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

GB/T 46062-2025

**Monolithic (unshaped) refractory products - Gunning refractory
panels by wet gunning techniques**

不定形耐火材料 湿法喷射技术制备耐火喷射料试块

(English Translation)

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents".

Drafting.

This document is modified to adopt ISO 18886:2016 "Preparation of Refractory Specimens - Preparation of Refractory Sprayed Specimens Using Wet Spraying Technique".

piece".

This document has undergone significant structural adjustments compared to ISO 18886:2016. A table comparing the structural numbering changes between the two documents is provided.

See Appendix A.

This document differs significantly from ISO 18886:2016. The relevant clauses are indicated in vertical margins.

Single lines (?) are indicated. A summary of these technical differences and their causes can be found in Appendix B.

The following editorial changes have been made to this document.

---To align with existing standards, the standard title has been changed to "Preparation of Refractory Spraying Specimens using Wet Spraying Technology for Unshaped Refractory Materials";

---Figure 1 includes an explanation of the mold's index number;

---Note added in version 5.1.4;

---Informative references to ISO.20183, ISO 1927-1, and ISO 1927-6 have been removed.

Please note that some content in this document may involve patents. The issuing

organization of this document assumes no responsibility for identifying patents.

This document was proposed and is under the jurisdiction of the National Technical Committee on Standardization of Refractory Materials (SAC/TC193).

1 Scope

This document specifies the principles, equipment, sampling, test procedures, and testing methods for preparing refractory sprayed material specimens using wet spraying technology at room temperature.

Report.

This document applies to refractory materials that, after being mixed with the required total amount of water or other liquids, can be transported through pipelines.

Note: When conducting quality evaluations or product development, test blocks are generally prepared under "standard conditions." When the purpose of the test is to establish a correlation with specific construction conditions, [the following is not explicitly stated in the original text].

Tests are often conducted under "on-site conditions," and parameters such as the type, quantity, and method of addition of the accelerator used, the conveying pressure, and the curing conditions (temperature, specimen orientation) are considered.

Try to get as close as possible to the on-site construction conditions.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included.

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

This document.

GB/T 4513.2 Unshaped refractories - Part 2: Sampling (GB/T 4513.2-2017, ISO 1927-2:2012, IDT) GB/T 4513.4 Unshaped refractories - Part 4: Determination of flowability of castables (GB/T 4513.4-2017) ISO 1927-4:2012, MOD) GB/T 18930 Terminology for Refractory Materials (GB/T 18930-2020, ISO 836:2001, MOD) GB/T 41503 Preparation of Refractory Spraying Specimens by Pneumatic Nozzle Mixing Gun for Unshaped Refractory Materials (GB/T 41503-2022, ISO.20182.2008, MOD)

3 Terms and Definitions

The terms and definitions defined in GB/T 4513.4, GB/T 18930 and GB/T 41503, as well as the following terms and definitions, apply to this document.

activator

Additives that accelerate the curing, hardening, or solidification of unshaped refractory materials.

4 Principles

The refractory material, after being mixed with water, is delivered to the nozzle using an appropriate method (compressed air can be introduced at the nozzle if necessary), and then...

The mixture is sprayed into the mold. A settling accelerator may be added at the nozzle or spray hose as needed to help the mixture adhere to the mold.

It flows on the surface and does not flow downwards.