

ICS 25.010

CCS J 04



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

GB/T 37400.12-2019

**Heavy machinery general technical specification - Part 12:
Painting**

重型机械通用技术条件 第12部分：涂装

Issued on: March 25, 2019

Implemented on: October 1, 2019

**Issued by: State Administration for Market Regulation;
Standardization Administration of the PRC**

Table of Contents

1 Scope

2 Normative references

Foreword

GB/T 37400 "General Technical Conditions for Heavy Machinery" is divided into 16 parts.

- Part 1. Product inspection;
- Part 2. Flame cutting parts;
- Part 3. Welded parts;
- Part 4. Cast iron parts;
- Part 5. Non-ferrous metal castings;
- Part 6. Steel castings;
- Part 7. Repair welding of steel castings;
- Part 8. Forgings;
- Part 9. Machining parts;
- Part 10. Assembly;
- Part 11. piping;
- Part 12. Painting;
- Part 13. Packaging;

1 Scope

Part 12 of China's general technical specification for heavy machinery, covering painting. It specifies the coating technical requirements and the testing requirements for heavy machinery products and their components. Paint on a machine of this kind is doing more than one job, and the standard has to serve all of them. It is corrosion protection for a structure that will stand in a steelworks or a mine for thirty years and cannot be taken out of service to be recoated. It is a functional marking system: the colours that identify a hazard, a moving part, a lifting point or the contents of a pipe are read by people working around the machine. And it is protection during a transit that may last months, since these machines are shipped in pieces by sea and stand in the open at the site before erection.

Surface preparation is the requirement that decides whether any of it works, which is why it comes before the coating specification.

This part of GB/T 37400 specifies the coating technical requirements and testing requirements for heavy machinery products and their components. This section applies to the surface of carbon steel and low alloy steel products with a thickness of not less than 3 mm applied in atmospheric, water or soil corrosive environments. Painting.

2 Normative references

The following documents are indispensable for the application of this document. 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 5206 Paint and varnish terms and definitions

GB/T 5210 paint and varnish pull-off adhesion test

GB 6514 Painting operation safety regulations Painting process safety and ventilation purification Basic identification color, identification symbol and safety identification of

GB 7231 industrial pipeline

GB 7692 Painting operation safety regulations Pre-painting process safety and ventilation purification

GB/T 8264 coating technical terminology

GB/T 8923.1.Determination of surface cleanliness of steels - Part 1 . Uncoated steel Corrosion grade and treatment grade of the surface of the steel after surface and overall removal of the original coating

GB/T 8923.2.Determination of surface cleanliness of steels - Part 2. The treatment level after the surface is partially removed from the original coating

GB/T 8923.3 - Determination of surface cleanliness of steels - Part 3. welds, edges and others Processing level of surface defects in the area

GB/T 9286 color and varnish paint film cross-cut test

GB/T 13288.5 Surface treatment of steels before application of coatings - Surface roughness characteristics of steels after blast cleaning - Part 5. Surface Method for determining roughness

GB/T 17849 Test method for non-metallic abrasives for surface treatment of steels before coating

GB/T 18570.3 - Evaluation of surface cleanliness of steels -- Part 3. Surface dust assessment