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Corrugated Steel Plates with Lath and Lentiform

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Corrugated Steel Plates with Lath and Lentiform

1 Subject Content and Scope of Application

This Standard specifies the external dimensions, technical requirements, inspection rules, packaging, marking and quality certificate of corrugated steel plates with lath and lentiform.

This Standard is applicable to carbon structural steel; hull structural steel; atmospheric corrosion resisting structural steel; hot-rolled diamond-shaped, lenti-shaped and round-bean-shaped corrugated steel plates.

2 References

GB 222 Method of Sampling Steel for Determination of Chemical Composition and Permissible Variations for Product Analysis

GB 247 General Rule of Package Mark and Certification for Steel Plates (sheets) and Strips

GB 700 Carbon Structural Steels

GB 709 Dimensions, Shape, Weight and Tolerances for Hot Rolled Steel Sheets and Strips

GB 712 Hull Structural Steel

GB 4171 Atmospheric Corrosion Resisting Structural Steel

3 Dimensions, Shape, Weight and Tolerances of Steel Plates

3.1 Dimensions of corrugated steel plates shall comply with the following stipulation:

Basic thickness: 2.5, 3.0, 3.5, 4.0, 4.5, 5.0, 5.5, 6.0, 7.0 and 8.0 mm.

Width: 600 ~ 1,800 mm, increased by 50 mm.

Length: 2,000 ~ 12,000 mm, increased by 100 mm.

Through the agreement between the supply-side and the demand-side, corrugated steel plates or coiled corrugated steel strips of a dimension not specified in this

theoretical weight.

3.8 Example of marking: round-bean-shaped corrugated steel plate, which is made from Q 235-A steel with the dimension: 4 x 1,000 x 4,000 mm, shall have the following marking: round-bean-shaped corrugated steel plate Q235 - A - 4 x 1,000 x 4,000 - GB/T 3277-91.

4 Technical Requirements

4.1 Nameplate and Chemical Composition

4.1.1 Steel used for corrugated steel plates shall be provided in accordance with the stipulation of steel nameplate in GB 700, GB 712 and GB 4171.

Through the agreement between the supply-side and the demand side, other nameplates may be used to manufacture corrugated steel plates.

4.1.2 The allowable deviation of chemical composition of finished steel plates shall comply with the stipulation in GB 222.

4.2 Mechanical Property

Mechanical property is not guaranteed here. When the demand side requests, the mechanical property indexes and test methods shall comply with the stipulation in relevant standards, or, be stipulated through the negotiation between both parties.

4.3 Delivery Status

Steel plates shall be delivered under hot-rolled status.

4.4 Surface Quality

4.4.1 The surface of corrugated steel plates shall not manifest any bubbles, scars, cracks, wrinkles or inclusions. The steel plates shall not be layered.

4.4.2 Surface quality may be divided into two grades:

General precision: the surface of steel plates is allowed to manifest thin oxidized iron scales, rust, rough surface caused by exfoliation of the iron scales, and other partial defects whose height or depth does not exceed the allowable deviation.

The corrugation is allowed to manifest indistinct burrs and individual traces whose height does not exceed the height of the corrugation. The maximum area of individual defect shall not exceed the square of the corrugation height.

Higher precision: the surface of steel plates is allowed to manifest thin oxidized iron scales, rust, and other partial defects whose height or depth does not exceed half of

the thickness deviation.

The corrugation shall be intact. On the corrugation, there may be slight partial burrs whose height does not exceed half of the thickness deviation.

5 Inspection Rules

5.1 The appearance and dimensions of corrugated steel plates shall be inspected one by one. Corrugated steel plates which are rolled by tandem mills may be sampled in accordance with coil.

5.2 The basic thickness and corrugation height of the steel plates shall be measured at a distance of not less than 40 mm from the edges along the width direction. Coiled corrugated steel stripes shall comply with the stipulation in GB 709.

6 Packaging, Marking and Quality Certificate

Packaging, marking and quality certificate shall comply with the stipulation in GB 247.

Additional information

This Standard was proposed by the Ministry of Metallurgical Industry of the People's Republic of China.

The responsible drafting organizations of this Standard: Ben Xi Iron Steel Company, Anshan Iron and Steel Company.

The main drafters of this Standard: Kongwei, Yue Wenguang, Dong Wenying.

Since the date of its implementation, the Standard GB/T 3277-91 shall serve as a replacement of GB 3277-82.

The level marking of this Standard: GB/T 3277-91 I.

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