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

GB/T 32257-2015

**Qualification testing of welders for fusion welding on nickel and
nickel alloys**

镍及镍合金熔化焊焊工技能评定
(English Translation)

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Foreword

This standard was drafted in accordance with GB/T 1.1-2009 given rules.

This standard uses redrafted Law Amendment uses ISO 9606-4:1999 "welders - Fusion welding - Part 4. Nickel and nickel alloys." this standard and ISO 9606-4:1999 and its main technical difference between the following reasons.

- Increasing the recommended format welder qualification certificates, welders approval mark, certificate extension to be confirmed and the content of nickel and nickel alloys Classification guidelines, and give in order to operate in the form of appendices;
- Unified regulations of the main parameters of welders and the scope of accreditation, and the recognition of the scope of the base metal and welding position were necessary adjustments Whole, making it more clear, specific, reasonable, easy to use;
- The ISO 9606-4:1999 foreign standards referenced in accordance with the actual situation of our country have been adjusted. Terminology, definitions, Welding Technology Procedures, non-destructive inspection and destructive testing methods - Part of the appropriate standards in place to facilitate the implementation.

This standard made the following editorial changes.

- Added Appendix A (informative) "welder qualification certificate";
- Added Appendix B (informative) "welders approval mark Example";
- Added Appendix C (informative) "professional knowledge";
- Added Appendix D (informative) "deferred to be confirmed and traceable parameters";
- Added Appendix E (normative) "Nickel and nickel alloys Classification Guide." this standard by the National Standardization Technical Committee welded (SAC/TC55) and

focal points.

This standard was drafted. Harbin Welding Institute, Shanghai Installation Engineering Group Co., Ltd., China Shipbuilding Equipment Co., Ltd. Shenghui.

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Nickel and nickel alloy welding Fusion welding skills assessment

1 Scope

This standard specifies the method of welders for fusion welding of nickel and nickel alloys for.

This standard applies to manual welding method of operation.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

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 3323-2005, EN1435:2003, IDT) GB/T 3375 Welding terminology GB/T 5185 Welding and allied processes method code (GB/T 5185-2005, ISO 4063:1998, IDT) GB/T 15169 steel welders - Fusion welding skills assessment GB/T 16672 Weld tilt and swivel working position definitions (GB/T 16672-1996, ISO 6947:1993, IDT) GB/T 19418 steel welding joint quality levels for imperfections GB/T 26955 Destructive tests on welds in metallic materials weld macroscopic and microscopic examination (GB/T 26955-2011, ISO 17639, MOD) GB/T 27551 Destructive tests on welds in metallic materials fracture test (GB/T 27551-2011, ISO 9017:2001, IDT) Melting ISO 17637 Non-destructive testing of welds welding head visual inspection (Non-destructive testing of welds-Visual testing of fusion-welded joints) ISO/T R15608 welding of metallic materials classified directory (Welding-Guidelines for a metallic materials grouping system)

3 Terms and Definitions

GB/T 3375, the terms and definitions GB/T 15169 apply to this document defined.

4.1 Overview

When completing welder qualification certificate, use the following symbols and abbreviations.

4.2 Specimen

a --- seam thickness is calculated;

BW --- butt weld;

D --- tube outer diameter;