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PROFESSIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

中华人民共和国机械行业标准

JB/T 9626-1999

Replace ZB J98 016-89

Specification for Boiler Forging

锅炉锻件 技术条件

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Foreword

This standard is a recension of Specification for Boiler Forging (ZB J98 016-89).The major technique difference between this standard and ZB J98 016-89 is given below: 1. Adding the introduction of normative standard;

2. Comparing with the primary standard, one steel grade is added and the mechanical property of one normal thickness range of the primary steel grade is extended;

3. The maximum diameter or thickness in the primary standard is modified as normal thickness in this standard, and the definition of the normal thickness of ordinary shape forging is given; 4. The Index value of impact toughness α_{ku} of steel grade is added in this standard (Informative Annex).

This standard replaces ZBJ98016 - 89 since the implemented date.

Annex A of this standard is informative.

This standard was proposed by and under the jurisdiction of China Standardization Committee on Boilers. This standard was drafted by the reediting group of professional standard of boilers and Wuhan Boiler Co., Ltd. This professional standard was prepared by Xu Jianlan, Dang Zhen, Xiao Huifang and He Zhenkang.

Specification for Boiler Forging

锅炉锻件 技术条件

1. Scope

This standard specifies the manufacture and acceptance requirements of boiler forging.

This standard is applicable to the fixed hot water boiler and the fixed steam boiler whose rated steam pressure is not larger than 13.7MPa and rated vapor temperature is not larger than 540℃, also, the standard may be adopted in steam boiler of subcritical pressure.

2. Normative References The following normative documents contain provisions which, through reference in this text, constitute provisions of this standard. At time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the latest editions of the standards indicated below.

GB/T228-1987	Standard Test Methods for Tension Testing of Metallic Materials
GB/T229-1994	Metallic Materials-Charpy Notch Impact Test
GB/T231-1984	Metal Brinell Test Method
GB/T699-1988	Technical Requirements on Quality Carbon Structure Steel
GB/T1220-1992	Stainless Steel Bars
GB/T3077-1988	Specifications of Alloy Structure Steels
GB/T 6397-1986	Metallic materials--Test pieces for tensile testing
GB/T10561-1989	Steel-Determination of Content of Non-metallic Inclusion-Micrographic Method Using Standard Diagrams
JB4730-1994	Nondestructive Testing of Pressure Vessels
YB/T5148-1993	Metal-methods for Estimating the Average Grain Size

3. Normal Thickness of Tin Member (t)

3.1 Cylinder-shape forging

It is the axial symmetry hollowness forging whose axial length L is larger than its outer diameter D, as shown in Figure 1 (a). T is the normal thickness.

3.2 Annular forging

It is the axial symmetry hollowness forging whose axial length L is less than or equal to its outer diameter D, as shown in Figure 1(b). The small one in L and t is normal thickness.

3.3 Cake-shape forging

It is the axial symmetry solid forging whose axial length t is less than or equal to its outer diameter D, as shown in Figure 1 (c). T is the normal thickness.

3.4 Calathiform forging

It is the axial symmetry forging whose section acts like saucer shape and length H is less than or equal to its outer diameter D, as shown in Figure 1 (d). The large one in t_1 and t_2 is normal thickness.

3.5 Integral flange forging

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