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

GB/T 11693-2022

Replacing GB/T 11693-2008

Welded bed plate for flanges of ship pipe

船用法兰焊接座板

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part

1. Structure and Drafting Rules of Standardization Documents" drafted. This document replaces GB/T 11693-2008 "Marine Flange Welded Seat Plate". Compared with GB/T 11693-2008, except for structural adjustment and In addition to editorial changes, the main technical changes are as follows:

- a) C-type and CS-type seat plates are deleted (see 3.3.4 of the.2008 edition);
- b) The flange connection size is added according to the type of marine flange welded seat plate of ASME B16.5-2020 (see 4.1);
- c) The flange connection size is added according to the type of marine flange welded seat plate according to JIS B2220.2012 (see 4.1);
- d) Added the flange connection size according to CB/T 4196-2011, GB/T 2501-2010 marine flat circular flange welded seat plate Type (see 4.1);
- e) Changed the product mark (see 4.4, 3.4 of the.2008 edition);
- f) Added 06Cr19Ni10, 022Cr19Ni10, 06Cr17Ni12Mo2, 022Cr17Ni12Mo2 of NB/T 47010-2017 materials (see 5.1);
- g) Added requirements and test methods for materials 10CrNi3MoCu (922A) and 15CrNi3MoV (925A) (see 5.1.2, 5.1.3, 6.1);
- h) Added requirements and test methods for interfaces (see 5.6 and 6.6). Please note that some content of this document may be patented. The issuing agency of this document assumes no responsibility for identifying patents. This document is proposed and managed by the National Marine Machinery Standardization Technical

Committee (SAC/TC137). This document is drafted by: Bohai Shipyard Group Co., Ltd., Jiangnan Shipbuilding (Group) Co., Ltd., Dalian Marine Valve Co., Ltd. Division, China Shipbuilding Industry Research Institute of Comprehensive Technology and Economics. The main drafters of this document. Zhang Tao, Wang Jinying, Li Wei, Liu Tao, Wang Shikai, Wu Yongfeng, Zhang Ye, Qi Shuo. The previous versions of this document and its superseded documents are as follows:

---First published in 1989 as GB/T 11693-1989, first revised in 1994;

1 Scope

GB/T 11693-2022 is the Chinese national standard on welded bed plate for flanges of ship pipe, 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 12 October 2022 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 12 October 2022. 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.

2 Normative references

The contents of the following documents constitute essential provisions of this document through normative references in the text. Among them, the dated reference documents, only The version corresponding to this date applies to this document; for undated references, the latest edition (including all amendments) applies to this document.

GB/T 197-2018 Common thread tolerance

GB/T 228.1 Tensile Test of Metallic Materials Part

GB/T 229 Charpy Pendulum Impact Test Method for Metallic Materials

GB/T 600 General technical conditions for marine pipeline valves

GB/T 700-2006 Carbon structural steel

GB/T 712-2011 Structural steel for ships and marine engineering

GB/T 1184-1996 Shape and position tolerances are not marked with tolerance values

GB/T 1220-2007 Stainless Steel Rods

GB/T 1804-2000 General Tolerances Unmarked Tolerances of Linear and Angular

Dimensions

GB/T 1958 Product Geometric Specifications (GPS) Geometric Tolerance Detection and Verification

GB/T 2501-2010 Marine flange connection size and sealing surface CB859-2004 Specification for P3.0MPa Welded Steel Flanges CB/T 4196-2011 Marine flange connection dimensions and sealing surface NB/T 47010-2017 Stainless steel and heat-resistant steel forgings for pressure equipment NB/T 47013.3 Nondestructive Testing of Pressure Equipment Part

3 Terms and Definitions

There are no terms and definitions that need to be defined in this document.

4 Classification and marking

4.1 Type The type of seat plate is as follows:

---Single-sided seat plate according to CB/T 4196-2011 for connection size and sealing surface;