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

GB/T 985.2-2008

Replacing GB/T 986-1988

Recommended joint preparation for submerged arc welding

埋弧焊的推荐坡口

(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 985.2.

The partial modification of the use of ISO 9692-2:1998 "Welding and allied processes recommended welding groove - Part 2. Submerged arc welding of steel" (In English).

This section according to ISO 9692-2:1998 redrafted. This standard and ISO 9692-2:1998 as compared to the technical content amended as follows.

- Normative references removed ISO 3834, ISO 9692 and ISO 9956;
- Added Appendix A.

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

- Deleted international standards foreword;
- The standard name changed to "SAW recommended Groove";
- To ISO 9692-2:1998 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 986-1988 "submerged arc weld groove in the basic form and size." Section compared with the GB/T 986-1988 The main changes are as follows.

- Groove in accordance with the one-sided and double-sided welding division;
- 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 submerged arc welding process method.

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 16672 Weld tilt and swivel working position definitions (GB/T 16672-1996, ISO 6947:1993, IDT)

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.

4 Welding position

Specified in this groove is aimed primarily at GB/T 16672 in the flat welding peace fillet welding position (PA and PB), the use of horizontal welding position (PC position), we can consider other groove forms and sizes.

5 Groove forms

Table 1 and Table 2 provides recommended groove forms and sizes. Basic symbols see GB/T 324.

In the case of using tack welding, Table 2 and Table 1 in the gap is a gap after the tack welding is completed.

This section does not specify liner material and size, selection and use of the pad should be combined with specific working conditions.