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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 13297-2021

Replacing GB/T 13297-1991

**General rules of packaging, marking and quality certification for
precision alloys**

精密合金包装、标志和质量证明书的一般规定

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1 Scope

GB/T 13297-2021 is the Chinese national standard on general rules of packaging, marking and quality certification for precision alloys, in the field of metallurgy. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 30 April 2021 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 November 2021. Classification: ICS 77.140.99, CCS H58. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This Standard specifies the general requirements for the packaging, marking, storage and quality certification for precision alloys. This Standard is applicable to the packaging, marking, storage and quality certification of finished products of precision alloy hot-forged (rolled) bars and flat bars, hot-rolled wire rods and strips, cold (warm) rolled strips, cold-rolled plates, cold-drawn wires and (polished) bars, and cold-rolled (drawn) pipes.

2 Normative References

This Standard does not have normative references.

3 Terms and Definitions

The following terms and definitions are applicable to this document.

3.1 Package Package refers to the operation activity of applying certain technical methods in the process of using materials and auxiliary materials to protect products, facilitate storage and transportation, and promote sales during the circulation process. [Source: GB/T 2101-2017, 3.1]

3.2 Label Label refers to an article made of paper or other materials that is fixed on the package or product to indicate product name, alloy designation, furnace (batch) number, specifications and supply-side's name (trademark). [Source: GB/T 2101-2017, 3.2, modified]

3.3 Tap Tap refers to a movable label that is fixed on the package or product with iron wire, U- shaped nail, flat-head nail and nylon cable ties, etc. equidistance with galvanized iron wires, or stainless steel wires, or straps with a diameter not less than 4 mm. The wire rods packed in bundles shall be radially re- bundled for no less than 2 passes.

4.3.1 Hot-rolled strips

4.3.1.1 Hot-rolled strips shall be packed in coils or in straight strips in bundles. The coil weight of the strips shall be not greater than 600 kg. The bundle weight of the strips packed in bundles shall be not greater than 80 kg for manual loading and unloading, and not greater than 1,000 kg for mechanical loading and unloading.

4.3.1.2 Each coil (bundle) of strips shall be bundled up for at least 3 passes in radial equidistance with galvanized iron wires, or stainless steel wires, or straps with a diameter not less than 4 mm.

4.3.2 Cold (warm) rolled strips

4.3.2.1 Cold-rolled strips shall be packed in coils; cold (warm) rolled straight strips shall be packed in bundles.

4.3.2.2 The weight of each coil (bundle) of strips shall be not greater than 80 kg for manual loading and unloading, and not greater than 5,000 kg for mechanical loading and unloading.

4.3.2.3 Before packaging, the strips shall receive anti-corrosion or oiling treatment (except for vacuum packaging). The layers of soft and deep-drawn strips shall be lined with volatile rust preventive paper or other neutral anticorrosive papers: for soft and deep-drawn strips delivered in coils, if the coils are tightly wound and there is no sliding between the layers, then, the anticorrosive paper is not required.

4.3.2.4 Straight strips shall carry out the form of bundled package for encasement. The

layers of the strips shall be lined with volatile rust preventive paper or other neutral anticorrosive papers. After each bundle is packed with volatile rust preventive paper or other moisture-proof papers and packing sheet, and before being encased, it shall be bundled up for at least 2 passes in equidistance with galvanized iron wires or straps.

4.3.2.5 The packaging and bundling methods of cold-rolled strips in coils shall comply with the stipulations of Table 2. The packaging of strips in wooden boxes is shown in Figure 1, Figure 2, Figure 3, or Figure 4 and Figure 5.

4.3.3.1 Plates shall be encased in the form of bundles. The weight of each box shall be not greater than 1,000 kg.

4.3.3.2 Before packaging, the plates shall receive anti-corrosion and oiling treatment. If there are special requirements, they shall be indicated in the contract.

4.3.3.3 The layers of the plates shall be lined with volatile rust preventive paper or other neutral anticorrosive papers. After each bundle is packed with volatile rust preventive paper or other moisture-proof papers and packing sheet, and before being encased, it shall be bundled up for at least 2 passes in equidistance with galvanized iron wires or straps.

4.3.3.4 The packaging of plates in wooden boxes is shown in Figure 1.

4.4.1 Cold-drawn wires

4.4.1.1 Cold-drawn wires shall receive anti-corrosion treatment, then, be packed in reels (or bundles). The weight of each reel (or bundle) of wires shall be specified by the supply-side in accordance with the product standard. If it is not specified in the product standard, the weight of each reel (or bundle) of wires shall be not greater than 150 kg.

4.4.1.2 Each reel of cold-drawn wire shall be composed of one wire. The shaft-winding wire shall be neatly arranged and the winding shall be tight. For cold-drawn wires with a nominal diameter not greater than 4 mm, the ends shall be bent into the reel or be marked. For cold-drawn wires with a nominal diameter greater than 4 mm, the ends shall be clearly marked. One or several reels of wires can be packed as a bundle.

4.4.1.3 Cold-drawn straight wires shall be firmly bundled with galvanized steel wires. Each bundle shall be bundled up for at least 3 passes in equidistance.

4.4.1.4 The packaging form, packaging and bundling methods, and wooden box packaging method of the wires shall comply with the stipulations of Table 3.

4.4.2 Cold-drawn (polished) bars

4.4.2.1 Cold-drawn and cold-drawn polished bars shall receive anti-corrosion treatment, then, be packed in bundles.

4.4.2.2 The packaging form, packaging and bundling methods, and wooden box packaging

method of the cold-drawn and cold-drawn polished bars shall comply with the stipulations of Table 3.

4.6 Special Requirements In accordance with the demand-side's requirements, through the negotiation between the demand-side and the supply-side, and statement in the contract, other packaging forms or packaging materials may be used.

5 Marking

5.1 The marking shall adopt the modes of stamping, jet printing, tag-hanging and label-pasting, etc. The marking shall be clear and firm; all externally hanged and pasted tags (labels) shall be prevented from being contaminated and falling off during transportation and handling.

5.2 Coiled strips shall be marked coil by coil with alloy designation, furnace number, specifications, weight and state on the end of the coil outer ring. On the outer packaging of each coil, at least one label shall be attached and marked with: supply-side's name (trademark), alloy designation, furnace number, specifications, state, net weight and production date, etc.

5.3 Bars with a nominal diameter not less than 50 mm shall be marked bar by bar with alloy designation, furnace number and specifications at the end or on the surface.

5.4 For products delivered in reels (bundles), at least 2 tags shall be hanged or at least 1 label shall be pasted on each reel (bundle), indicating supply-side's name (trademark), alloy designation, furnace (batch) number, specifications, weight and delivery state, etc. The tag (label) shall be firmly tied up or pasted on the reel (bundle) on the side that is convenient for inspection.

5.5 For precision alloy products packed and delivered in wooden (iron) boxes, the outer surface of the box shall be printed or pasted with a label, indicating supply-side's name (trademark), alloy designation, furnace (batch) number, specifications, gross weight, net weight, number of pieces and production date, etc.

6 Storage

6.1 Precision alloy products shall be stored in a clean, dry, rain-proof and moisture-proof place. If necessary, the bottom layer may use dry timber to prevent moisture.

6.2 After the package is opened, moisture-proof protection shall be implemented in time.