ICS 23.060.01
CCS J16

# NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA



# GB/T 22652-2019

Replacing GB/T 22652-2008

## Overlaying-welding procedure qualification for valves sealing face

阀门密封面堆焊工艺评定

**Issued on: October 18, 2019** **Implemented on: May 1, 2020**

**Issued by: State Administration for Market Regulation;**
**Standardization Administration of China**

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## Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009. This standard replaces GB/T 22652-2008 "Valve Seal Surface Surfacing Welding Process Assessment". Compared with GB/T 22652-2008, the main change The following is as

follows:

--- Added "heap welding process specification", "pre-surfacing process specification", "surfacing welding evaluation report", "surfacing operation instruction book", "down conversion temperature" "" and "post-weld heat treatment" terms (see 3.1);

--- Increased common abbreviations for surfacing process qualification (see 3.2);

--- Increased the base metal commonly used for valve surfacing and its categories and groups (see 5.2);

--- Modified the surfacing process evaluation factor (see 5.5,

5.1 of the.2008 edition);

--- Increased classification of filler metal (welding rod, welding wire, solder powder) and surfacing process qualification rules (see 5.3, 6.3);

--- Increased tubular surfacing specimens and specified sampling locations (see 7.1);

--- Added "Spoiler Process Specification Flow Chart" "Supplementary Specification for Base Metal, Filler Metal and Surfacing Method" "Pressure Welding Process Evaluation Form Push Recommended format" 3 appendices (see Appendix A, Appendix B, Appendix C). This standard was proposed by the China Machinery Industry Federation. This standard is under the jurisdiction of the National Valve Standardization Technical Committee (SAC/TC188). This standard was drafted. Hangzhou Huayu Valve Co., Ltd., Nantong Longyuan Power Station Valve Co., Ltd., Zhejiang Petrochemical Valve Co., Ltd., Ann Huizhou Tunxi High Pressure Valve Co., Ltd., Zhejiang Jinlong Automatic Control Equipment Co., Ltd., Kairuite Valve Industry Co., Ltd., Zhejiang Xinhai Testing Co., Ltd. Division, Nantong Power Station Valve Co., Ltd., China Energy Construction Group Guangdong Electric Power Design and Research Institute Co., Ltd., Shanghai Special Equipment Supervision Inspection and Inspection Technology Research Institute, Zhuzhou South Valve Co., Ltd., Datong Mutual Group Co., Ltd., Yuanda Valve Group Co., Ltd., Zhejiang Provincial Quality and Technical Supervision Education and Training Center, Anhui Tongdu Fluid Technology Co., Ltd. The main drafters of this standard. Chen Lilong, Zhang Ming, Wu Zhenyu, Huang Meilin, Hu Jiayong, Yu Jinhai, Li Yunlong, Yan Gang, Zhang Jianhua, Li Xiaolong, Fu Minghai, Xie Aihua, Cai Tianshan, Fan Hongjie, Chen Yong, Xu Hui. The previous versions of the standards replaced by this standard are.

---GB/T 22652-2008. Valve sealing surface surfacing process evaluation

## 1 Scope

GB/T 22652-2019 is the Chinese national standard on overlaying-welding procedure qualification for valves sealing face, in the field of fluid systems and general-purpose components. 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 18 October 2019 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 May 2020. Classification: ICS 23.060.01, CCS J16. 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 general requirements for the surfacing of valve sealing surfaces, the evaluation factors and classification of surfacing welding, the qualification rules for surfacing welding, and the test Supplementary provisions for summoning specimen inspection, surfacing welding evaluation, and recommended format for pre-surfacing welding procedure specification and surfacing welding qualification report. This standard is applicable to plasma arc surfacing, oxyfuel gas surfacing, electrode arc surfacing, submerged arc surfacing, melting on the surface of the valve sealing surface. Process qualification for catalytic gas surfacing, tungsten gas shielded surfacing and other surfacing methods.



## 2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article. Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 699 high quality carbon structural steel

GB/T 700 carbon structural steel

GB/T 713 steel plate for boiler and pressure vessel

GB/T 984 surfacing electrode

GB/T 1220 stainless steel rod

GB/T 2054 nickel and nickel alloy plate

GB/T 3077 alloy structural steel

GB/T 3274 carbon structural steel and low alloy structural steel hot rolled steel sheet and strip

GB/T 3280 stainless steel cold rolled steel plate and strip

GB/T 4237 stainless steel hot rolled steel sheet and strip

GB/T 4435 nickel and nickel alloy rod

GB/T 11352 casting carbon steel for general engineering

GB/T 12228 general valve carbon steel forgings technical conditions