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Hot rolled steel plate and strip for porcelain enameling

搪瓷用热轧钢板和钢带

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Hot rolled steel plate and strip for porcelain enameling

1 Scope

This Standard specifies the designation representation method and method [Translator note: should be “classification”], ordering contents, dimension, shape, weight, technical requirements, test methods, inspection rules, packaging, marking and quality certificate of hot rolled steel plates and strips for porcelain enameling.

This Standard is applicable to hot rolled steel plates and strips with good porcelain enameling properties and thickness of not more than 40 mm, used in industries such as light industry, household appliances, metallurgy, construction, chemical equipment, water treatment industry (hereinafter referred to as steel plates and strips).

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 222 Permissible tolerances for chemical composition of steel products

GB/T 223.3 Methods for chemical analysis of iron, steel and alloy - The diantipyryl methane phosphomolybdate gravimetric method for the determination of phosphorus content

GB/T 223.9 Iron, steel and alloy - Determination of aluminium content - Chrome azurol S photometric method

GB/T 223.17 Methods for chemical analysis of iron, steel and alloy - The diantipyryl methane photometric method for the determination of titanium content

GB/T 223.40 Iron, steel and alloy - Determination of niobium content - The sulphochlorophenol S spectrophotometric method

GB/T 223.58 Methods for chemical analysis of iron, steel and alloy - The extraction-absorption catalytic polarographic method for the determination of manganese content

GB/T 232 Metallic materials - Bend test

GB/T 247 General rule of package, mark and certification for steel plates (sheets) and strips

GB/T 709 Dimension, shape, weight and tolerances for hot-rolled steel plates and sheets

GB/T 2975 Steel and steel products - Location and preparation of test pieces for mechanical testing

GB/T 4336 Carbon and low-alloy steel - Determination of multi-element contents - Spark discharge atomic emission spectrometric method (routine method)

GB/T 8170 Rules of rounding off for numerical values & expression and judgement of limiting values

GB/T 17505 Steel and steel products - General technical delivery requirements

GB/T 20066 Steel and iron - Sampling and preparation of samples for the determination of chemical composition

GB/T 20123 Steel and iron - Determination of total carbon and sulfur content - Infrared absorption method after combustion in an induction furnace (routine method)

GB/T 20125 Low-alloy steel - Determination of multi-element contents - Inductively coupled plasma atomic emission spectrometric method

3 Designation representation method and classification

3.1 Designation representation method

The steel designation consists of three parts: a letter representing the yield strength, the minimum value of specified lower yield strength and a classification code. Among them, it adds a quality grade symbol for the classification of steel for porcelain enameling for chemical equipment, and when the quality grade symbol is omitted, it is supplied according to Grade B.

Example: Q245GTD

Q - The first letter of Chinese Pinyin of “Qu” in yield strength;

- hot rolled pickled surface.

The hot rolled pickled surface is suitable for continuously hot rolled steel plates and strips.

3.4 Surface quality grade

The surface quality grade consists of:

- normal grade surface FA;
- higher grade surface FB.

4 Ordering contents

4.1 Contracts or orders ordered in accordance with this Standard shall include the following:

- a) serial number of this Standard;
- b) product name (steel plate or steel strip);
- c) designation;
- d) delivery condition;
- e) dimension and flatness accuracy;
- f) surface condition;
- g) surface quality grade;
- h) weight;
- i) edge condition;
- j) use;
- k) special requirements.

4.2 When the surface condition is not indicated in the contract, it is delivered by hot rolled surface. When the surface condition is hot rolled pickled surface, and the contract does not indicate whether it is oiled, it is delivered after oiling. When the surface quality grade is not indicated in the contract, the surface is delivered by normal grade.

7 Test methods

7.1 The test methods for various inspection items of steel plates and strips shall comply with the provisions of Table 9.

7.2 The chemical composition test of steel is generally carried out according to GB/T 4336, GB/T 20123 or general chemical analysis method. In case of arbitration, it is carried out according to the provisions of GB/T 223.3, GB/T 223.9, GB/T 223.17, GB/T 223.40, GB/T 223.58, GB/T 223.59, GB/T 223.60, GB/T 223.61, GB/T 223.62, GB/T 223.63, GB/T 223.64, GB/T 223.67, GB/T 223.68, GB/T 223.69, GB/T 223.71, GB/T 223.72, GB/T 223.79 and GB/T 20125.

Table 9 -- Inspection item, sampling quantity, sampling method and test method

No.	Inspection item	Sampling quantity	Sampling method	Test method
1	Chemical analysis	1 (each furnace number)	GB/T 20066	See 7.2
2	Tensile test	1/batch	GB/T 2975	GB/T 228.1
3	Bending test	1/batch	GB/T 2975	GB/T 232
4	Impact test	1 set (3)/batch	GB/T 2975	GB/T 229
5	Dimension, shape	—	—	Suitable measuring tools
6	Surface quality	Piece by piece/coil by coil	—	Visual inspection

8 Inspection rules

8.1 Inspection and acceptance

Inspection and acceptance of steel plates and strips shall be carried out by the supplier's technical supervision department.

8.2 Batching rules

Steel plates and strips shall be accepted in batches. Each batch shall consist of steel plates or strips of the same designation, the same furnace number, the same delivery condition, the same thickness, the same rolling system and the same surface condition.

8.3 Sampling quantity

Sampling method and sampling quantity of each batch of steel plates and strips are shown in Table 9.

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