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TECHNICAL SUPPLY CONDITION OF
BAOSTEEL GROUP CORPORATION

Q/BQB 401-2014

Replacing Q/BQB 401-2009

**Dimension, shape, weight and tolerance for
cold-rolled steel plates and strips**

冷轧钢板及钢带的尺寸、外形、重量及允许偏差

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Dimension, shape, weight and tolerance for cold-rolled steel plates and strips

1 Scope

This Standard specifies the requirements for the classification and code, dimension, shape, weight and tolerance of cold-rolled steel plates and strips.

This Standard **is applicable to** the cold-rolled steel strips with the thickness of 0.17mm to 3.50mm and the width of 400mm to 1,850mm, and the steel plates cut from the above-mentioned steel strips (hereinafter referred to as “steel plates and strips”), which are produced by Baosteel Group Corporation.

2 Normative references

The following documents are essential to the application of this document. For dated references, only the editions with the dates indicated are applicable to this document. For undated references, only the latest editions (including all the amendments) are applicable to this document.

GB/T 8170-2008 *Rules of rounding off for numerical values & expression and judgement of limiting values*

3 Classification and codes

According to different product shapes, the classification and codes for the edge status and dimensional precision of steel plates and strips shall conform to the provisions of Table 1.

Table 1

Product shape	Classification and code													
	Edge status		Thickness precision			Width precision		Length precision		Flatness precision				
			Precision thickness	Precision thickness	Precision thickness	Precision width A	Precision width B	Precision length A	Precision length B	Precision flatness	Precision flatness			
			A	B	C					A	B			
Steel strip	Mill edge	EM	PT.A	PT.B	PT.C	PW.A	-	-	-	-	-			
	Cut edge	EC					PW.B	-	-	-	-			
Steel plate	Mill edge	EM									PL.A	PL.B	PF.A	PF.B
	Cut edge	EC												

Note: According to the shapes and the positions where the steel plates show up, the strain types of steel plates can be divided into the following categories:

Bow

It refers to the residual curving along various directions of the steel plate, which can be in longitudinal direction (along the rolling direction) and in transverse direction (perpendicular to the rolling direction);

Wave

The waves refer to the waves and rippling along the longitudinal direction of the steel plate;

Edge wave

The edge waves refer to the waves along the edges of the steel plate;

Center buckle, centre fullness, full centre

It refers to the waves appearing in the middle of the steel plate, which is also known as central fold.

6.3.4 For the steel plates with the minimum yield strength of less than 260MPa, during the supply in accordance with the precision flatness B, it is necessary to conduct further inspection to the edge waves in the case of arbitration. The edge waves shall conform to the following provisions:

- When the edge wave's length is not less than 200mm, for the steel plate whose nominal width is less than 1,500mm, the wave height shall be less than 1% of the edge wave's length;
- When the edge wave's length is not less than 200mm, for the steel plate whose nominal width is not less than 1,500mm, the wave height shall be less than 1.5% of the edge wave's length;
- When the edge wave's length is less than 200mm, the wave height shall not be greater than 2mm.

6.3.5 For the steel plates with the specified minimum yield strength of not less than 340MPa, the flatness shall be negotiated by the supply and requisitioning parties, and shall also be indicated in the contract.

6.3.6 If the requisitioning party makes no provisions on the flatness of steel plates, the supply party shall meet the end-use requirements of the product to the greatest extent.

Appendix A

(Normative)

Method for calculating the theoretical weight

A.1 During the calculation of the theoretical weight, USE the nominal dimensions of the steel plates in general.

A.2 When the thickness tolerances of the steel plates are symmetrical tolerances, USE nominal thicknesses during the calculation of the theoretical weight. When the thickness tolerances of the steel plates are limited negative deviations or limited positive deviations, USE the mean value OF maximum allowable thickness AND minimum allowable thickness during the calculation of the theoretical weight.

A.3 The method for calculating the theoretical weight of the steel plate shall conform to the provisions of Table A.1.

Table A.1

Calculation order	Calculation method	Digits of the result
Basic weight (kg/mm • m ²)	7.85 (the weight of the steel plate with the thickness of 1mm and the area of 1m ²)	-
Unit weight (kg/m ²)	Basic weight (kg/mm • m ²) × thickness (mm)	Rounded off to 4 significant digits
Steel plate's area (m ²)	Width (m) × length (m)	Rounded off to 4 significant digits
Weight of one piece of steel plate (kg)	Unit weight (kg/m ²) × steel plate's area (m ²)	Rounded off to 3 significant digits
Weight of one bundle of steel plates (kg)	Weight of one piece of steel plate (kg) × Number of pieces of steel plates with same specifications in one bundle	Rounded off to integer value of kg
Total weight (kg)	ADD the weights of all bundles	Integer value of kg
Note: Total weight can be calculated by multiplying the weight of one piece of steel plate (kg) by total number of pieces.		

Additional information:

This Technical Condition was drafted by reference to EN 10131:2006, JIS G3141:2011 and GMW 3224-2012.

This Technical Condition replaces Q/BQB 401-2009.

Compared with Q/BQB 401-2009, the major modifications in this Technical Condition are as follows:

- DELETE the provisions on the original slitting steel strips;
- ADD the provisions on the precision thickness C;
- ADD the provisions on using the diagonal method for measuring the out of squareness.

The Appendix A of this Technical Condition is normative appendix.

This Technical Condition was proposed by the Manufacturing Management Department of Baosteel Group Corporation.

This Technical Condition was drafted by the Manufacturing Management Department of Baosteel Group Corporation.

Drafter of this Technical Condition: Sun Zhongming.

This Technical Condition was first released in 1988. The first revision was released in 1994. The second revision was released in 1999. The third revision was released in 2003. The fourth revision was released in 2009. This is the fifth revision.

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