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

GB/T 15547-2025

Replacing GB/T 15547-2012

Blanks of forged steel rolls for cold rolling mill

锻钢冷轧辊辊坯

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part

1. Structure and Drafting Rules of Standardization Documents". Drafting. This document replaces GB/T 15547-2012 "Forged Steel Cold Roll Blanks". Compared with GB/T 15547-2012, except for structural adjustments and rewriting... Aside from the logical changes, the main technical changes are as follows:

---The straightening roll blank included in the scope has been removed and incorporated into other roll blanks (see Chapter 1 of the.2012 edition);

---A new chapter on "Terms and Definitions" has been added (see Chapter 3);

---The category of straightening roll blanks included in the application classification has been removed (see Chapter 3 of the.2012 edition);

---The method of representing metallurgical quality classification has been changed (see 4.2,

4.1 in the.2012 edition, and Table 1);

---9SiCr has been removed (see Table 1 in the.2012 edition);

---The chemical composition of 8Cr5MoV has been changed (see Table 1,.2012 edition of Table 1);

---Added 8Cr5Mo1V, 9Cr3NiMoV, 9Cr5Mo, 9Cr5NiMoV, and 9Cr6MoV (see Table 1);

---Increased permissible deviations for Cr and Nb chemical composition, as well as unspecified deviations for roller diameters above 1150 mm (see Table 2);

---The recommended material for roll blanks has been changed, and the application of steel grades has been adjusted to be informative in the appendix (see 5.11,

4.2 of the.2012 edition);

---The inclusion rating requirements have been changed (see 5.6.1,

1 Scope

GB/T 15547-2025 is the Chinese national standard on blanks of forged steel rolls for cold rolling mill, 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 31 October 2025 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 May 2026. Classification: ICS 77.180, CCS H94. 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.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included. For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies. This document. GB/T 145 Center Hole

GB/T 221 Method for designating steel product grades

GB/T 223 (all parts) Chemical Analysis Methods for Iron and Steel and Alloys

GB/T 226 Steel - Low-magnification microstructure and defect testing method using acid etching

GB/T 231.1 Metallic materials - Brinell hardness test - Part

GB/T 1299-2025 Tool and Die Steel

GB/T 1979-2025 Evaluation of Low-Magnification Microstructural Defects in Structural Steel - Acid Immersion Method and Ultrasonic Testing Method

GB/T 6402 Ultrasonic Testing Methods for Steel Forgings

GB/T 4336 Determination of Multi-Element Content in Carbon Steel and Medium-Low Alloy Steels by Spark Discharge Atomic Emission Spectrometry (Conventional Method)

GB/T 10561-2023 Standard rating chart microscopic examination method for the determination of non-metallic inclusion content in steel

GB/T 11261 Determination of Oxygen Content in Iron and Steel - Pulse Heating Inert Gas Melting-Infrared Absorption Method

GB/T 13314-2025 General Technical Requirements for Forged Steel Cold Rolling Work Rolls

GB/T 15546 Metallurgical Roll Terminology

GB/T 18254-2016 High Carbon Chromium Bearing Steel

GB/T 20066 Sampling and Sample Preparation Methods for the Determination of Chemical Composition of Steel and Iron

GB/T 20125 Inductively Coupled Plasma Atomic Emission Spectrometry for Multi-Element Measurement of Low Alloy Steel

GB/T 46218 Support Rollers YB/T 6240-2024 Evaluation Standard Rating Chart Method for Carbides in Hypereutectoid Steel

3 Terms and Definitions

The terms and definitions defined in GB/T 15546 apply to this document.

4 Classification and Codes

4.1 Roll blanks are classified into the following three categories according to their uses.