

ICS 47.020.01
CCS U05



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

GB/T 13147-2009

Replacing GB/T 13147-1991

**Specification for welding of copper and copper alloy clad steel
plates**

铜及铜合金复合钢板焊接技术要求

Issued on: March 23, 2009

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Quarantine of the People's Republic of China;
Standardization Administration of China**

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Foreword

This standard replaces GB/T 13147-1991 "copper and copper alloy clad steel plate welding conditions." This standard compared with GB/T 13147-1991, the main changes are as follows:

--- Standard name changed to "copper and copper alloy clad steel plate welding technical requirements";

--- Adjusted normative references;

--- Table 1 in Appendix A to informative;

--- Increasing the helium gas welding protection;

--- Modify requirements buffer layer weld thickness;

--- Modify the provisions of the bending test at room temperature;

--- Security to press GB 9448 "welding and cutting safety" requirement. Appendix A of this standard is an informative annex. The standard proposed by China Shipbuilding Industry Corporation. This standard by the National Standardization Technical Committee Marine boat marine materials application process Technical Committee (SAC/TC12/SC4) Centralized. This standard was drafted. China Shipbuilding Industry Corporation seventh twenty-five Institute. The main drafters of this standard. Wang Xiaohua, Jiang Chengyu, Chao, Houfa Chen, Zheng Xiaojun, Zhang Lei, Wang Ting, Yan Keng. This standard replaces the standards previously issued as follows:

--- GB/T 13147-1991. Copper and copper alloy clad steel plate welding requirements

1 Scope

GB/T 13147-2009 is the Chinese national standard on specification for welding of copper and copper alloy clad steel plates, 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 23 March 2009 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 November 2009. Classification: ICS 47.020.01, CCS U05. 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.

This standard specifies the materials copper and copper alloy clad steel plate (hereinafter referred to as copper clad steel) welding, welder before welding preparation, welding, soldering Quality inspection and defect repair welding and other technical requirements. This standard applies to the total thickness of more than 8mm, clad copper or copper alloy, carbon steel or base layer of copper low alloy steel composite plate welding Connection. This standard is not provided for other welding copper-steel composite panel may also refer to use.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 985.1 gas welding, arc welding, gas welding and beam welding Recommended groove (GB/T 985.1-2008, ISO 9692-1.2003, MOD)

GB/T 985.2 SAW recommended groove (GB/T 985.2-2008, ISO 9692-2.1998, MOD)

GB/T 2650 welded joint impact test method (GB/T 2650-2008, ISO 9016.2001, IDT)

GB/T 2651 welded joint tensile test method (GB/T 2651-2008, ISO 4136.2001, IDT)

GB/T 2653 welded joint bending test method (GB/T 2653-2008, ISO 5173.2000, IDT) GB/T 3125 White copper

GB/T 3323 metal fusion welded joints radiography

GB/T 3670 Copper and copper alloys GB/T 4842 Ar GB/T 4844.2 pure helium

GB/T 4844.3 high purity helium

GB/T 5117 carbon steel electrode

GB/T 5118 Low Alloy Steel Electrode

GB/T 5231 Wrought copper and copper alloy chemical composition and shape of the product

GB/T 5235 and processing of nickel and nickel alloy chemical composition and shape of the product

GB/T 5293 carbon steel submerged arc welding wire and flux

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