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

YC/T 10.3-2018

Replacing YC/T 10.3-2006

**Tobacco Machinery General Technical Conditions Part 3:
Weldments
(English Translation)**

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Foreword

YC/T 10 "General Technical Conditions for Tobacco Machinery" is divided into 16 parts.

- Part 1. Cutting parts;
- Part 2. Cold work;
- Part 3. Welded parts;
- Part 4. Gray cast iron parts;
- Part 5. Ductile iron castings;
- Part 6. Cast carbon steel parts;
- Part 7. Copper alloy castings;
- Part 8. Aluminum alloy castings;
- Part 9. Forgings;
- Part 10. Metal plating and chemical treatment;
- Part 11. Painting;
- Part 12. Assembly;
- Part 13. Packaging;
- Part 14. Electrical control systems;
- Part 15. Electrical control system assembly;
- Part 16. Polished and brushed stainless steel parts.

This part is the third part of YC/T 10.

This part is drafted in accordance with the rules given in GB/T 1.1-2009.

This part replaces YC/T 10.3-2006 "General Technical Conditions for Tobacco Machinery

Part 3. Welded Parts", and YC/T 10.3-Compared with 2006, the main technical changes except editorial changes are as follows.

- Unspecified dimensional tolerances directly refer to national standards (see 3.4.1.5, 3.5.6, 2006 editions 3.4.1.3, 3.5.6);
- Removed the requirements for welding personnel (see 2006 edition 3.1.7);
- Increased the general requirements for the welding of stainless steel sheet metal parts (see 3.1.8~3.1.10, Table 1);
- Modified the requirements of the welding process (see 3.3.1, 2006 version 3.3.1);
- Revised the thickness requirements of the flame cutting board (see Table 2, Table 1 of the 2006 edition);
- Increased dimensional deviation requirements for water cutting and cutting (see Table 4);
- Increased dimensional deviation requirements for laser cutting blanks (see 3.4.1.4);
- Modified the angular limit deviation requirements of the splicing piece (see 3.5.6, 2006 version 3.5.6);
- Modified the dimensional deviation requirements of welded parts (see Table 7, Table 5 of the 2006 version);
- Modified the general tolerance requirements for the flatness, straightness and parallelism of welded parts (see Table 8, Table 6 of the 2006 edition);
- Modified the angular deviation requirements of the welded parts (see Table 9, Table 7 of the 2006 version);
- Increased the quality requirements for stainless steel fusion welding (see 3.6.2.6, 3.6.2.7, 3.6.2.9);
- Increased welding requirements for stainless steel sheet metal parts (see 3.6.2.8);
- Increased the quality requirements for stainless steel resistance welding (see 3.6.3.5);
- Increased the requirements of the leak test (see 4.4);
- Increased the requirements for stainless steel welding quality inspection rules (see 5.6).

This part is proposed by the National Tobacco Monopoly Bureau.

This part is under the jurisdiction of the National Tobacco Standardization Technical Committee Smoke Machine Subcommittee (SAC/TC144/SC3).

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1 Scope

This part of YC/T 10 specifies the general technical requirements, test methods and inspection rules for tobacco mechanical welded parts.

This section applies to carbon steel, low alloy steel, stainless steel, non-ferrous metals and their alloys by means of fusion welding, electric resistance welding and brazing.

Welded parts of tobacco machinery.

This section does not apply to welded parts of pressure vessels.

2 Normative references

The following documents are indispensable for the application of this document. 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 324 weld symbol notation GB/T 985.1 Recommended groove for gas welding, electrode arc welding, gas shielded welding and high energy beam welding GB/T 985.2 recommended groove for submerged arc welding GB/T 1804 General tolerances for tolerances of linear and angular dimensions GB/T 2650 welded joint impact test method GB/T 2651 welded joint tensile test method GB/T 2653 welded joint bending test method GB/T 2654 welded joint hardness test method GB/T 3323 metal fusion welding joints radiography GB/T 3375 welding terminology GB/T 5185 welding and related process code GB/T 12212 Technical drawing weld symbol size, proportion and simplified representation JB/T 4381 Limit deviation of uncut tolerance dimensions for stamping and shearing NB/T 47015-2011 Pressure Vessel Welding Procedure

3.1 General provisions

3.1.1

The manufacture of welded parts is to comply with the product drawings, process documentation and the provisions of this section.

3.1.2

If there are other special requirements for the welded parts beyond the scope of this part, they shall be indicated in the technical requirements of the drawings.

3.1.3

The weld symbol in the product drawings and process documents shall comply with the

provisions of GB/T 324, the dimensions, proportions and simplified representation of the weld symbol.

According to the provisions of GB/T 12212, the welding terminology shall comply with the provisions of GB/T 3375, and the indication code of the welding method shall comply with GB/T 5185.

Provisions.

3.1.4

Quality classification of welds According to GB/T 3323, welds of type I, II and III are important load-bearing welds, weld grades and welds.

Mechanical properties and other performance test requirements shall be indicated in the technical requirements of the drawings or in the technical documentation. Any weld that does not indicate the weld level, generally