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

GB/T 3287-2024

Replacing GB/T 3287-2011

Malleable cast iron pipe fittings

可锻铸铁管路连接件

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part

1. Structure and drafting rules for standardization documents" Drafting. This document replaces GB/T 3287-2011 "Mallet Iron Pipe Connectors". Compared with GB/T 3287-2011, except for the structural adjustment and In addition to editorial changes, the main technical changes are as follows:

- Changed the scope (see Chapter 1, Chapter 1 of the.2011 edition);
- Added the terms and definitions of wide side (throat) and ductility (flattening rate) (see 3.2, 3.10);
- Deleted the terms and definitions of pipe fitting specifications and installation lengths (see 3.11 of the.2011 edition);
- Added UC copper core unions and UCA copper core union elbows classified by structural type (see Table 1, Table 2 of the.2011 edition);
- Added classification by product type (see 4.3);
- Changed the graphic mark of the reducing pipe fittings with more than two outlet ports and different outlet specifications (see 4.4.2.3, Figure 2, 4.3.2.3 and Figure 2 of the.2011 edition);
- Changed the marking example (see 4.4.3, 4.3.3 of the.2011 edition);

--- Changed the lead content of the zinc layer (see 5.2, Table 4, 5.2.1 of the 2011 edition);

1 Scope

GB/T 3287-2024 is the Chinese standard for malleable cast iron pipe fittings: the threaded elbows, tees, sockets, unions and bends used on screwed steel pipe in water, gas, fire and low pressure process installations. They are made and used by the hundred million, they are interchangeable across manufacturers only because a standard says so, and a fitting that is out of specification does not fail in the warehouse, it fails in a wall. The standard sets the types of fitting and their designation, the dimensions and tolerances including the thread form and its gauging, the requirements on the material and its mechanical properties, the pressure rating and the leak tightness, the surface condition and the galvanised coating where it is applied, the marking, the test methods, the inspection rules and the packaging. The 2024 edition replaces GB/T 3287-2011. For a foundry, a plumbing or fire contractor, or a buyer inspecting a delivery in China, this is the dimension and acceptance text.

This document defines the terms and definitions of malleable cast iron pipe fittings (hereinafter referred to as "pipe fittings"), establishes the product classification and standardization of pipe fittings, It specifies the technical requirements for pipe fittings, such as materials, design, appearance, performance, etc., and describes the corresponding test methods, inspection rules, marking, packaging, transportation, etc. Transport and storage, etc. This document is applicable to the maximum working pressure of 2.5MPa, nominal size (DN) 6~(DN) 150, operating temperature of -20°C~300°C, Design, manufacture and acceptance of pipe fittings used for general pipeline connections with media such as water, oil, air, gas, steam, etc.

2 Normative references

The contents of the following documents constitute the essential clauses of this document through normative references in this document. For referenced documents without a date, only the version corresponding to that date applies to this document; for referenced documents without a date, the latest version (including all amendments) applies to This document.

GB/T 192 Basic profile of common thread

GB/T 193 Common thread diameter and pitch series

GB/T 196 Basic dimensions of common threads

GB/T 197 General thread tolerances

GB/T 2828.1 Sampling procedures for inspection by attributes Part

3 Terms and Definitions

The following terms and definitions apply to this document.

3.1 Pipe fitting Products used to connect one or several parts.

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