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Steel stripes for welded steel pipe

焊接钢管用钢带

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Steel stripes for welded steel pipe

1 Subject contents and applicable scope

This Standard specifies the classification, size, shape and weight, technical requirements, test methods, inspection rules, packaging marks of steel stripes for welded steel pipe.

This Standard is applicable to steel stripes for common straight seam welded steel pipe, including hot-rolled and cold-rolled strips of which the width is less than 600 mm, hot-rolled and cold-rolled strips of which the width is less than 600 mm after it is longitudinally cut from that of which the width is greater than and equals to 600 mm.

2 Normative references

GB 222 Method of sampling steel for determination of chemical composition and permissible variations for product analysis

GB 223 Methods for chemical analysis of iron, steel and alloy

GB 228 Metallic materials - Tensile testing at ambient temperature

GB 232 Metallic Materials - Bend Test

GB 247 General provisions on acceptance, package, marks and quality certificate of steel sheets and strips

GB 699 Technical conditions of quality carbon structural steels

GB 700 Carbon structural steel

GB 708 Dimension, Shape, Weight, and Tolerance for Cold Rolled Steel Sheets and Strips

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

GB 710 Quality carbon structural hot-rolled thin steel sheets and strips

GB 711 Quality carbon structural hot-rolled thick steel sheets and wide steel strips

GB 716 Carbon structural steel cold-rolled steel strips

GB 912 Carbon structural steel and low-alloy structural steel hot-rolled, cold-rolled fine steel sheets and strips

GB 1591 Low Alloy Structural Steels

GB 2975 Steel mechanical and process performance test sampling provisions

GB 3274 Carbon structural and low alloy steel-rolled plates and strips

GB 3522 Cold-rolled quality carbon structural steel strips

GB 3524 Ordinary carbon structural steel hot-rolled strips

GB 3526 Low carbon steel cold-rolled steel strips

GB 6397 Metallic materials - Test pieces for tensile testing

GB 8749 Quality carbon structural steel hot-rolled strips

GB 11253 Cold-rolled sheets and strips of carbon structural steels

GB 13237 Cold-rolled quality carbon structural steel sheets and strips

3 Classification and code

3.1 Classified by delivery state:

Hot-rolled steel strips.....RJ

Cold-rolled steel strips.....LJ

3.2 Classified by edge state:

Trimming strips.....Q

Un-trimming strips.....BQ

3.3 Classified by manufacturing precision:

Ordinary precision.....P

Higher precision.....H

thickness, longitudinal scratches, projection of which the height is not greater than allowed positive deviation of thickness shall be allowed on steel strip surface. The depth and height (counting from the actual size) shall be calculated by single face.

5.4 Steel strips must not have any delamination. Broken edge and significant wave edge that shall affect welded pipe quality are not allowed, It may have chisel-shaped notches, cracks, burrs, imprints and other defects. Its depth or height at one side must not be greater than width tolerance.

5.5 Steel strip head and tail shall be cut neat. Strips of uncut head and tail shall be delivered agreed by both parties.

For steel strips rolled by rolling machine, unusual part must not exceed 8% of steel strip length.

6 Test methods

6.1 The sample number, sampling method and test method of each batch of steel strips shall comply with the provisions in Table 5.

Table 5

Test item	Sample number (pcs)	Sampling method	Test method
Chemical analysis (melting component)	1 (Each furnace number)	GB 222	GB 223
Stretching	1	GB 2975	GB 6397 GB 228
Cold-forming	1	GB 2975	GB 232
Surface quality	Visual inspection		

6.2 The samples for stretching and cold-forming tests shall be extracted in the middle of steel strip width, and 1 m above from outer ring of steel strip coil to end. When sample length is restricted by steel strip width, longitudinal sampling shall be conducted on the position specified in provisions mentioned above.

6.3 Steel strip thickness shall be measured at the place less than 10 mm from the edges.

6.4 When measuring camber, put the test part of steel strip on the plane. Place a 1 meter long ruler next to the concave edge of steel strip. And measure the maximum distance between the steel strip and the ruler.

7 Acceptance rules

7.1 Steel strips shall be inspected and accepted by technical supervision department of the supplier.

7.2 Steel strips shall be accepted in batch. Each batch shall be consisted of steel strips of same brand, same furnace number, same category, same size (thickness and width) and same heat treatment furnace-number (referring to after heat treatment). Carbon structural steel and low-alloy structural steel strips shall be respectively batched according to the provisions in GB 700 and GB 1591.

7.3 Re-inspection of steel strips shall be in accordance with the provisions in GB 247.

8 Package, marks and quality certificate

The package, marks and quality certificate of steel strips shall comply with the provisions in GB 247.

Additional information

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

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