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**NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC
OF CHINA**

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GB/T 15169-2003

Welder skill evaluation for steel melted weld

钢熔化焊焊工技能评定

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Foreword

This Standard is revision of GB/T 15169-1994 *Qualification examination method for steel melted welder by hands*. Based on using ISO 9606: 1994 and its supplement ISO 9606/Amd: 1998 for reference in revising, this Standard has adopted in an equivalent manner the European standard draft pr EN ISO 9606-1:2002 *Welder examination , melted welding first part: steel*(this draft is equal to ISO draft fully). In order to ensure the applicability and coordination of standard, this standard has made some necessary treatment of normative cited documents in equality conversion. This standard compared with the original standard, the major modifications in technical content are given as the follows:

--- Welder examination is emphasized in operation test, and it is no hard rule in professional knowledge;

--- The examination rule and approval scope is emphasis in main parameters of welding examination as basis.

--- Material group, test method and acceptance rule is emphasis in international uniform requirement

This Standard will replace GB/T 15169 – 1994 since the implementation date.

This Standard is proposed by China Machinery Industry Federation.

This Standard is under the jurisdiction of National Technical Committee of Welding Standardization.

This Standard is drafted jointly by Harbin Welding Institute, Harbin Welding Training Centre and Dong Fang Boiler Group CO.LTD as units in charge

Main drafters of this standard are Pu DongGuang, Wang Lin, Qin GuangMei and Zou Jie.

Welder skill evaluation for steel melted weld

1 Scope

This standard specifies the examination method for steel melted welder.

In order to ensure the examination to suitable for difference product type, area and examination institution, this standard affords skill evaluation rule system for welder.

This standard is emphasized in testing welder to operate hawkbill, welding gun and torch by hand, and their skill for welding qualified seam.

This standard applies to manual welding and semi-automatic welding method, and it does not apply to mechanized and automatic welding method.

2 Normative References

The articles contained in the following documents have become this standard when they are quoted herein. For the dated documents so quoted, all the modifications (excluding corrections) or revisions made thereafter shall not be applicable to this Standard. For the undated documents so quoted, the latest editions shall be applicable to this Standard.

GB/T 3375 Welding terms

GB/T 5185 Expressing code for metal welding and brazing method in pattern

GB/T 16672-1996 Weld working position the definition of dip angle and rotation angle

GB/T 19418-2003 Arc welding joints of steel the quality grade guide of defect

ISO 9017: 2001 Destructibility test for weld of metal material

ISO/TR 15608 Welding guide for classification system of metal material

3 Terms

For the purposes of this Standard, the following terms and definitions given in GB/T 3375 shall apply.

3.1 Welder

The person who operates hawkbill, welding gun and torch by hand.

3.2 Examiner

Some body who is appointed to check whether it accords with application standard.

3.3 Examining body

Some organization which is appointed to check whether it accords with application standard

3.4 Backing

A foil which is preset along the back of joint to ensure the root of joint to weld fully and the back of weld to shape.

3.5 Root run

During multi-layer welding, the run which welds in the root

3.6 Filling run

During multi-layer welding, the run which deposit behind root run and in front of capping run

3.7 Capping run

During multi-layer welding, the run which can be seen in the surface of weld seam while finishing

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