Standard Specification for Reinforcing Bar Joint Work
: Gas Pressure Welded Joint Work

Contents

Chapter 1  General Rules  1
  1.1  Scope of Application  1
  1.2  Performance of Gas Pressure Welded Joint  1
  1.3  Terms and Definitions  1

Chapter 2  Execution Plan of Joints  4
  2.1  Execution Plan of Gas Pressure Welded Joints  4
  2.2  Coordination Personnel for Joints  4

Chapter 3  Common Items  5
  3.1  Reinforcing Bar  5
  3.2  Gas Pressure Welding Equipment  6
    3.2.1  Gas pressure welding equipment  6
    3.2.2  Gas for gas pressure welding  6
    3.2.3  Gas Supplying Equipment  6
  3.3  Preparation for Gas Pressure Welding Work  6
    3.3.1  Confirmation and presentation of certification document  6
    3.3.2  Maintenance of gas pressure welding equipment and tools  6
    3.3.3  Validation tests before execution  6
    3.3.4  Cutting reinforcing bar and processing gas pressure welded end face  7
    3.3.5  Air temperature/Weather  7
  3.4  Safety Aspects  8

Chapter 4  Manual Gas Pressure Welding  9
  4.1  Gas Pressure Welder with Qualified Skill  9
  4.2  Gas Pressure Welding Equipment  9
  4.3  Installation of Bar Holder  12
  4.4  Pressing and Heating  12
  4.5  Inspection  13
    4.5.1  General  13
    4.5.2  Visual inspection  13
    4.5.3  Ultrasonic inspection  16
    4.5.4  Sampling inspection in ultrasonic inspection  16
4.6 Disposal of Failed Pressure Welded Part 16

Chapter 5 Automatic Gas Pressure Welding 18
5.1 Gas Pressure Welder with Qualified Skill 18
5.2 Gas Pressure Welding Equipment 18
5.3 Installation of Bar Holder 18
5.4 Pressing and Heating 18
5.5 Inspection 19
  5.5.1 General 19
  5.5.2 Visual inspection 19
  5.5.3 Inspection by crosschecking of pressure welding execution record 19
5.6 Disposal of Failed Gas Pressure Welded Part 20

Chapter 6 Hot Trimming Gas Pressure Welding 21
6.1 Gas Pressure Welder with Qualified Skill 21
6.2 Pressure Welding Equipment 21
6.3 Installation of Bar Holder 21
6.4 Pressing, Heating, and Trimming 22
6.5 Inspection 22
  6.5.1 General 22
  6.5.2 Visual inspection 23
6.6 Disposal of Failed Gas Pressure Welded Part 23

Chapter 7 Execution and Inspection of Grade-A Gas Pressure Welded Joint 25
7.1 Grade-A Joint Gas Pressure Welding Company 25
7.2 Gas Pressure Welding Procedure and Reinforcing Bars that can be Pressure Welded 25
7.3 Gas Pressure Welder with Qualified Skill 25
7.4 Validation Tests before Execution 25
7.5 Preparation Work and Pressure Welding Work 26
7.6 Inspection 26
  7.6.1 General 26
  7.6.2 Manual gas pressure welding 26
  7.6.3 Automatic gas pressure welding 27
  7.6.4 Hot trimming gas pressure welding 27
7.7 Disposal of Failed Gas Pressure Welded Parts 27