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ELECTRIC POWER INDUSTRY STANDARD OF

THE PEOPLE'S REPUBLIC OF CHINA

中华人民共和国电力行业标准

DL/T 821-2002

Replacing: DL/T 5069-1996

**The code of radiographic examination of butt
Welded-joints of pressure steels pipes and tubes**

钢制承压管道对接焊接头射线检验技术规程

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NOTICE

This code is written in Chinese and English. The Chinese text shall be taken as the ruling one in the event of any inconsistency between the Chinese text and the English text.

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Foreword

According to the request of No.70 Electrical Power document [2000] issued by Electric Power Department of SETC, the Power Construction Institute of the State Power Corporation has organized the corresponding experts in the power industry and established a standard amendment experts group on revising DL/T 5069-1996 “Construction and Check-and-Accept Technical Specification of Electric Power Construction (the radiographic test of pressure steels pipes and tubes)”. Its compiling formats and rules comply with the requirements of DL/T 600-2001 “Basic Standard Compiling Rules of Power Industry”.

The revision of the standard is in the light of international standard “Basic Rules of Non-Destructive Test - Metal X-ray and Gamma-ray Radiographic Test” (ISO 5579-1998).

The revised standard retains the original norms on the deflection inspection procedure which has been proved effective in the long-term practice.

The revised standard increases a new source of y-ray Se75 (selenium 75).

The standard will be implemented replacing DL/T 5069-1996.

Appendix B and Appendix C of the standard are the normative annexes.

Appendix A of the standard is information appendix,

The standard is proposed and placed by the Power Station Welding Standardization Technical Committee of the Power Industry.

The main drafting units of the standard; the Power Construction Institute of the State Power Corporation, Zhejiang Thermal Power Construction Corporation, Tianjin Power Construction Corporation, Heilongjiang No.3 Thermal Engineering Corporation.

The main authors of this standard: Bao Leqing, Yan Zheng, Wu Shusen, Yang Jianping, Li Changhui, Guo Jun.

The Power Station Welding Standardization Technical Committee of the Power Industry takes charge of the explanation of the standard.

The standard is issued first in 1985, and revised for the first time in 1996, and this is the second amendme

The code of radiographic examination of butt welded-joints of pressure steels pipes and tubes

1 Scope

The standard regulates the radiographic procedure and the quality classification of butt welded-joints ("butt joint" for short) of pressure steels pipes and tubes.

When producing, fixing and repairing the electricity generators in the power industry, the standard applies to the radiographic test of the component whose radiographic thickness is 2mm~175mm, such as the pressure tubes and pipes, and the butt joints with one-side welded and double-side shaped. The radiographic test of the welding pipe (the vertical seam welding pipe, the spiral welding pipe) and the pipe fitting (the tee, the junction) can refer to this method.

This standard does not apply to the butt joint welded by the way of friction welding, flash welding and other mechanical welding.

2 Normative Documents Cited

The terms of the following documents through its citing become the terms of this standard. As to the cited documents with the date, all these subsequent modification sheets (not including the contents of the corrigendum), or revisions do not apply to this standard, however, it encourages the parties agreeing on the standard to research whether the latest versions of these documents can be used. As to the cited documents without the date, all these latest versions apply to the standard.

GB 4792 Basic Radiation Health Protection Standard

DL/T 675 Qualification Examination Rules of Non-Destructive Examination Personnel
in the Power Industry

DL 5007 Construction and Check-and-Accept Technical Specification of Electric
Power Construction (Welding in the Thermal Power Station)

JB/T 7902 Linear Image Quality Meter

3 Radiographic Test Personnel

3.1 Basic Conditions of Radiographic Test Personnel



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