

Translated English of Chinese Standard: Q/BQB110-2018

www.ChineseStandard.net → Buy True-PDF → Auto-delivery.

Sales@ChineseStandard.net

BQB

ENTERPRISE STANDARD OF BAOSTEEL

Q/BQB 110-2018

Replacing Q/BQB 110-2014

Rolled square blank

轧制方坯

Issued on: January 15, 2018

Implemented on: April 10, 2018

Issued by: Baoshan Iron and Steel Co., Ltd.

Table of Contents

Foreword.....	3
1 Scope.....	5
2 Normative References	5
3 Information for ordering.....	6
4 Dimension, shape, weight and tolerance	6
5 Technical requirements	7
6 Inspection and testing.....	9
7 Packaging, marks and inspection documents.....	10

Foreword

This Standard is drafted in accordance with the requirements and format of GB/T 1.1-2009 "Directives for Standardization - Part 1: Structure and Drafting of Standards".

This Standard is drafted in accordance with the characteristics of products and techniques of this enterprise.

Please be noted that certain content in this Standard might involve patents. The issuing institution of this Standard does not undertake the responsibility of identifying these patents.

This Standard serves as a replacement of Q/BQB 110-2014. In comparison with Q/BQB 110-2014, there are several main changes as follows:

- normative references were modified to the latest version applicable; deleted the test method for chemical composition analysis;
- added the specifications of side lengths of 160mm and 215mm as well as their technical requirements; deleted the specifications of side lengths of 90mm, 134mm;
- tightened the side length tolerance of Table 1;
- modified 5.1.1 from "the designation and chemical composition of the steel (except for the welding rod and the steel for the welding wire are the finished components of the square blank, the others are all smelting components) shall meet the requirements of the corresponding Baosteel enterprise standard or other standards" TO "the designation and chemical composition of the steel (except for the welding rod and the steel for the welding wire are the finished components of the square blank, the rest are smelting components) shall comply with the corresponding Baosteel enterprise standard, GB/T 669, GB/T 1591, GB/T 3077, GB/ T 1222, GB/T 6478 or other standard regulations";
- "Except for steel for welding rods and low carbon steel square blanks, square blanks shall be inspected at low magnification. There shall be no visible bubbles, white spots, cracks, tumbling, inclusions and residual shrinkage holes on the acid immersion low-magnification test piece" was MODIFIED TO "Except for boiling steel, square blank shall be inspected at low magnification. There shall be no visible bubbles, white spots, cracks, tumbling, inclusions, residual craters, metal foreign bodies on the acid immersion low-magnification test piece"; ADDED that "the center segregation is not more than 2.5; the general spot-like segregation is not more than 2.0; the edge speckle segregation is not more than 2.0";
- added requirements for non-metallic inclusions;

Rolled square blank

1 Scope

This Standard specifies the dimension, shape, weight and tolerance, technical requirements, inspection and testing, packaging, marks and inspection documents of primarily rolled square blanks and hot rolled square blanks.

This Standard is applicable to primarily rolled square blanks and hot rolled square blanks for re-rolling or forging manufactured by Baoshan Iron and Steel Co., Ltd.

2 Normative References

The following documents are indispensable to the application of this Standard. In terms of references with a specified date, only versions with a specified date are applicable to this Standard. The latest version (including all the modifications) of references without a specified date is also applicable to this Standard.

GB/T 222-2006, *Permissible Tolerances for Chemical Composition of Steel Products*

GB/T 226-2015, *Test method for macrostructure and defect of steel by etching*

GB/T 699-2015, *Quality carbon structural steels*

GB/T 1222-2016, *Spring steels*

GB/T 1591, *High strength low alloy structural steels*

GB/T 1979-2001, *STANDARD diagrams for macrostructure and defect of structural steels*

GB/T 3077-2015, *Alloy structure steels*

GB/T 6478-2015, *Steels for cold heading and cold extruding*

GB/T 10561-2005, *Steel - Determination of Content of Nonmetallic Inclusions - Micrographic Method Using Standards Diagrams*

GB/T 20066-2006, *Steel and Iron - Sampling and Preparation of Samples for the Determination of Chemical Composition*

3 Information for ordering

The user needs to provide the following information when ordering.

- a) Reference to this enterprise;
- b) Designation;
- c) Specification;
- d) Weight;
- e) Other particular requirements.

4 Dimension, shape, weight and tolerance

4.1 Dimension and tolerance

4.1.1 The section size and tolerance of a square blank shall comply with the requirements of Table 1.

4.1.2 A square blank with a side length of less than or equal to 140mm usually has a length of 2000mm~19000mm. A square blank with a side length of more than or equal to 160mm usually has a length of 2000mm~10000mm. Square blanks can also be delivered in fixed length and multiple lengths. The length shall be within the usual length range. The tolerance is 0 ~ +70mm.

5.6.1 The end of a square blank shall not have shrinkage cavities, airbags, delamination and tail holes. The surface of a square blank shall be free from cracks, crusting, inclusions, folds, cracks and ears.

5.6.2 The maximum depth of scratches, roll marks, pits, and pitting on the surface of a square blank is: 2mm when side length $\leq$ 140mm; 3mm when side length $\geq$ 160mm. The maximum depth of the surface of a square blank that is allowed to exist is: 1mm when side length $\leq$ 140mm; 2mm when side length $\geq$ 160mm.

5.6.3 The surface defects of square blank are allowed to clear. The cleaning place shall be smooth and without corners. The cleaning depth (on the same section) must not be greater than 6% of the side length. The cleaning width shall be no less than five times the cleaning depth.

5.7 Other particular requirements

According to the requirements of the purchaser, other items can be inspected upon agreement between the supplier and the purchaser. The indicators shall be stipulated by the agreement between the supplier and the purchaser.

6 Inspection and testing

6.1 Dimension and shape check

6.1.1 Use an appropriate gauge to measure the dimension and shape of square blanks one by one.

6.1.2 Measurement of side length: use a measuring tool to measure, at a distance of not less than 150mm from the end of the square blank, along with the vertical direction of the square blank length. Take its maximum size as the side length value.

6.1.3 Measurement of length: the distance between the two end faces of a square blank measured along with the square blank side centerline shall be the actual length of the square blank.

6.2 Surface quality check

The surface quality of a square blank is checked with naked eyes.

6.3 Other inspection items

Other inspection items, sampling quantity, sampling method and test methods of a square blank shall comply with the provisions of Table 3.

6.4 Batching rules

Square blanks shall be inspected and accepted in batches. Gland steel square blanks

This is an excerpt of the PDF (Some pages are marked off intentionally)

Full-copy PDF can be purchased from 1 of 2 websites:

1. <https://www.ChineseStandard.us>

- SEARCH the standard ID, such as GB 4943.1-2022.
- Select your country (currency), for example: USA (USD); Germany (Euro).
- Full-copy of PDF (text-editable, true-PDF) can be downloaded in 9 seconds.
- Tax invoice can be downloaded in 9 seconds.
- Receiving emails in 9 seconds (with download links).

2. <https://www.ChineseStandard.net>

- SEARCH the standard ID, such as GB 4943.1-2022.
- Add to cart. Only accept USD (other currencies - <https://www.ChineseStandard.us>).
- Full-copy of PDF (text-editable, true-PDF) can be downloaded in 9 seconds.
- Receiving emails in 9 seconds (with PDFs attached, invoice and download links).

Translated by: Field Test Asia Pte. Ltd. (Incorporated & taxed in Singapore. Tax ID: 201302277C)

About Us (Goodwill, Policies, Fair Trading...): <https://www.chinesestandard.net/AboutUs.aspx>

Contact: Wayne Zheng, Sales@ChineseStandard.net

Linkin: <https://www.linkedin.com/in/waynezhengwenrui/>

----- The End -----