

ICS 47.020.01

CCS U05



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

GB/T 13148-2008

Replacing GB/T 13148-1991

Specification for welding of stainless steel clad plate

不锈钢复合钢板焊接技术要求

Issued on: July 30, 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**

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Foreword

This standard replaces GB/T 13148-1991 "stainless steel clad plate welding conditions."

This standard compared with GB/T 13148-1991, the main changes are as follows:

- Standard name changed to "stainless steel composite plate welding technology requirements";
- Adjusted normative references;
- Table 1 to informative A "composite stainless steel welding materials" Appendix;
- Added two stainless steel composite butt groove type, four grassroots steel grades and a multi-layer steel grades;
- Modified stainless steel clad steel plate butt joints at room temperature bending test provisions;
- Modify the selection of welding materials at the grassroots first weld cladding;
- Remove the prolonged absence of production and orders for primary steel 22g, 15MnVR and can use the same ingredients and base metal wire or mother Timber board cut wire strips as described;
- 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 of marine vessels marine materials application technology at the Technical Committee. This standard was drafted. China Shipbuilding Industry Corporation seventh twenty-five Institute, Technical and Economic Research Institute of China Shipbuilding Industry, Kam West Chemical Machinery (Group) Co., Ltd. The main drafters of this standard. Wang Xiaohua, Wu Jing, Xin Bao, Hao Wensheng, Caowei Xiang, Xuming Lin, Wu Daowen. This standard replaces the standards previously issued as follows:
- GB/T 13148-1991. Stainless steel composite plate welding technology requirements

1 Scope

GB/T 13148-2008 is the Chinese national standard on specification for welding of stainless steel clad plate, 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 30 July 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 47.020.01, 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 material of stainless steel clad steel welding, welders, welding preparation, welding process, welding quality inspection and welding defects back Repair and other technical requirements. This standard applies to stainless steel cladding to carbon steel or low alloy steel for the base layer is not less than the total thickness of 4mm stainless steel composite Welded steel plate.

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 150 steel pressure vessels

GB/T 983 stainless steel electrode

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 3323 metal fusion welded joints radiography

GB/T 4241 stainless steel welding rod

GB/T 4334.5 Stainless sulfuric acid - copper sulfate corrosion test GB/T 4842 Ar

GB/T 5117 carbon steel electrode

GB/T 5118 Low Alloy Steel Electrode

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

GB/T 6052 industrial liquid carbon dioxide

GB/T 6396 composite steel mechanical and process performance test method

3 Terms and Definitions

The following terms and definitions apply to this standard.

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