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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 5000.3-2007

Replace JB/T 5000.3-1998

**Heavy mechanical general techniques and
standards—Part 3: And standards welding**

**重型机械通用技术条件
第 3 部分：焊接件**

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Forward

JB/T 5000 《Heavy mechanical general techniques and standards》 divided into 15 parts:

- ___ Part one : Product Inspection
- ___ Part two: Oxygen cutting workpiece
- ___ Part three: Weldment
- ___ Part four: Iron casting
- ___ Part five: Cast nonferrous metal
- ___ Part six: Cast steel
- ___ Part seven: Cast Steel repair welding
- ___ Part eight: Forging
- ___ Part nine: Cutting workpiece
- ___ Part ten: Assembly
- ___ Part eleven: Tubing
- ___ Part twelve: Painting
- ___ Part thirteen: Packing
- ___ Part fourteen: Cast steel nondestructive examination
- ___ Part fifteen: Forging steel nondestructive examination

This part is JB/T 5000's part three

This part is instead of JB/T 5000.3-1998 《Heavy mechanical general techniques and standards standards welding》

This part compare to the JB/T 5000.3-1998, the main changes are as follow:

- ___ Added the chamfer treatment to the rolled steel's flexion angular.
- ___ Added the requirement of the tack weld's length, weld leg and quality.
- ___ According to the GB to classify the table 5's steel grade.
- ___ Added the requirement of the annotation and nondestructive examination for the full penetration welds.
- ___ Added the requirement of the weld joint need to have the full and continuous side weld.
- ___ Added that in the condition of ensure the quality, the manufacturer can according to the method of the welding to choose the groove welding way.
- ___ Added that the exposure edge need to be chamfered after you finish the welding.
- ___ According to the structure workpiece's quality status, Cancel the D, H, DS and DK etc. grade's requirement.

This part is offered by the China Machinery Industry Association.

This part is centralized management by the engineering industry metallurgical equipment technical committee for standardization.

This part's draft out unit: Taiyuan heavy mechanical group co., ltd

This part's draftsman: Qingyang Chen, Peijun Chen, Wenhui Hou, Chungang zhen

This part's previous edition:

—JB/T 5000.3—1998

Heavy mechanical general techniques and standards

Part 3:And standards welding

1 Scope

This part in the JB/T 5000 is specify the requirement of the steel weldment's technical requirement,testing method and drawing annotation.

This part is apply to the heavy mechanical and its parts' shielded metal arc welding, gas shielded welding and submerge-arc welding

All drawing, technical document and place order technical condition need to apply to this part unless have special requirement.

2 Normative Reference

Through the quoted by JB/T 5000 , Following documents' items are become to the items of this parts.Any quoted documents if it is dated,the following modify notification (not including the errata contents) or modify edition are not apply to this part.But,the agreement which is according to this part can use this parts'latest edition. If it's not dated,it's latest edition can apply to this part.

GB/T 324 Welds-symbolic representation on drawings (GB/T 324-1998,eqv ISO 2553:1989)

GB/T 985 gas welding, electrode welding and gas shielded welding groove's basic form and the dimension.

GB/T 986 submerged arc welding groove's basic form and the dimension

GB/T 2649 Sampling method of the welded joint's mechanical test

GB/T 2650 Welded joint's impact testing method

GB/T 2651 Welded joint's tensile testing method

GB/T 2652 Welded joint and deposited metal's tensile testing method

GB/T 2653 Welded joint's bend and compression tests

GB/T 2654 Welded joint and deposited metal's rigidity tests

GB/T 3323 Metal melting weld metal's radiogram (GB/T 3323—2005,EN 135:1997,MOD)

GB/T 11345 Steel weld joint ultrasonic equipment for manual testing and result grade of detection

JB/T 3223 Welding material's quality management

JB/T 4735 Steel welding non-pressure vessel

JB/T 5000.2 Heavy mechanical general techniques and standard Part 2:Oxygen cutting workpiece

JB/T 5000.11 Heavy mechanical general techniques and standard Part 11:Tubing

JB/T 5000.12 Heavy mechanical general techniques and standard Part 12: Painting

JB/T 5926 The effective of the VSR Assessment method

JB/T 6046 After the welding,carbon Steel and low alloyed steel wedling structure assembly s thermal method

JB/T 6061 Nondestructive examination weld joint's magnetic particle testing

JB/T 7949 Steel structure weld joint Overall dimensions

3 General requirements

3.1 The manufacture of the weldment need apply to the design, technological documentation and this part's requirement.

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