

( )

INTERSTATE COUNCIL FOR STANDARDIZATION, METROLOGY AND CERTIFICATION  
(ISC)

**ISO 9692-2—  
2020**

2

**(ISO 9692-2:1998, IDT)**

2020

1.0 «  
 1.2 «  
 »  
 1 «  
 » ( « »)  
 5  
 2 364 «  
 3 ( -  
 29 2020 . Ne 130- )  
 :

( 3166) 004-97	( 3166) 004—97	
	AM BY KG RU UZ	

4 8  
 2020 . 346- ISO 9692-2—2020  
 1 2020 .  
 5 ISO 9692-2:1998 «  
 2.  
 («Welding and allied processes — Joint preparation — Part 2: Submerged arc welding of steels». IDT).  
 ISO/TC 44 «  
 », SC 7.

6



ISO 9692

- 1. ; ;
- 2. ;
- 3. ;
- 4. .

Welding and allied processes. Joint preparation. Part 2. Submerged arc welding of steels

— 2020—12—01

1

( 121 ISO 4063).

ISO 6947.

PC

( . ISO 4063),

ISO 9692-1.

2

( ):  
 ISO 2553:1992, Welded, brazed and soldered joints — Symbolic representation on drawings ( )

ISO 3834-1:1994, Quality requirements for welding — Fusion welding of metallic materials — Part 1: Guidelines for selection and use ( )

1.  
 ISO 3834-2:1994, Quality requirements for welding — Fusion welding of metallic materials — Part 2: Comprehensive quality requirements ( )

2.  
 ISO 3834-3:1994, Quality requirements for welding — Fusion welding of metallic materials — Part 3: Standards quality requirements ( )

3.  
 ISO 3834-4:1994, Quality requirements for welding — Fusion welding of metallic materials — Part 4: Elementary quality requirements ( )

4.  
 ISO 4063, Welding and allied processes — Nomenclature of processes and reference numbers ( )

ISO 9692-2—2020

ISO 6947:1990. Welds — Working positions — Definitions of angles of slope and rotation ( )

ISO 9692:1992 Metal-arc welding with covered electrode, gas-shielded metal arc welding and gas-welding — Joint preparations for steel ( , )

ISO 9956-2:1995<sup>2></sup>. Specification and approval of welding procedures for metallic materials — Part 2: Welding procedure specification for arc welding ( 2. )

3

4

1 2.

ISO 3834)

1 2. (

ISO 9956-2.

ISO 2553;

( )—

ISO 9692-1:2003 «

1.

21

ISO 15609-1:2004 «

1.

1.

{ ISO 2553}

.0

( ISO 69\*7i



6S0.51  
max 5

1.3	$10 \leq r \leq 20$	С V-образным скосом кро- мок				$30^\circ \leq \alpha \leq 50^\circ$	$4 \leq b \leq 8$	$c \leq 2$
1.14	$r > 20$	С V-образным скосом кромки с уве- личенным зазором				$4^\circ \leq \beta \leq 10^\circ$	$10 \leq b \leq 25$	—
1.3.3	$r > 12$	С V-образным скосом кромки и с V-образным скосом для корня шва				$60^\circ \leq \alpha \leq 70^\circ$ $4^\circ \leq \beta \leq 10^\circ$	$1 \leq b \leq 4$	$0 \leq c \leq 3$

4 Shi  
6

5  
0.51

5  
0.5

5  
0.5

\*\*

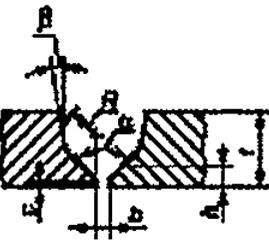
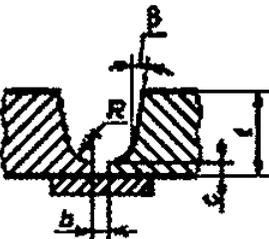
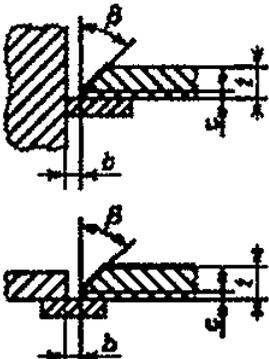
1

1 -  
L

13.7 12

U-

U-

Обозначение (по ISO 2553)	Изображение сварного шва	Поперечное сечение
		
		
		

60°2  
2 70° 12624  
4°2 2 52 210 °SCS3 6  
10°

30° 2  
α  
50°

R.

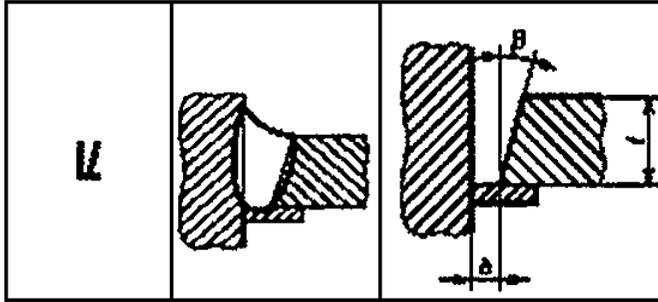
ISO 69471

5  
05

5  
051

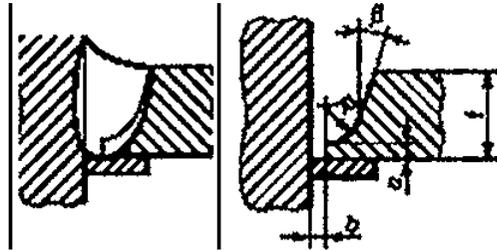
L 0 081 ( ISO 2553)

1.15 16



1.8 816

(J-



«.		-	-	{
				ISO 6947)
8'sps 10*	5St»S 15	—	—	
4'S pS 10*	2SE>S4 5SRS 10	2SCS3	—	

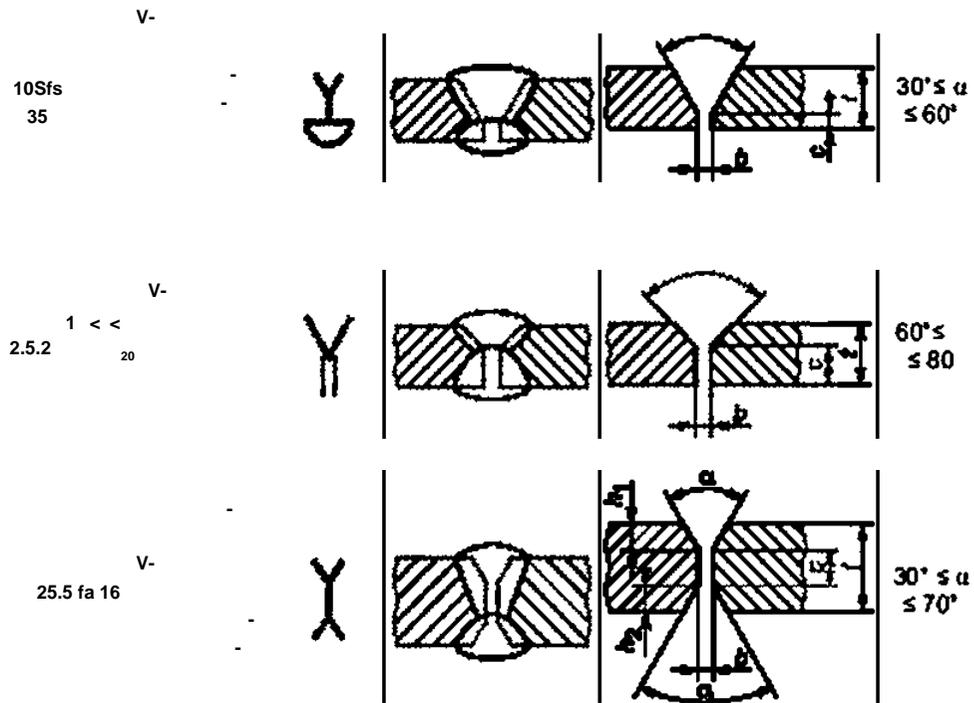
5  
05 t

», 5  
0,5/

t, » < -  
ISO 2553}

« ( «30 6947»

2.2 3 s £ 20

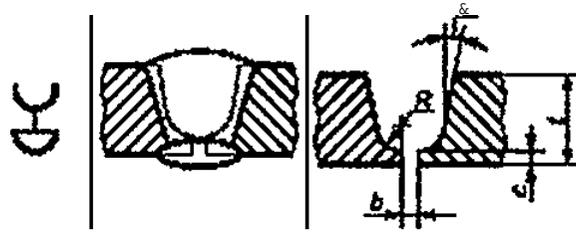


I

EO 25531

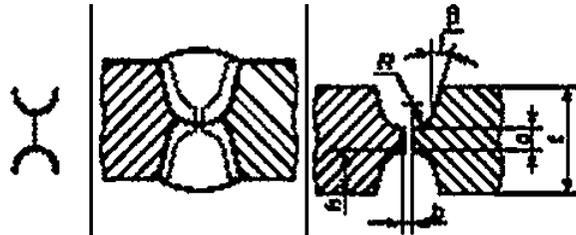
(no ISO 69471)

U-



50

С двусто-  
ронним  
U-образным  
скосом кромок



$$5^\circ \leq \beta \leq 10^\circ$$

$$\begin{matrix} b \leq 4 \\ 5 \leq R \leq \\ 10 \end{matrix}$$

$$4 \leq c \leq 10$$

$$h = 0,5 (t - c)$$

PA

v-

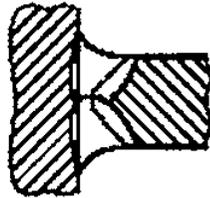
woe

t.

<  
60 2553}

< ISO 6947}

2.6.6



30\* sp  
S50'

4S cs  
10

V-



J-

26.9

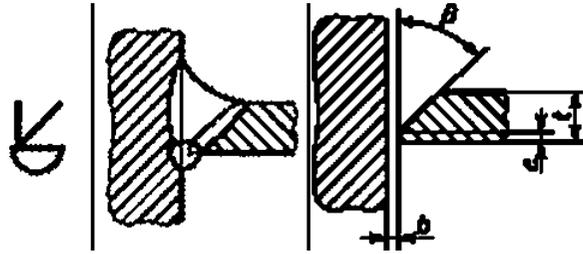
4ScS  
10

woe

(  
SO 2553)

ISO 6947)  
h.

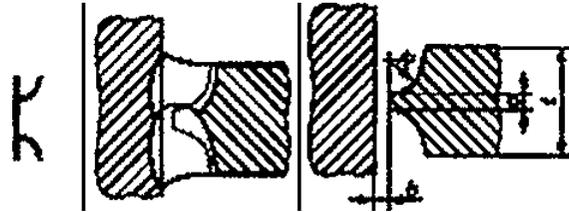
t < 12



28.8

f 30

J-



$$5' \leq \beta \leq 10'$$

$$\begin{matrix} b \leq 4 \\ 5 \leq R \leq 10 \end{matrix}$$

$$2 \leq c \leq 7$$

v-

I.

(  
60 25531

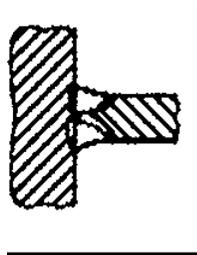
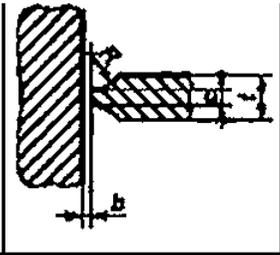
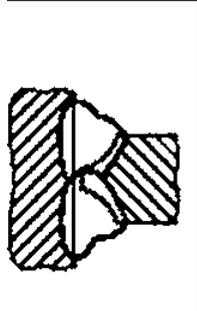
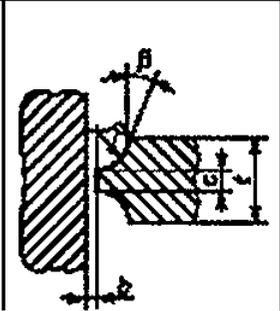
0.0

(no ISO 6947)

2.8.8

(i) 12

J-  
on

		<p>—</p>	<p><math>b \leq 2</math> <math>5 \leq R \leq 10</math></p>	<p><math>2 \leq c \leq 3</math></p>
		<p><math>5^\circ \leq \beta \leq 10^\circ</math></p>	<p><math>b \leq 4</math> <math>5 \leq R \leq 10</math></p>	<p><math>2 \leq c \leq 7</math></p>

28.8

1 > 12

J-

( )

ISO 2553:1992	—	*. 1)
ISO 3834-1:1994	—	•
ISO 3834-2:1994	—	•
ISO 3834-3:1994	—	•
ISO 3834-4:1994	—	•
ISO 4063	—	*.2)
ISO 6947:1990	—	*.3)
ISO 9692:1992	1DT	ISO 9692-1—2016 « 1. - , , »
ISO 9956-2:1995	—	*. 4>
* - - - IDT —		

1> 2553—2017 «  
».

2> 4063—2010 «  
».

3\* 6947—2017 «  
».

4> 15609-1—2009 «  
1. -  
».

: , , ,

10-2018/34

. .  
. .  
. .  
. .

13.07.2020.

12.08.2020. 80\*84/g.  
. . 1.80 .- . . 1.60.

« .117418 . »

[www.goelinfo.ru](http://www.goelinfo.ru) [xifo@goptxifo.ru](mailto:xifo@goptxifo.ru)

- . . 31, . 2.