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Hot rolled titanium and titanium alloy seamless tubes

热轧钛及钛合金无缝管材

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Table of Contents

Foreword.....	3
1 Scope.....	4
2 Normative references.....	4
3 Terms and definitions	5
4 Technical requirements	5
5 Test method	7
6 Inspection rules.....	8
7 Marking, packaging, transportation, storage, accompanying documents.....	9
8 Content of purchase order	11
Appendix A (Informative) Recommended outer diameter series for ordering of tubes	12

Hot rolled titanium and titanium alloy seamless tubes

1 Scope

This document specifies the technical requirements, test methods, inspection rules, marking, packaging, transportation, storage, accompanying documents, purchase orders for hot-rolled titanium and titanium alloy seamless tubes.

This document is applicable to general industrial hot-rolled titanium and titanium alloy seamless tubes (hereinafter referred to as "tubes"), which are produced by the cross-rolling piercing and rolling process (hereinafter referred to as "tubes"). The other hot-rolled tubes may refer to this document.

2 Normative references

The contents of the following documents constitute the indispensable clauses of this document through normative references in the text. Among them, for dated reference documents, only the version corresponding to that date is applicable to this document; for undated reference documents, the latest version (including all amendments) is applicable to this document.

GB/T 228.1-2010 Metallic materials - Tensile testing - Part 1: Method of test at room temperature

GB/T 229 Metallic materials - Charpy pendulum impact test method

GB/T 241 Metal materials - Tube - Hydrostatic pressure test

GB/T 3620.1 Designation and composition of titanium and titanium alloys

GB/T 3620.2 Titanium and titanium alloys - permissible variations of chemical composition for wrought product analysis

GB/T 4698 (all parts) Methods for chemical analysis of titanium sponge, titanium and titanium alloys

GB/T 5193 Method of ultrasonic inspection for wrought titanium and titanium alloy products

GB/T 8180 Wrought titanium and titanium alloy products packing marking transporting and storing

YS/T 1262 Method for chemical analysis of titanium sponge, titanium and

use the R8 specimens; for tubes which have a wall thickness of not less than 8 mm, use the R7 specimens. The impact test shall comply with the provisions of GB/T 229.

5.3 The ultrasonic testing shall comply with the provisions of GB/T 5193.

5.4 The hydraulic test method shall comply with the provisions of GB/T 241.

5.5 The external dimensions shall be measured by the measuring tools of corresponding precision.

5.6 The appearance quality shall be inspected visually. If necessary, it may select a magnifying glass of not more than 5X, for the purpose of inspection. The inner surface can be inspected by an endoscope.

6 Inspection rules

6.1 Inspection and acceptance

6.1.1 The product shall be inspected by the supplier or a third party, to ensure that the quality of the product meets the requirements of this document and the purchase order.

6.1.2 The buyer may inspect the received products, in accordance with the provisions of this document. If the inspection result is not in conformity with the provisions of this document and the purchase order, it shall be submitted to the supplier in written form, which will be settled, through negotiation, between the supplier and the buyer. For objections pertaining to external dimensions or appearance quality, they shall be filed within one month from the date of receipt of the product. For objections pertaining to other aspects, it shall be filed within three months from the date of receipt of the product.

6.2 Group-batch

Products shall be submitted for acceptance in batches. Each batch shall consist of products of the same designation, melting furnace number, specification, manufacturing method, state, as well as the same heat treatment furnace batch.

6.3 Inspection items and sampling

The inspection items and sampling methods of the products shall meet the requirements of Table 4.

- a) Designation;
- b) Specification;
- c) Smelting furnace number or batch number;
- d) State;
- e) The number of this document (GB/T 39856).

7.2 Packaging, transportation, storage

The packaging, transportation, storage of the product shall comply with the relevant provisions in GB/T 8180.

7.3 Accompanying documents

Each batch of products shall be accompanied by accompanying documents, which shall include the supplier information, product information, number of this document (GB/T 39856), date of manufacture or packaging date. Meanwhile, it should also include:

- a) Product quality guarantee:
 - The main performance and technical parameters of the product;
 - Product characteristics (including the characteristics of manufacturing process and raw materials);
 - Responsibility for product quality;
 - The quality certification obtained by the product, as well as the analysis and testing results of each item, which are checked and stamped by the supplier's technical supervision department;
- b) Product certificate:
 - Inspection items and their results or inspection conclusions;
 - Batch size or batch number;
 - Inspection date;
 - The inspector's signature or seal;
- c) During product quality control, the inspection report and finished product inspection report;
- d) Instruction for use of product: correct handling, use, storage methods, etc.;

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