

CCS J 33



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

GB/T 41113-2021

Qualification testing of brazers and brazing operators

Issued on: December 31, 2021

Implemented on: July 1, 2022

**Issued by: State Administration for Market Regulation, China National
Standardization Administration**

Table of Contents

foreword

1 Scope

2 Normative references

2003 (E), MOD)

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 of Standardization Documents"

drafted:

This document is drafted with reference to ISO 13585:2012 "Assessment of Skills for Brazing and Brazing Operators in Brazing", the degree of consistency is not

Equivalent:

Please note that some content of this document may be patented: The issuing agency of this document assumes no responsibility for identifying patents:

1 Scope

This document specifies the main parameters and scope of accreditation, tests and inspections, and acceptance of test pieces in the skill evaluation of brazing and brazing operators:

Requirements, make-up exams, expiration date, certificates and brazer exam approval marks:

This document applies to the assessment of skills of brazers and brazing operators other than aerospace applications:

2 Normative references

The contents of the following documents constitute essential provisions of this document through normative references in the text: Among them, dated citations

documents, only the version corresponding to that date applies to this document; for undated references, the latest edition (including all amendments) applies to

this document:

GB/T 230:1 Rockwell hardness test of metallic materials Part 1: Test method (GB/T 230:1-2018, ISO 6508-1:

2016, MOD)

GB/T 2653 Bend Test Method for Welded Joints (GB/T 2653-2008, ISO 5173:2000, IDT)

GB/T 2654 Test method for hardness of welded joints (GB/T 2654-2008, ISO 9015-1:2001, IDT)

GB/T 3323 (all parts) Non-destructive testing of welds, radiographic testing

GB/T 11345 Ultrasonic Testing Technology, Testing Grade and Evaluation for Nondestructive Testing of Welds (GB/T 11345-2013,

ISO 17640:2010, MOD)

GB/T 11363 Test method for strength of brazed joints (GB/T 11363-2008, ISO 5187:1985, NEQ)

GB/T 15823 Nondestructive Testing Helium Leak Detection Method

GB/T 18449:1 Knoop hardness test of metallic materials Part 1: Test method (GB/T 18449:1-2009,

ISO 4545-1:2005, MOD)

GB/T 18851:1 Nondestructive Testing Penetrant Testing Part 1: General (GB/T 18851:1-2012, ISO 3452-1:2008,

IDT)

GB/T 20967 General rules for visual inspection of non-destructive testing

GB/T 26955 Destructive test of welds in metallic materials Macro and microscopic inspection of welds (GB/T 26955-2011, ISO 17639:

2003 (E), MOD)

GB/T 27552 Destructive Test of Welds of Metal Materials Microhardness Test of Welded Joints (GB/T 27552-2021,

ISO 9015-2:2016, MOD)

GB/T 32074 Nondestructive testing method for ammonia leakage detection

GB/T 33148 Brazing Terminology (GB/T 33148-2016, ISO 857-2:2005, MOD)

GB/T 33219 Brazing joint defects (GB/T 33219-2016, ISO 18279:2003, MOD)

GB/T 34637 Nondestructive Testing Method for Bubble Leakage Detection

GB/T 38883 Active infrared thermal imaging detection method for nondestructive testing

NB/T 47013:8-2012 Non-destructive testing of pressure equipment - Part 8: Leak detection

ISO /T R15608 Welding-Guidelinesformetalicmaterialsgrouping

chinastandards.org - PREVIEW