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**National Standard of the People's Republic of China**  
**中华人民共和国国家标准**

GB/T 985.1-2008

Replace GB/T 985-1988

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**Recommended Joint Preparation for Gas  
Welding, Manual Metal Arc Welding,  
Gas-shield Arc Welding and Beam Welding**

**气焊、焊条电弧焊、气体保护焊和高能束焊的推  
荐坡口**

(ISO 9692-1:2003, Welding and Allied Processes--Recommendations  
for Joint Preparation—Part 1: Manual Metal Arc Welding, Gas-Shield  
Arc Welding, Gas Welding, TIG Welding and Beam Welding of Steels,  
MOD)

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Jointly Issued by **General Administration of Quality Supervision, Inspection  
and Quarantine and Standardization Administration of the  
People's Republic of China**

## Foreword

The standard GB/T 985 is divided as following 4 parts:

- GB/T 985.1 Recommended Joint Preparation for Gas Welding, Manual Metal Arc Welding, Gas-shield Arc Welding and Beam Welding;
- GB/T 985.2 Recommended Joint Preparation for Submerged Arc Welding;
- GB/T 985.3 Recommended Joint Preparation for Gas-shield Arc Welding on Aluminum and Its Alloys;
- GB/T 985.4 Recommended Joint Preparation for Welding on Clad Steels.

The standard GB/T 985.1 is referred to Part 1.

The part is modified partially in relation to ISO 9692-1:2003, "Welding and allied processes-Recommendations for Joint Preparation-Part 1: Manual Metal Arc Welding, Gas-Shield Arc Welding, Gas Welding, TIG Welding and Beam Welding of Steels" (English edition).

The part is redrafted reference to ISO 9692-1: 2003. There are some technical content changes in this national standard over ISO 9692-1: 2003 in the following technical aspects:

—Appendix A is added.

In order to facilitate the application, the part has following editorial revisions:

—The foreword of the international standard is canceled;

—The standard name is changed to "Recommended Joint Preparation for Gas Welding, Manual Metal Arc Welding, Gas-shield Arc Welding and Beam Welding";

—Other international standards referred by ISO 9692-1: 2003, that the standard is identical to or is modified in relation to, shall be replaced to corresponding Chinese national standards;

—Order numbers in tables are regulated.

This part replaces the GB/T 985-1988 "Basic Forms and Sizes of Weld Grooves for Gas Welding, Manual Arc Welding and Gas-shielded Arc Welding".

There are some changes in this part over GB/T 985 in the following aspects:

—Beam welding joint is added in applicable scope;

—Joint Preparation (weld groove) is classified as one side welding type and both sides welding type;

—Corresponding welding method is recommended for each weld groove;

—Narrow gap welding groove is added.

Appendix A in this part is normative one.

This part is proposed and under the jurisdiction of China National Standardization Technical Committee of Welding.

This part is prepared by Harbin Welding Institute and Dongfang Boiler (Group) Co., Ltd.

This part is drafted by Piao Dongguang, Pan Qian'gang and Chu Jijun.

The part replaces following editions issued previously:

——GB 985-1967、GB 985-1980 and GB/T 985-1988.

## 1 Scope

The part of GB/T 985 specifies forms and sizes of steel welding groove. And this part is applicable to gas welding, manual metal arc welding, gas-shield arc welding and beam welding.

## 2 Normative References

The following documents contain contents which, through reference in this text, composite provisions of this part of GB/T 985. For dated reference, subsequent amendments (excepting corrigenda content) to, or revisions of, any of these publications do not apply. Parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. For undated references, the latest edition of the normative document referred to applies.

GB/T 324 Welds-symbolic Representation on Drawings (GB/T 324-1988, eqv ISO 2553: 1984).

GB/T 5185 Welding, Brazing, Braze Welding and Soldering of Metals-List of processes, for Symbolic Representation on Drawings (GB/T 5185-2005, ISO 4068: 1998, IDT)

GB/T 16672 Welds-Working Positions-Definitions of Angles of Slope and Rotation (GB/T 16672-1996, idt ISO 6947: 1993)

## 3 General Provision

This part specifies form and size butt joint weld groove on the principle of full fusion penetration. For butt joint without full fusion penetration, welding grooves of other forms may be allowed. The representation of welding symbols is specified in GB/T 324. The welding position arrangement is detailed in GB/T 16672.

## 4 Welding Method

Weld grooves specified in Table 1~Table 4 are applicable to corresponding welding method. In case of need, combination of two or more applicable welding methods may be adopted.

Welding method code is detailed in GB/T 5185.

## 5 Weld Groove Bottom Edge Burnishing

From the process, the bottom edge of the non-blunt-edged weld groove may be burnished and certain blunting volume shall be reserved.

## 6 Recommended Form and Size of Weld Groove

### 6.1 Single-Sided Butt-Welding Groove

Table 1 specifies form and size of single-sided butt-welding groove. On horizontal position of welding, the groove angle (or groove face angle) may be increased properly, and may be dissymmetrical type. Given clearances are applicable to tack welding condition.

### 6.2 Double-sided Butt Welding Groove



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