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

GB/T 19867.2-2026

Replacing GB/T 19867.2-2008

**Specification and qualification of welding procedures for
metallic materials - Welding procedure specification - Part 2:
Gas welding**

金属材料焊接工艺规程及评定 焊接工艺规程 第2部分：气焊

(English Translation)

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Foreword

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This document conforms to GB/T 1.1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents".

Drafting is scheduled.

This document is Part 2 of GB/T 19867 "Specifications for Welding Procedures and Qualification of Welding Procedures for Metallic Materials".

The following sections have been released.

--Part 1: Arc Welding;

--Part 2: Gas welding.

This document replaces GB/T 19867.2-2008 "Specification for Gas Welding Procedure". Compared with GB/T 19867.2-2008, the only differences are in the structural adjustments.

Aside from integration and editorial changes, the main technical changes are as follows.

--The scope has been changed (see Chapter 1, Chapter 1 of the 2008 edition);

--Terminology and definitions have been changed (see Chapter 3, Chapter 3 of the 2008 edition);

--The general rules regarding the technical content of the Welding Procedure Specification (WPS) and the content concerning manufacturers have been revised (see 4.1, 4.2, 2008 edition).

4.1, 4.2);

General content on welding procedures, including material handling and post-weld heat treatment (see 4.3.1, 4.3.2, 4.4.1~4.4.5, 4.4.8, 4.4.14, 2008 edition).

(4.3.1, 4.3.2, 4.4.1~4.4.5, 4.4.7, 4.4.9).

--Added welding processes including back-side cleaning, backing, mechanized and automated welding, preheating temperature, interpass temperature, and preheating maintenance temperature.

General content (see 4.4.6, 4.4.7, 4.4.10~4.4.13).

--The welding material specifications have been removed (see 4.4.8 in the 2008 edition).

This document is equivalent to ISO 15609-2:2019 "Welding procedures for metallic materials and qualification procedures - Part 2." gas welding".

The following minimal editorial changes have been made to this document.

--Added Appendix NA (Informative) Steel Classification Guide.

Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents.

This document was proposed and is under the jurisdiction of the National Technical Committee on Standardization of Welding and Related Processes (SAC/TC 55).

Introduction

From the date of this document's issuance, all newly compiled welding procedure specifications must be prepared in accordance with this document. However, specifications based on older versions of standards, specifications, or this document may be disregarded.

The original welding procedure specifications compiled in previous versions of this document shall not become invalid due to the release of this document.

It is an important foundation for quantity control and industry standards.

GB/T 19867, "Specification for Welding Procedures and Qualification of Welding Procedures for Metallic Materials," provides a unified standard for welding procedure specifications.

Standardized process requirements can effectively improve welding quality. GB/T 19867 provides standardized specifications for the welding procedures and qualification of metallic materials.

The guidelines and detailed explanations will consist of six parts.

--Part 1: Arc Welding. The purpose is to standardize the welding procedure specifications for arc welding.

--Part 2: Gas Welding. The purpose is to standardize the welding procedure specifications for gas welding methods.

--Part 3: Electron Beam Welding. The purpose is to standardize the welding process specifications for electron beam welding methods.

--Part 4: Laser Welding. The purpose is to standardize the welding process specifications for laser welding methods.

--Part 5: Resistance Welding. The purpose is to standardize the welding process specifications for resistance welding.

--Part 6: Laser-Arc Hybrid Welding. The purpose is to standardize the welding process

specifications for laser-arc hybrid welding methods.

Welding Procedure Specifications and Evaluation for Metallic Materials Welding Procedure Specification Part 2: Gas Welding

1 Scope

This document specifies the requirements for the process specifications of gas welding.

For details of the ISO 15609 series, see ISO 15607. This document considers variables that affect the quality of welded joints.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are listed below.

For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies.

This document.

menclature of processes and reference numbers) Note. GB/T 5185-2005 Welding and Related Processes Codes (ISO 4063:1998, IDT) ISO 6947 Welding and allied processes - Welding positions Note. GB/T 16672-1996 Definition of the working position angle and rotation angle of weld (ISO 6947:1990, IDT) ISO 15607 Specification and qualification of welding procedures for metallic materials.

procedures for metallic materials-General rules) Note. GB/T 19866-2026 General principles for the qualification and specification of welding procedures (ISO 15607:2019, IDT) ISO/TR 25901-1 Vocabulary for Welding and Allied Processes Part 1: General Terminology Vocabulary-Part 1: General terms) ISO 25901-2 Vocabulary for Welding and Allied Processes - Part 2: Health and Safety cabulary-Part 2: Health and safety) ISO/TR 25901-3 Vocabulary for Welding and Related Processes - Part 3: Welding Processes Vocabulary-Part 3: Welding processes) ISO/TR 25901-4 Welding and related processes vocabulary - Part 4: Arc welding cabulary-Part 4: Arc welding)

3 Terms and Definitions

Terms defined in ISO 15607, ISO/TR 25901-11, ISO 25901-21, ISO/TR 25901-31 and ISO/TR 25901-41 the definitions apply to this document.

2007.