1977)

GB/T 1804-2000 General tolerances for linear and angular dimensions without individual tolerance tolerance (eqv ISO 2768-1. 1989)

GB/T 2040-2002 Copper and copper alloy sheet

GB/T 2059-2000 Copper and copper alloy strip

GB/T 7306.1-2000 55 ° sealing pipe thread - Part 1. the inner cylindrical thread and taper external thread (eqv ISO 7-1.1994)

GB/T 8619-1988 brazed seam strength test

GB/T 8888 heavy non-ferrous metal processing products, packaging, labeling, transportation and storage

GB/T 18033-2007 seamless copper pipes and copper pipe YS/T 649-2007 copper and copper alloy extruded rod "In drinking water equipment and protective materials hygiene and safety evaluation norms" Ministry of Health Health Law Jian Fa (2001) No. 161 annex 2 "Steel ship classification rules" China Classification Society 2006 Volume 3

3 Classification and Marking

3.1 Classification and basic parameters Brazing pipe fittings according to the pipe material is divided into two series.

--- referring to the German standard DVGW W534;

--- refer to Japanese standards JCDA0004. Categories brazing pipe fittings and basic parameters in Table 1.