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JG

INDUSTRY STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

JG/T 94-2013

Replacing JG/T 94-1999

Gas pressure welder for reinforcing steel bar

(English Translation)

Issued on: January 1, 1970 **Implemented on: January 1, 1970**

Issued by: Ministry of Housing and Urban-Rural Development of the People's Republic of China

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces JG/T 94-1999 "bar gas pressure welding machine." this standard is the revision of JG/T 94-1999; revised main contents are as follows.

--- Increasing the semi-automatic solid-state gas pressure welding equipment and equipment at room temperature right angle cutting machine requirements;

--- Increase oxygen LPG multi-mouth ring heater nozzle, modify the multi-mouth ring tube heater basic parameters;

--- Increase the electric pump flow test requirements, modify the electric pump test system illustrations;

--- Modify the axial pressure of the pressurizer requirements, increase the top pressure test method;

--- Modify the welding fixture chuck and cylinder parallelism test method;

--- Modify the basic dimensions of the mandrel and casing.

This standard proposed by the Ministry of Housing and Urban Standard and Design Institute.

This standard by the Ministry of Housing and Urban Construction Safety Standardization Technical Committee centralized.

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1 Scope

This standard specifies the classification and marking of bar gas welder, requirements, test methods, inspection rules, signs, packaging and storage.

This standard applies to multi-mouth ring tube heater, pressurizer and welding fixture consisting of three parts of manual or electric steel bar welding machine.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 3766 Hydraulic System General Specifications GB 9448 Welding and cutting safety GB/T 10544 wire wound reinforced rubber covered hydraulic rubber hose and hose assemblies GB 50150 electrical installations installation of electrical equipment handover test standards JG J18 steel welding and acceptance procedures JG J27 steel welded joints test methods and standards

3 Terms and definitions

The following terms and definitions apply to this document.

Steel gas pressure welding gaspressureweldingofreinforcingsteelbar the use of oxyacetylene flame or oxygen gas oil gas flame, butt the two steel heating, so that it reached the thermoplastic state (solid) (1150 °C ~ 1250 ° C), or in the molten state (above 1540 ° C), a pressure-welding method.

Reinforced air pressure welder gaspressurewelderofreinforcingsteelbar by the multi-mouth ring tube heater, pressure device, welding fixture for the composition of bar welding machinery.

Oxyacetyleneflame

The flame produced by the mixed combustion of oxygen (O2) and acetylene (C2H2), the maximum temperature is 3150 °C.

Oxygen liquefied petroleum gas flame oxy-liquefiedpetroleumgasflame Combustion of liquefied petroleum gas and oxygen formed by the flame, the maximum temperature of 2200 °C ~ 2800 °C.

Multi-mouth ring tube heater multiplenozzlesringcanalheater Flame heater consisting of gas mixing chamber and heating coil. Gas mixing is mainly spray-type, but also pressure type.

Nozzle flamenozzle

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The mixed gas thereby ejects the ignited flame-producing part.

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