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ENTERPRISE STANDARD OF

BAOSHAN IRON AND STEEL CO., LTD.

Q/BQB 302-2023

Replacing Q/BQB 302-2020

Continuously Hot-Rolled Steel Sheet and Strip for Cold Forming

冷成型用热连轧钢板及钢带

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Continuously Hot-Rolled Steel Sheet and Strip for Cold Forming

1 Scope

This Document specifies the size, shape, technical requirements, inspection and testing, packaging, marking and inspection documents of continuously hot-rolled steel sheet and strip for cold forming.

This Document applies to the hot-rolled steel strip for cold forming produced by Baoshan Iron and Steel Co., Ltd., as well as the steel sheet cut horizontally and the steel strip cut longitudinally, hereinafter referred to as steel sheet and strip.

2 Normative References

The provisions in following documents become the essential provisions of this Document through reference in this Document. For the dated documents, only the versions with the dates indicated are applicable to this Document; for the undated documents, only the latest version (including all the amendments) is applicable to this Document.

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

GB/T 223 Chemical Analysis Method of Iron, Steel and Alloy (Applicable Parts)

GB/T 228.1-2021 Metallic materials - Tensile testing - Part 1: Method of test at room temperature

GB/T 232 Metallic materials – Bend test

GB/T 2975 Steel and steel products – Location and preparation of samples and 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 and expression and judgment of limiting values

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

5 Information Required for Ordering

5.1 Users need to provide the following information when ordering:

- a) This Document number;
- b) Product category;
- c) Designation, surface treatment method and surface quality level;
- d) Specifications and dimensional accuracy (thickness, width, unevenness);
- e) Edge state;
- f) Usage;
- g) Type of verification file.

5.2 Omissions in the ordering contract

5.2.1 If the surface treatment method is not specified, except for designations BRC1, BRC2 and BRC3, which are delivered by pickled surfaces, other designations are delivered by rolled surfaces.

5.2.2 For hot-rolled steel sheets and strips, if the dimensional accuracy is not specified, they will be delivered with ordinary accuracy; if the edge condition is not specified, the steel strips will be delivered in an untrimmed state, and the steel plates will be delivered in a trimmed state.

5.2.3 For hot-rolled pickled steel sheets and strips, if the dimensional accuracy is not specified, the thickness shall be delivered with higher thickness accuracy and other dimensions shall be delivered with ordinary accuracy. If the edge condition, surface quality level and whether it is oiled or not is not specified, it shall be delivered by trimmed state, higher level surface and oiled state. If the inner diameter of the steel coil is not specified, it shall be delivered with the inner diameter of the steel coil 610mm.

6 Size, Shape, Weight and Tolerance

The size, shape, weight and tolerance of steel sheet and strips shall comply with the provisions of Q/BQB 301. The tolerance of thickness shall comply with the provisions of Table 2 in Q/BQB 301. The allowable value of unevenness shall not exceed the specified minimum yield strength of 300MPa. If the customer has higher requirements for thickness accuracy, the advanced precision PT.C with a specified yield strength less than 360MPa given in Table 4 of Q/BQB 301 can be selected when ordering.

transportation, loading and unloading and storage conditions, the supplier shall ensure that the surfaces of the steel sheets and strips shall not rust within 3 months since the completion date of manufacturing. After negotiation between the supplier and the purchaser, and indicating in the contract, the hot-rolled pickled surface can also be supplied without oiling.

NOTE: For non-oiled products required by the purchaser, rust may occur; and the surface may be slightly scratched during transportation, loading, unloading, storage and use processes.

7.5 Mechanical and process properties

7.5.1 The performance guarantee period of steel sheets and strips shall comply with the provisions of the corresponding Tables 3, 4 and 5. The performance guarantee period of steel sheets and strips is calculated from the date of completion of product manufacturing.

NOTE: Due to the aging nature of steel, it is recommended that users use it as soon as possible.

7.5.2 The mechanical and process properties of steel sheets and strips during the performance guarantee period shall comply with the provisions of the corresponding Tables 3, 4 and 5. When used as raw material for cold rolling, the supplier does not need to conduct the test if the supplier can ensure that the mechanical test is qualified.

7.5.3 After the bend test, there shall be no visible cracks on the outer surface of the specimen. If the supplier can ensure that the bend test is qualified, the test may not be performed.

7.5.4 The mechanical properties of steel sheets and strips with designations of IF HR1, IF HR2 and IF HR3 are referenced in the informative Appendix A, but they are not regarded as guaranteed conditions.

8.6 Reinspection

8.6.1 If a certain test result does not meet the standard requirements, double the number of specimens will be taken from the same batch for reinspecting of the unqualified item.

8.6.2 If the reinspection results (including all indicators required for the test of the project) are qualified, the entire batch will be qualified. If even one index of the reinspection results (including all indicators required for the test of the project) fails, the reinspection shall be unqualified.

8.6.3 If the reinspection is unqualified, the individual pieces that have been tested and have unsatisfactory test results cannot be accepted, but the single pieces of the batch of materials that have not been tested can be resubmitted for testing and acceptance one by one.

9 Packaging, Marking and Inspection Documents

The packaging, marking and inspection documents of steel sheets and strips shall comply with the provisions of Q/BQB 300.

10 Numerical Rounding Rules

The numerical judgment adopts the rounding and comparison method, and the numerical rounding shall comply with the provisions of GB/T 8170.

11 Appendix

The comparison table between this Document and similar designations in relevant standards is shown in Appendix B (informative).

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