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

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Procurement guidelines for welding consumables

焊接材料采购指南

(English Translation)

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Foreword

This revised standard adopts ISO 14344:2010 "Welding and related processes slag protection and gas protection welding materials Buyer's Guide." Consideration of the actual situation of welding materials products, the use of ISO 14344:2010 when you made the following technical modifications.

--- The ISO 14344 in Chapter 3, "Terms and Definitions" in paragraph 1 content alone to form a "General Principles", as this standard 4, ISO 14344 Chapter 4 to Chapter 7 of this standard postpone adjustment in Chapter 5 to Chapter 8;

--- On the "Identification" chapter editing structure has been adjusted. The ISO 14344 in 4.1 "General", 4.2 "furnace" and the 4.3 "control the chemical composition" merger of this standard 5.1" preform moldings, solid wire and ribbon, filler wire, the core wire, flux cored wire and drugs Rod, strip or tube filled wire with a core identity "and divided according to type of marking 5.1.1" heats "and 5.1.2" Control of Chemical composition. "The ISO 14344 in 4.4" electrode coating "adjustment based standard 5.2" welding rod coatings logo "will ISO 14344 in 4.5 "cored filler" Adjust this standard 5.3 "filler drug core identity." This Press Materials Do not carry out the adjustment easier selection and application;

--- For flux cored electrode and edit a sequence of ISO 14344 in the chapter "Batch rules" for the exchange;

--- Table 2 "magnesium and magnesium alloy" to "titanium and titanium alloy." for ease of use, this standard also made the following editorial changes.

--- Standard name was changed to "welding materials Buyer's Guide";

--- Removed Normative references ISO 9001 standard, with the country have been identical

with the standard GB/T 19001 instead.

This standard by the National Standardization Technical Committee welded (SAC/TC55) and focal points.

This standard was drafted. Harbin Welding Research Institute, Tianjin Golden Bridge Welding Materials Group Co., Ltd., Tianjin Bridge Welding Materials Group Co., Changzhou Huatong Wire Co., Ltd., Sichuan Atlantic Welding Materials Co., Ltd. Jiande Xin'anjiang welding electrodes plant, Böhler Welding Technology (China) Limited.

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Welding Materials Buyer's Guide

1 Scope

This standard specifies the terms and definitions welding materials procurement, identification, Batch rules, proof test level and quality content.

This standard applies to the welding material according to the procurement requirements of both supply and demand, choose the preparation of the specific details of welding materials procurement.

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 19001 quality management system requirements (GB/T 19001-2008, ISO 9001:2008, IDT)

3 Terms and Definitions

The following terms and definitions apply to this standard.

Single dry ingredients drybatch Several once dry ingredients in a mixing apparatus for mixing ingredients within.

Note: When the dry ingredients were added to a single liquid binder to form a wet material is stirred. Single dry ingredients can be divided into several smaller quantities. In this case Under the condition, adding the liquid binder may be formed of several smaller quantity of wet material is stirred.

Combination of dry ingredients dryblend Combination of dry ingredients by more than two single dry ingredient composition. Each single quantity of each ingredient according to the proportion of added dry, then Mixing within a mixing apparatus to form a large number of components are uniformly distributed, as the components are mixed in a mixing device within a large Made.

Note: The combination of dry ingredients with a single dry ingredients, you can use or be divided into several smaller quantity alone. After adding the liquid binder may be formed or if a Dry a wet material is stirred.

Wet stirred material wetmix Wet stirred by the liquid binder material is dry ingredients with a single or a combination of the dry ingredients, or portions thereof, in a first mixing means mixing Close together.

Heat number heat

Preform moldings, solid wires and filler wire, ribbon, core wire, flux cored wire and cored wire filled with the rod, strip or tube furnace No.

The method depends on the definition of smelting and refining, as follows.

--- Metal smelting process, the slag - metal sometimes gas - reaction between the metal (such as open-hearth furnace, electric arc furnace, converter, argon - oxygen furnace), No.

It means obtained from the same material in the smelting furnace.

--- Metal smelting process, without significant chemical reactions (such as controlled atmosphere induction melting or vacuum induction melting), furnace number is it refers to a number of control elements and alloys metal ingredients in a melting furnace, using the same conditions obtained by a continuous melting Group of materials, and the chemical composition of each heat melting materials are in accordance with the scope of the purchaser (welding materials factory) is.

--- When using a continuous melting and casting (such as consumable electrode remelting), furnace number refers to a smelting furnace smelting under the same conditions,