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

GB/T 985.1-2008

Replacing GB/T 985-1988

**Recommended joint preparation for gas welding, manual metal
arc welding, gas-shield arc welding and beam welding**

气焊、焊条电弧焊、气体保护焊和高能束焊的推荐坡口

(English Translation)

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Foreword

GB/T 985 is divided into the following four parts.

- GB/T 985.1 gas welding, arc welding, gas welding and beam welding Recommended groove;
- GB/T 985.2 SAW recommendation groove;
- GB/T 985.3 aluminum and aluminum alloy gas welding recommendation groove;
- GB/T 985.4 clad steel recommendation groove.

This section GB/T 985.1.

The partial modification of the use of ISO 9692-1:2003 "Welding and allied processes recommended welding groove - Part 1. Arc welding of steel Welding, gas metal arc welding, gas welding, TIG welding and beam welding of high-energy "(in English).

This section according to ISO 9692-1:2003 redrafted. This standard and ISO 9692-1:2003 as compared to the technical content amended as follows.

- Added Appendix A.

For ease of use, this section made the following editorial changes.

- Deleted international standards foreword;
- The standard name changed to "gas welding, arc welding, gas welding and beam

welding Recommended groove";

--- To ISO 9692-1:2003 and other international standards referenced, or modified have been adopted as the equivalent of a standard by our standards Instead of the corresponding international standards;

--- Table numbers were adjusted.

This Part replaces GB/T 985-1988 "welding, SMAW basic form and GMAW welding groove and the size." Section compared with the GB/T 985-1988 The main changes are as follows.

--- Increasing the scope of high-energy beam welding head;

--- Groove in accordance with the one-sided and double-sided welding division;

--- Recommended for each groove corresponding welding method;

--- Increased the narrow gap welding groove.

Appendix A of this section is an informative annex.

This part of the National Standardization Technical Committee welded and centralized.

This section is drafted. Harbin Welding Institute, Dongfang Boiler (Group) Co., Ltd.

1 Scope

GB/T 985 provisions of this part of the steel welding groove forms and sizes. This section applies to gas welding, arc welding, gas protection Welding protection and energy-beam welding.

2 Normative references

The following documents contain provisions which, through reference GB/T 985 of this text, constitute provisions of this section. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest versions apply to this section.

GB/T 324 Weld notation (GB/T 324-1988, eqv ISO 2553. 1984) GB/T 5185 Welding and allied processes method code (GB/T 5185-2005, ISO 4063:1998, IDT) GB/T 16672 Weld tilt and swivel working position definitions (GB/T 16672-1996, idt ISO 6947:1993)

3 General

This section on the principle of full penetration of the provisions of the butt joint groove forms and sizes. For incomplete penetration butt joints, allowing Xu other forms of welding

groove. Welding symbols see GB/T 324. Welding position See GB/T 16672.

4 Welding method

Table 1 to Table 4 provides all kinds of groove for the appropriate welding method. If necessary, it can also be used in combination of two or more applicable methods welding.

Welding code See GB/T 5185.

5 Groove bottom grinding

From the process point of view, without the blunt edge of the groove can be polished to its roots base, retain a certain amount of blunt edges (2mm or less).

6.1 Single-sided butt weld groove

Table provides single-sided butt welding groove forms and dimensions 1. When the cross-position welding, bevel (or groove face angle) may be appropriate to increase, And allow asymmetric. Given clearance also apply to tack welding conditions.

6.2 Double-sided butt weld groove

Table 2 provides double-sided butt welding groove forms and sizes. When the cross-position welding, bevel (or groove face angle) may be appropriate to increase, And allow asymmetric. Given clearance also apply to tack welding conditions.

6.3 Single-sided fillet weld

Table 3 specifies the form of joint-sided fillet welds.

6.4 Double-sided fillet welds

Table 4 provides a form fitting double fillet welds.