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

GB/T 985.3-2008

**Recommended joint preparation for gas-shield arc welding on
aluminium and its alloys**

铝及铝合金气体保护焊的推荐坡口

(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 985.3.

The partial modification of the use of ISO 9692-3:2000 "Welding and allied processes recommended welding groove Part 3. aluminum and aluminum alloys GMAW "(in English).

This section according to ISO 9692-3:2000 redrafted. For ease of use, this section made the following editorial changes.

- Deleted international standards foreword;
- The standard name be changed to "aluminum and aluminum alloy gas 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 of the National Standardization Technical Committee welded and centralized.

This section is drafted. Harbin Welding Institute.

1 Scope

GB/T 985 provisions of this part of the aluminum and aluminum alloy welding groove forms and sizes.

This section applies to gas welding of aluminum and aluminum alloy 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 5185 Welding and allied processes method code (GB/T 5185-2005, ISO 4063:1998, IDT)

3 General

This part of the weld groove Recommended for all weldable aluminum and aluminum alloy full penetration joints, for incomplete penetration butt joints, allowing Xu other forms of welding groove.

4 Welding method

Table 1 to all types of bevel specified in Table 3 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 processing

Bevel edge should be used mechanical methods (such as cutting, sawing, grinding) process. Not use mineral oil cleaner. Plasma when cutting, it should pay attention to the quality of the cut surface (such as cracks may not appear).

Groove longitudinal edges (especially not with a padded one-sided butt weld groove) should be done sanding or chamfered.

6 Groove forms

Table 1 to Table 3 provides recommended groove forms and sizes.

Specific selection groove (bevel gap, blunt edge) depends on the joint thickness, welding position and welding methods. Large clearance ($\geq 1.5\text{mm}$) may be a small bevel.

For single-sided welding plate is part of the groove.