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

GB/T 34202-2017

**Ductile iron pipes, fittings and accessories - Epoxy coating
(heavy-duty)**

球墨铸铁管、管件及附件 环氧涂层（重防腐）

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009. This standard is proposed by China Iron and Steel Association. This standard by the National Standardization Technical Committee Steel (SAC/TC183) centralized. This standard was drafted unit. Xinxing Ductile Iron Pipes Co., Ltd., Metallurgical Industry Information Standards Institute. The main drafters of this standard. Li Ning, Jia Qingbo, Cheng Aimin, Hou Jie, Li Xiaodong, Li Jun. Ductile iron pipes, fittings and accessories epoxy coating (Heavy duty)

1 Scope

China's national standard for heavy-duty epoxy coatings applied in the factory to ductile iron pipes, fittings and accessories meeting GB/T 13295 and GB/T 26081. It covers the classification and recommended specifications for the anti-corrosion coatings used - fusion bonded epoxy powder, two-component solvent-free liquid epoxy and epoxy ceramic - together with the requirements for the coated product. Ductile iron pipe is the mainstay of water distribution: strong, tough, and able to take the ground movement and surge loads that a buried main experiences. What it is not is corrosion resistant, and a buried iron pipe in aggressive soil will corrode from the outside while carrying water that corrodes it from within. The coating is therefore the component that decides the pipe's service life, and a water main is expected to last a century. Heavy-duty here is a real distinction rather than a marketing one: these coatings are specified where the standard cement mortar lining and bitumen coating are not enough, in aggressive ground and in wastewater service.

This standard specifies the ductile iron pipe, fittings and accessories in line with GB/T 13295, GB/T 26081 requirements in the factory coated with epoxy heavy Classification and Recommended Specifications for Anti-Corrosive Coatings (Fused Epoxy Powder Coatings, Two-Component Solvent-Free Liquid Epoxy Coatings, Epoxy Ceramic Undercoats), Technical Requirements, test methods and inspection rules. This standard applies to the delivery temperature does not exceed 60 °C water coated ductile iron pipes, fittings and accessories. It can be buried in corrosion Soil or water, the ambient temperature does not exceed 50 °C.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 1771 Paints and varnishes - Determination of resistance to neutral salt spray performance

GB/T 2411 Plastics and hard rubbers Determination of indentation hardness (Shore hardness) using a durometer

GB/T 5210 Paints and varnishes pull open method adhesion test Visual inspection of surface cleanliness of steel surfaces before application of paints - Part 1. Uncoated Of the steel surface and the full removal of the original coating after the steel surface corrosion level and treatment level Paints and varnishes - Determination of resistance to liquids GB/T 9274-1988

GB/T 13288.1-2008 Steel surfaces before application of coatings - Surface roughness characteristics of spray-cleaned steel parts - Part

1 The technical requirements and definitions for the comparative sample of ISO surface roughness used to evaluate the surface roughness of steel after blasting

GB/T 13295 water and gas ductile iron pipes, fittings and accessories

GB/T 17219 drinking water distribution equipment and protective materials safety evaluation criteria

GB/T 17456.2 Zinc coating on the outer surface of ductile iron pipe Part

3 Terms and definitions

GB/T 13295 defined and the following terms and definitions apply to this document.