

UDC



NATIONAL STANDARD

OF THE PEOPLE'S REPUBLIC OF CHINA

中华人民共和国国家标准

P

GB 50683-2011

**Code for Acceptance of Field Equipment,
Industrial Pipe Welding Construction
Quality**

**现场设备、工业管道焊接工程
施工质量验收规范**

Issued on: February 18, 2011

Implemented on: May 1, 2012

Jointly issued by the Ministry of Housing and Urban-Rural Development (MOHURD) and the General Administration of Quality Supervision, Examination and Quarantine (AQSIQ) of the People's Republic of China

National Standard of the People's Republic of China

中华人民共和国国家标准

Code for Acceptance of Field Equipment,
Industrial Pipe Welding Construction Quality

现场设备、工业管道焊接工程
施工质量验收规范

GB 50683-2011

Chief Development Department:

China Association of Engineering Construction Standardization - Chemical
Engineering Subcommittee

Approval Department:

Ministry of Housing and Urban-Rural Development of
Ministry of Housing and Urban-Rural Development (MOHURD) of the
People's Republic of China

Implementation Date:

May 1, 2012

China Planning Press

中国计划出版社

2012 Beijing

**Announcement of the Ministry of Housing and
Urban-Rural Development of the People's Republic of China**

No. 939

**Announcement on Issuing the National Standard "Code for
Acceptance of Field Equipment, Industrial Pipe Welding Construction
Quality"**

“Code for Acceptance of Field Equipment, Industrial Pipe Welding Construction Quality” is hereby approved as national standard with the serial number as GB 50683-2011 and shall be implemented on May 1, 2012. Therein, Article 3.2.3 (4) is mandatory and must be enforced strictly.

Authorized by the Standard Rating Research Institute of the Ministry of Housing and Urban-rural Development of the People's Republic of China, this code is published and distributed by China Planning Press.

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

February 18, 2011

Foreword

This code was redeveloped based on “Code for Construction and Acceptance of Field Equipment, Industrial Pipe Welding Engineering” GB 50236-8 by the China Petroleum & Chemical Engineering Survey and Design Association and China Petroleum Jilin Chemical Engineering & Construction Co., Ltd in conjunction with the concerned departments in the industry according to the requirements of Document Jianbiao [2007] No. 126 issued by the former Ministry of Construction (MOC) - “Notice on Printing the Development and Revision Plan of Engineering Construction Standards and Codes in 2007 (the second batch). The new standard is named as “Code for Quality Acceptance of Field Equipment, Industrial Pipe Welding Construction Quality”.

The drafting group of this code formulated this code by carrying out extensive investigations, earnestly summarizing the practical experiences, making reference to the related international standards and foreign advanced standards and based on also extensively soliciting opinions and the code is finalized after review finally.

This code comprises of eight chapters and one appendix. The major technical content includes: General Provisions, Terms, Fundamental Ruler, Materials, Preparation before Welding, Welding, Heat Treatment after Welding and Welding Quality Examination.

The provisions printed in bold type in this code are compulsory and must be enforced strictly.

The Ministry of Housing and Urban-Rural Development of the People's Republic of China is in charge of the administration of this code and the explanation of the compulsory provisions, the Branch on Chemical Industry of China Association for Engineering Construction Standardization is in charge of the current management of this code, and the National Administrative Center of Standardization of Chemical Construction is responsible for the explanation of specific technical contents. During the process of implementing this code, the relevant opinions and advice, whenever necessary, can be posted or passed on to National Administrative Center of Standardization of Chemical Construction (address: Room 1-1-1107, No. 28, Benevolence hotel, Huai'an East Road, Qiaodong District, Shijiazhuang City, Hebei Province, 050020, China) for reference during future update.

Chief development organization, participating development organization, chief drafting staffs and chief examiners of this code:

Chief development organizations:

China Petroleum & Chemical Engineering Survey and Design Association
China Petroleum Jilin Chemical Engineering & Construction Co., Ltd.

Participating development organizations:

China National Chemical Engineering Third construction Co., Ltd.
Tenth Construction Company of Sinopec
Shanghai Baoye Group Corp., Ltd
Beijing Electric Power Construction Company
China CMIIC Engineering & Construction Corporation
Harbin Welding Institute
China Nuclear Industry 23 Construction Co., Ltd.

Shiyiye Construction Group Co, Ltd
Wison (China) Chemical Engin
Amec Engineering Consultation (Shanghai) Co., Ltd.
China Metallurgical Construction Group Research Institute
Beijing Yanhua Construction Engineering Co., LtdNational Administrative Center of
Standardization of Chemical Construction

Chief drafting staffs:

Xia Jiewen, Guan Yizhuo, Zhao Xiping, Lu Lixiang, Ren Yongning, Wnag Lijuan,
Piao Dongguang, Shao Gang, Zhang Yong, Sun Zhongliang, Yang Hui, Duan Bin,
Yang Lei, Lu Tian andYan Zuqing

Chief examiners:

Ji Zhanghong, Ge Zhaowen, Ji Fangqi, Wang Mingtao, Li Xiaosong, Yuan
Zhuandong, Li Zhiyuan, Guo Jun, Qiao Yaxia, Shi Xuejun, Zhang Ximin, Zhou
Wuqiang, Jiang Guiying and Li Xiaoqiong

Contents

Foreword	I
1 General Provisions	1
2 Terms	1
3 Basic Requirements	1
3.1 Division for Acceptance of Construction Quality	1
3.2 Acceptance of Construction Quality	1
3.3 Procedure and Organization for Acceptance of Construction Quality	2
4 Materials	2
5 Preparation before Welding	3
6 Welding	7
7 Heat Treatment after Welding	8
8 Examination of Welded Seam Quality	10
8.1 Visual Quality Examination of Welded Seam	10
8.2 Nondestructive Detection of Welded Seam Surface	14
8.3 Radiographic Examination and Ultrasonic Flaw Detection for Welded Seam	15
8.4 Other Examination	16
Appendix A Record for Quality Acceptance of Sub-item Project	17
Explanation of Wording in This Code	18
List of Quoted Standards	19

Code for Acceptance of Field Equipment, Industrial Pipe Welding Construction Quality

现场设备、工业管道焊接工程施工质量验收规范

1 General Provisions

1.0.1 This code was formulated in order to unify the acceptance of welding quality acceptance of field equipment and industrial pipelines and strengthen the engineering quality management.

1.0.2 This code is applicable to the construction quality acceptance of the welding engineering of the metallic materials such as carbon steel, alloy steel, aluminium and aluminium alloy, copper and copper alloy, nickel and nickel alloy, titanium and titanium alloy as well as zirconium and zirconium alloy.

1.0.3 The codes shall be applied together with "Code for Construction of Field Equipment, Industrial Pipe Welding Engineering" (GB 50236).

1.0.4 The requirements for the construction quality acceptance of engineering technical document and contract agreement document shall not be less than those specified in this code.

1.0.5 Except meeting this code, the acceptance of welding engineering construction quality shall also meet the requirements of the current relevant national standards.

2 Terms

2.0.1 100% examination

The entire examination of a specific item in a specified examination batch

2.0.2 Random sampling examination The examination is conducted on a specific item by a certain proportion of random sampling.

2.0.3 Local sampling examination A specific part of examination is conducted for a specific item on every piece in a specific examination batch.

3 Basic Requirements

3.1 Division for Acceptance of Construction Quality

3.1.1 The welding engineering quality acceptance of field equipment and industrial pipelines shall be conducted on the division into the sub-item project.

3.1.2 The sub-item project of field equipment welding engineering shall be divided according to the piece of field equipment and the sub-item project of industrial pipeline welding engineering shall be divided into according to the pipeline grades and materials.

3.2 Acceptance of Construction Quality

完整版本请在线下单

或咨询：

TEL： 400-678-1309

QQ： 19315219

Email：info@lancarver.com

<http://www.lancarver.com>

对公账户：

单位名称：北京文心雕语翻译有限公司

开户行：中国工商银行北京清河镇支行

账 号：0200 1486 0900 0006 131

支付宝账户：info@lancarver.com

注：付款成功后，请预留电邮，完整版本将在一个工作日内通过电子 PDF 或 Word 形式发送至您的预留邮箱，如需索取发票，下单成功后的三个工作日内安排开具并寄出，预祝合作愉快！