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

GB/T 32260.2-2015

**Destructive tests on welds in metallic materials -- Cold cracking
tests for weldments -- Arc welding processes -- Part 2:
Self-restraint tests**

金属材料焊缝的破坏性试验 焊件的冷裂纹试验 弧焊方法 第2部分：自拘束试验
(English Translation)

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Foreword

GB/T 32260 "cold crack test welds in metallic materials welding methods Destructive tests weldment" is divided into three parts.

--- Part 1. General;

--- Part 2. Self-restraint tests;

--- Part 3. external load test.

This section GB/T Part of 232,260.

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

This section uses redrafted Law Amendment uses ISO 17642-2:2005 "Destructive tests on welds in metallic materials weldment cold cracks Arc test methods - Part 2. Self-restraint tests. " this part of ISO 17642-2:2005 and its technical differences for the following reasons.

--- On normative references, this part has been adjusted technical differences, in order to adapt our technical conditions. Adjustment situation Focus is reflected in the status of Chapter 2, "Normative references", the specific adjustments are as follows.

- increase the GB/T 3375 "Welding terms";
- The ISO 17642-2:2005 standard of international and European standards cited, instead of using the corresponding standard.

This part of ISO 17642-2:2005, compared the structure to reduce the appendix ZA.

This part of the National Welding Standardization Technical Committee (SAC/TC55) and focal points.

This section is drafted. Harbin Welding Research Institute, Department of Shipbuilding Equipment Co., Ltd. St. Dongguan future Laser Technology Co., Ltd., Shanghai Special Equipment Inspection Technology Research Institute, Chinese Academy of Oil and Gas Pipeline, China Special Equipment Inspection and Research Institute, Tianjin gold Bridge Welding Materials Group Co., Ltd.

Drafters of this section. Wang Kenan, Su Jinhua, Zhang, Dai Hai, Xu Bin, Suiyong Li, Shi Kun, Yang Yongmei, Pudong Guang.

Destructive tests on welds in metallic materials Cold cracking test method for welding weldment Part 2. Self-restraint tests

1 Scope

GB/T 32260 provisions of this section, the following self-restraint cold cracking test specimen size, sampling requirements, test procedures and evaluation methods.

- CTS (controlled thermal strength) test;
- Tekken (oblique Y-groove) or the Caspian Sea (U-groove) test.

This section applies to (but not limited to) carbon and low alloy steel weld cold cracking susceptibility assessment.

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 2654 welded joint hardness test method (GB/T 2654-2008, ISO 9015-1:2001, IDT)
GB/T 3375 Welding terminology GB/T 3965 deposited metal diffusible hydrogen determination method (GB/T 3965-2012, ISO 3690:2000, MOD) GB/T 26955 Destructive tests on welds in metallic materials weld macroscopic and microscopic examination (GB/T 26955-2011, ISO 17639.

2003, MOD)

Cold welding crack test methods - Part 1 GB/T 32260.1 Destructive tests on welds in metallic materials weldment. General (GB/T 32260.1-2015, ISO 17642-1:2004, MOD)

3 Terms and Definitions

Terms and definitions GB/T 3375 and GB/T 32260.1 defined apply to this document.

Names and symbols 4 test parameters Names and symbols of test parameters are shown in Table 1.

Table 1 Name and Symbol

Symbol Name Unit

CTS (to control heat intensity) test t Material thickness mm LV size of fillet (vertical) mm LH weld leg size (transverse) mm L length mm test weld