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**The continuous roll-casting strips of
aluminium and aluminium alloy**

铝及铝合金铸轧带材

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The continuous roll-casting strips of aluminium and aluminium alloy

1 Scope

This Standard specifies the terms and definitions, requirements, test methods, inspection rules, marking, packing, transporting, storing, quality certificate, and order form (or contract) content of the continuous roll-casting strips of aluminium and aluminium alloy.

This Standard applies to the continuous roll-casting strips of aluminium and aluminium alloy (hereinafter referred to as the continuous roll-casting strips).

2 Normative references

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

GB/T 3190 Wrought aluminium and aluminium alloy - Chemical composition

GB/T 3199 Wrought Aluminium and Aluminium Alloy Products - Packing, Marking, Transporting and Storing

GB/T 3246.2 Inspection method for structure of wrought aluminum and aluminum alloy products - Part 2: Inspection method for macrostructure

GB/T 7999 Optical emission spectrometric analysis method of aluminum and aluminum alloys

GB/T 8170 Rules of rounding off for numerical values and expression and judgement of limiting values

GB/T 16865 Test pieces and method for tensile test for wrought aluminium and magnesium alloys products

GB/T 17432 Methods for sampling for analyzing the chemical composition of wrought aluminum and aluminum alloys

GB/T 20975 (all parts) Methods for chemical analysis of aluminium and

aluminium alloys

GB/T 26492.2 Defects of wrought aluminium and aluminium alloys ingots and products - Part 2: Defects for roll-casting strips

GB/T 32186-2015 Test methods of cleanliness of aluminium and aluminium alloy ingots

3 Terms and definitions

The terms and definitions defined in GB/T 26492.2 and the following apply to this document.

3.1 Longitudinal thickness difference

The maximum difference between the thickness of any two points at the same distance from the edge measured along the longitudinal direction of the continuous roll-casting strips.

3.2 Edge thickness

The thickness measured at 50 mm from the side edge of the continuous roll-casting strips (see H_1 , H_2 in Figure 1).

3.3 Edge thickness difference

The difference between the thickness of the two edges measured at 50 mm from both side edges (see H_1 , H_2 in Figure 1) on any cross-section of the continuous roll-casting strips.

3.4 Adjacent points thickness difference

The thickness difference between any two thickness measurement points of 100 mm apart [such as H_0 and H_{m1} (or H_{n1}), H_{m1} and H_{m2} , H_{n1} and H_{n2} in Figure 1] on any cross-section of the continuous roll-casting strips.

and “Other” columns of the corresponding designations in Table 2 and GB/T 3190. When the mass fraction of unconventional analytical elements is suspected to exceed the limit values of this Standard, producers shall analyze these elements.

5.2.3 The judgement of analytical numerical values adopts the rounding-off comparison method. The rules of rounding off for numerical values shall be in accordance with the relevant provisions of GB/T 8170. The rounding-off digit shall be consistent with the limit digit specified in Table 2 or GB/T 3190.

5.3 Dimensional deviation

5.3.1 USE a micrometer with a precision of not less than 0.01 mm (or the same-precision measuring tool), at any point of the test piece of the continuous roll-casting strips not less than 50 mm from the edge, to measure the edge thickness of the continuous roll-casting strips. According to the measurement positions shown in Figure 1, MEASURE the thickness of each point.

5.3.2 On the test piece of the continuous roll-casting strips, USE a steel plate (tape) ruler with a precision of 1 mm or a measuring tool of corresponding precision to measure the width of the continuous roll-casting strips.

5.3.3 Calculate the edge thickness difference (3.3), adjacent points thickness difference (3.4), intermediate crown (3.5), and the relative transverse thickness difference (3.7) of each test piece. Calculate the maximum difference in the measurement results of the thickness at points equidistant from the edge between the test pieces, i.e. longitudinal thickness difference (3.1). Calculate the maximum difference in the measurement results of the intermediate crown between the test pieces, i.e. intermediate crown difference (3.6).

5.3.4 The dislocation layer and tower-shape of the continuous roll-casting strips are measured using a steel plate (tape) ruler with a precision of 1 mm or a measuring tool of corresponding precision.

5.4 Tensile mechanical properties at room temperature

The room-temperature tensile test of the continuous roll-casting strips is carried out in accordance with the provisions of GB/T 16865.

5.5 Macrostructure

The microstructure test of the continuous roll-casting strips is carried out in accordance with the provisions of GB/T 3246.2.

5.6 Inspection method of appearance quality

The appearance quality is visually inspected and, if necessary, measured using a steel plate (tape) ruler with a precision of 1 mm or a measuring tool of corresponding precision.

6 Inspection rules

6.1 Inspection and acceptance

6.1.1 The continuous roll-casting strips shall be inspected by the supplier, to ensure that the quality of the strips meets the requirements of this Standard. The quality certificate shall be filled out.

6.1.2 The purchaser shall inspect the received continuous roll-casting strips in accordance with the provisions of this Standard. When the inspection result is inconsistent with the provisions of this Standard and the order form (or contract), it shall be submitted to the supplier in writing and shall be settled by negotiation between the supplier and the purchaser. Any objection to the appearance quality shall be filed within 1 month from the date of receipt of the continuous roll-casting strips. Any other objection shall be filed within 3 months from the date of receipt of the continuous roll-casting strips. If arbitration is required, the arbitration sampling shall be made at the purchaser place and jointly carried out by both the supplier and the purchaser.

6.2 Lot grouping

The continuous roll-casting strips shall, in coils, be submitted for acceptance.

6.3 Weighing

The continuous roll-casting strips shall be weighed in coils.

6.4 Inspection items

6.4.1 Each lot of continuous roll-casting strips, before leaving the factory, shall be inspected for chemical composition, edge thickness deviation, width deviation, edge thickness difference, intermediate crown, macrostructure, and appearance quality.

6.4.2 The continuous roll-casting strips shall be sampling-inspected for longitudinal thickness difference, adjacent points thickness difference, the relative transverse thickness difference, intermediate crown difference, and hydrogen content.

6.4.3 The mechanical properties and slag content are guaranteed by the supplier process. When the purchaser requires the mechanical properties and

inspection, print the following mark (or attach a label):

- a) Product name;
- b) Designation;
- c) Dimension specifications;
- d) Product lot number or coil number;
- e) Net weight;
- f) Inspection imprint of the quality inspection department of the supplier or inspection imprint of the quality inspector.

7.1.2 Packing marking

The packing marking of the continuous roll-casting strips shall comply with the provisions of GB/T 3199, or otherwise agreed between the supplier and the purchaser.

7.2 Packing, transporting, storing

The method of packing the continuous roll-casting strips shall be stated in the order form (or contract). Other packing, transporting, and storing requirements shall be in accordance with GB/T 3199.

7.3 Quality certificate

Each lot of the continuous roll-casting strips shall be accompanied by a product quality certificate indicating:

- a) Name, address, telephone number, and fax of the supplier;
- b) Product name;
- c) Designation, dimension specifications;
- d) Lot number or coil number;
- e) Net weight;
- f) This Standard number;
- g) Inspection results of various analysis items and imprint of the technical supervision department;
- h) Packing date (or exit-factory date).

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