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

GB/T 44439-2024

**Plastics pipes and fittings - Automatic recognition systems for
electrofusion joints**

塑料管材和管件 电熔熔接自动识别系统

(English Translation)

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Table of Contents

Preface
1 Scope
2 Normative references
3 Terms and Definitions
4 Categories
5 Requirements for digital identification systems
Appendix A (Informative) Comparison table of structure numbers between this document and ISO 13950:2007
Appendix B (Informative) Technical differences between this document and ISO 13950:2007 and their causes
Appendix C (Normative) 24-bit barcode structure and code encoding rules
Appendix D (Normative) 32-bit barcode structure and code encoding rules
Appendix E (Informative) Electromechanical Identification System
Appendix F (Informative) Adaptive Control Identification System
References

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 is required.

This document is modified to adopt ISO 13950:2007 "Automatic identification system for electric fusion joints of plastics pipes and fittings".

Compared with ISO 13950:2007, this document has many structural adjustments. The comparison table of structural number changes between the two documents is shown in Appendix A.

This document has more technical differences than ISO 13950:2007.

A list of these technical differences and their causes is given in Appendix B.

The following editorial changes were made to this document.

The amendments to ISO 13950:2007/Cor 1.2008 have been incorporated, and the outer margins of the clauses involved are marked with double vertical lines.

(||) is marked;

Added note in 5.1.-

1 Scope

This document specifies the classification of the automatic identification system for electric fusion welding, the code structure of the digital identification system, establishes the coding rules, and gives Basic information of electromechanical identification system and adaptive control identification system.

This document is applicable to automatic identification systems based on 24-bit and 32-bit barcodes for gas, water supply and drainage, general use or other fluid transport Communication and welding process control between electric fusion fittings and welding equipment in pipeline systems.

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.

in this document.

GB/T 16829 Information technology automatic identification and data collection technology bar code system specification interleaved 25 bar code GB/T 19278 General terms and definitions for thermoplastic pipes, fittings and valves GB/T 20674.2 Plastic pipes and fittings - Polyethylene system welding equipment - Part 2: Electric fusion connection

3 Terms and definitions

The terms and definitions defined in GB/T 19278 and GB/T 20674.2 and the following apply to this document.

code

All natural numbers from 0 to 9.

character

Numbers 0 to 9, letters or symbols.

Offset value

An additional natural number added to a certain code.

Fusion cycle

The method used to achieve electrofusion pipe welding.

Note: It is divided into single-stage welding, multi-stage welding and temperature-controlled welding.

Constant voltage mode mode U the electric fusion welding machine uses voltage to control the welding process and keeps the input voltage constant.

Constant current mode mode I the electric fusion welding machine uses current to control the welding process and keep the input current constant.