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Tubular welding rods of tungsten carbide

硬质合金管状焊条

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Foreword

This document was drafted in accordance with the rules given in GB/T 1.1-2020, *Directives for standardization - Part 1: Rules for the structure and drafting of standardizing documents*.

This document replaces GB/T 26052-2010 *Tubular welding rods of tungsten carbide*; compared with GB/T 26052-2010, in addition to structural adjustments and editorial changes, the main technical changes are as follows:

- a) Change the scope of application (see Chapter 1; Chapter 1 of the 2010 edition);
- b) Add the normative reference of GB/T 2967 (see Chapter 2, 5.2 and 6.1);
- c) Add the types of hard particles of tubular welding rods (see Chapter 4);
- d) Change the representation of designations (see Chapter 4; 3.1 of the 2010 edition);
- e) Add the designation of HTYZ (see Chapter 4);
- f) Delete “mechanical properties” (see 3.3 of the 2010 edition);
- g) Change the representation of hard particle size and particle size composition (see 5.3; 3.1 of the 2010 edition);
- h) Add the tubular welding rod with a diameter of “6.0” and a length of “400, 500, 700” (see 5.5);
- i) Change the test method for the filling rate of welding rods (see 6.3; 4.3 of the 2010 edition);
- j) Change the sampling quantity for chemical composition, physical properties and structure, as well as hard particle size (see 7.3; 5.3 of the 2010 edition);
- k) Change the packaging method (see 8.2; 6.2 of the 2010 edition).

Please note that some of the contents of this document may involve patents. The issuing organization of this document is not responsible for identifying patents.

This document was proposed by the China Nonferrous Metals Industry Association.

This document shall be under the jurisdiction of National Technical Committee 243 on Nonferrous Metals of Standardization Administration of China (SAC/TC 243).

Drafting organizations of this document: Zigong Great Wall Hardfacing Materials Co., Ltd., Luoyang Golden Egret Geotools Co., Ltd., Kingdream Public Limited Company, China Nonferrous Metals Techno-Economic Research Institute, SHAREATE TOOLS LTD.

Tubular welding rods of tungsten carbide

1 Scope

This document specifies the technical requirements, test methods, inspection rules, marking, packaging, transportation, storage, accompanying documents and order form for tubular welding rods of tungsten carbide.

This document applies to tubular welding rods of tungsten carbide (hereinafter referred to as welding rods) for surface overlaying or brazing of steel parts.

2 Normative references

The following documents are normatively referenced in this document and are indispensable for its application. For dated references, only the version corresponding to that date is applicable to this document; for undated references, the latest version (including all amendments) is applicable to this document.

GB/T 699, Quality carbon structural steels

GB/T 1480, Metallic powders - Determination of particle size by dry sieving

GB/T 2967, Cast tungsten carbide powder

YS/T 412, Cemented carbide pellets

3 Terms and definitions

No terms and definitions need to be defined in this document.

4 Product classification

Welding rods are divided into four designations according to the type of hard particles: HTYZ, HTYQ4, HTYQ6, and HTYQ7, as shown in Table 1.

7.4.2 When the hard particle size test result is unqualified, double sampling shall be taken in the batch of products for repeated inspection of the unqualified items. If any item is still unqualified in the test result, the batch of products shall be judged unqualified.

7.4.3 When the test result of filling rate of the welding rod is unqualified, double sampling shall be taken from the batch of products for a repeated inspection of the unqualified items. If any item is still unqualified in the test results, the batch of products shall be judged unqualified.

7.4.4 If the inspection result of the welding rod size and allowable deviation is unqualified, the welding rod shall be judged as unqualified.

7.4.5 If the inspection result of the welding rod appearance quality is unqualified, the welding rod shall be judged as unqualified.

8 Marking, packaging, transportation, storage and accompanying documents

8.1 Marking

The following markings (or labels) shall be placed on the product packaging:

- a) name and address of the supplier;
- b) product name and designation;
- c) batch number;
- d) net weight;
- e) number of this document.

8.2 Packaging

The product shall be packed in anti-rust paper (or kraft paper), put into a double-layer plastic bag or an aluminum-plastic bag, and vacuumized, and then put into a plastic box or a cardboard box. The net weight of each box is generally 3 kg ~ 8 kg, or determined by the supplier and the buyer.

8.3 Transportation

The product, during transportation, shall be protected from moisture. During the handling process, it shall be lightly loaded and unloaded, and violent collision and mechanical extrusion shall be prevented.

8.4 Storage

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