

ICS 77.140.60

CCS H 54



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

GB/T 24595-2025

Replacing GB/T 24595-2020

Hot-rolled steel bars for quenched and tempered crankshafts

调质曲轴用热轧钢棒

Issued on: October 31, 2025

Implemented on: May 1, 2026

**Issued by: State Administration for Market Regulation;
Standardization Administration of the PRC**

Table of Contents

Foreword	3
1 Scope	5
2 Normative references	5
3 Order content	7
4 Size, shape, weight	7
5 Technical requirements	8
6 Test method	11
7 Inspection rules	12
8 Packaging, marking and quality certificate	13

1 Scope

This Standard specifies the order content, size, shape, weight, technical requirements, test methods, inspection rules, packaging, marking and quality certificates of hot-rolled steel bars for quenched and tempered automobile crankshafts.

This Standard applies to hot-rolled steel bars whose nominal diameter is not greater than 200 mm (hereinafter referred to as steel bars).

2 Normative references

GB/T 222
 GB/T 223.3
 GB/T 223.11
 GB/T 223.19
 GB/T 223.23
 GB/T 223.26
 GB/T 223.60
 GB/T 11261
 GB/T 17505
 GB/T 20066
 GB/T 20123

GB/T 34474.1-2017

3 Order content

Contracts or orders which are ordered under this Standard shall include the following contents:

- a) number of this Standard;
- b) product name;
- c) designation;
- d) specifications;
- e) weight (quantity);
- f) delivery status;
- g) other special requirements;

4.1 Size and allowable deviation

4.1.1 The diameter of the steel bar and its allowable deviation shall meet the requirements of Group 2 in Table 1 of GB/T 702-2017.

4.1.2 Steel bars are delivered at a fixed length; the fixed length or multiple length is specified in the contract; the allowable deviation of the length is $+50 \text{ } 0 \text{ mm}$. The existence of short length is allowed; the length of the short length shall not be less than 2 000 mm; the delivery volume of the short length cannot exceed 10% of the total weight of the batch.

8 Non-metallic inclusions 2 pcs/ batch Different steel bars

GB/T 10561- 2005

7.1.1 The delivery inspection and acceptance of steel bars shall be carried out

by the supplier's quality and technical supervision department.

7.1.2 The supplier shall ensure that the delivered steel bars meet the

requirements of this Standard or the contract. If necessary, the buyer has the right to inspect and accept according to any inspection item that is specified in this Standard or the contract.

7.2 Batch rules

Steel bars shall be inspected and accepted in batches; each batch consists of steel bars of the same designation, the same furnace number, the same size and the same delivery

status.

7.3 Sampling quantity and sampling position

The sampling quantity and sampling position of the steel bars shall comply with the requirements of Table 7.

7.4 Re-inspection and determination rules

The re-inspection and determination rules of the steel bars are performed according to the provisions of GB/T 17505.

About this edition

GB/T 24595-2025 is the current edition. It was issued on 31 October 2025 and has been in force since 1 May 2026, replacing GB/T 24595-2020.

GB/T 24595-2020 has been superseded: a specification that still cites it is citing a withdrawn edition.

The interval between issue and effect is the transition period. It exists so that producers, laboratories and buyers can requalify products, revise procedures and use up documentation before the new text becomes the one that applies. The date on this page is the official one from the record of the Standardization Administration.

Classification and status

GB/T 24595-2025 is classified under ICS 77.140.60. ICS is the International Classification for Standards, the same scheme used by ISO and by the national bodies of most countries, which is what allows a Chinese standard to be placed beside its foreign counterparts on subject rather than on number.

Its Chinese Standard Classification code is CCS H 54. CCS is the domestic scheme, a letter for the sector and two digits for the subject within it, and it is the code by which the standard is filed and searched in China.

The GB/T prefix marks a recommended national standard. It is not, in itself, law: it becomes binding when a contract names it, when a regulation or a mandatory standard refers to it, or when a producer declares conformity with it. In practice that covers most of the cases in which it will be read - a purchase specification, an inspection agreement or a certification scheme.

How a Chinese national standard is set out

Chinese national standards are drafted to the rules of GB/T 1.1, which fixes the order in which a standard is set out. The document opens with a foreword recording the issuing

bodies, the relationship to any previous edition and the technical committee responsible for it. Clause 1 is the scope. Clause 2 lists the normative references - the other standards that have to be applied together with this one, and without which its requirements cannot be met. Clause 3 gives the terms and definitions. The technical clauses follow: the requirements themselves, the test or measurement methods by which conformity is established, the inspection rules that say how a lot is sampled and judged, and, for a product standard, the provisions on marking, packaging, transport and storage. Annexes, normative or informative, come last.

GB/T 24595-2025 runs to 15 pages in the English translation. What is delivered is the complete document in that order: every clause, every table, every figure and every annex of the Chinese original, with the same numbering, so that a reference to a clause number in a contract or a test report points to the same place in both languages.

About this English translation

The English edition of GB/T 24595-2025 is a full translation of the official Chinese text, not a summary, an abstract or a machine rendering left unchecked. Clause and subclause numbers, table and figure numbers and annex letters are those of the original, because they are what a specification, a purchase order or a test report cites.

Technical terms are translated against the vocabulary standards of the same field, so that a term used in GB/T 24595-2025 reads the same way as in the other Chinese standards it is used beside. Where a term has an established English form in an ISO or IEC document on the same subject, that form is used; where China's term has no foreign counterpart, it is translated literally and the Chinese is kept alongside it rather than replaced by an approximation.

Quantities, units and symbols are carried over unchanged. Chinese standards use SI, so a value in the translation is the value in the original document, not a conversion, and a limit read from the English text is the limit that will be applied by a Chinese inspection body reading the Chinese one.

This page is compiled from the official publication record: the standard number and both titles, the issuing bodies, the dates of issue and effect, the edition it replaces, the ICS and CCS classification. The requirements, limits, tables and test conditions are in the document itself.