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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 19867.1-2005

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**Welding procedure specification for arc welding**

**电弧焊焊接工艺规程**

(ISO 15609-1: 2004, Specification and qualification of welding procedures for  
metallic materials – Welding procedure specification – Part 1: Arc welding, IDT)

**Issued on Aug 10, 2005**

**Implemented on Apr 01, 2006**

**Issued by**

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

**Standardization Administration of the People's Republic of China**

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## **Forward**

This Code is equivalent to ISO 15609-1: 2004 *Specification and qualification of welding procedures for metallic materials -- Welding procedure specification -- Part 1: Arc welding*

In order to ensure the coordination and maneuverability of this Standard, it made necessary changes for this Standard when refers to ISO.

In comparison with ISO 15609-1, Main changes of this Standard as follows:

- Adopted the terms in GB/T 3375 *Welding Terms*;
- Added the Annex B, for explanation of classification of related materials;
- Deleted the Article 4.1 in ISO 15609-1 which unrelated to technical contents, relevant explanations will be integrated in Article 4.1 of this Code.
- Article 4.4.13 in ISO 15609-1 is error, this Code adjusted for that.

This Code is first issued.

The Annex A and B of this Code are informative annex.

This Code is proposed by China Mechanical Industry Association.

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

Main draft units of this Code are Harbin Welding Research Institute and Harbin Welding Technical Training Center.

Main drafters of this Code are Piao Dongguang, Wang Lin and Qian Qiang.

# **Welding procedure specification for arc welding**

## **1 Scope**

This Standard specifies requirements for the content of welding procedure specifications for arc welding processes.

The variables listed in this Standard are those influencing the quality of the welded joint

This Standard is applicable to arc welding of metal materials

## **2 Normative References**

The provisions of the following GB/T 19867 become provisions of this Standard after being referenced. For dated reference documents, all later amendments (excluding corrigendum) and versions do not apply to this Standard; however, the parties to the agreement are encouraged to study whether the latest versions of these documents are applicable. For undated reference documents, the latest versions apply.

GB/T 3375 Welding Terms

GB/T 5185 Welding, brazing, braze welding and soldering of metals -- List of processes for symbolic representation on drawings

GB/T 16672 – 1996 Welds-Working positions-Definitions of angles of slope and rotation

GB/T 18591 – 2001 Welding--Guidance on the measurement of preheating temperature, interpass temperature and preheat maintenance temperature

GB/T 19866 Specification and qualification of welding procedures for metallic materials — General rules

## **3 Terms and Definitions**

For the purposes of this document, the terms and definitions given in GB/T 3375 and GB/T 19866 apply

## **4 Technical Content of Welding Procedure Specification (WPS)**

### **4.1 General**

A preliminary Welding Procedure Specification / Welding Procedure Specification (WPS) shall provide all necessary information required to make a weld. The information required in a pWPS /WPS is given in 4.2 to 4.5. For some applications it may be necessary to supplement or reduce



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