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

GB/T 25052-2024

Replacing GB/T 25052-2010

**Dimensions, shape, weight and tolerances for continuously
hot-dip coated steel sheet and strip**

连续热浸镀层钢板和钢带尺寸、外形、重量及允许偏差

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1 Scope

China's national standard for the dimensions, shape, weight and permissible deviations of continuously hot-dip coated steel sheet and strip. It specifies the thickness, width and length tolerances, the shape tolerances, the weight and the deviations for galvanized, galvanized, aluminium-zinc and similar hot-dip coated products. Every coated steel

product standard specifies the coating, the substrate grade and the mechanical properties, and refers the dimensions to this document rather than restating them - which is why a short standard of tables is cited by all of them. The tolerances are not simply those of uncoated strip with an allowance added, and that is the reason it exists separately. A hot-dip line passes the strip through molten metal and wipes the coating to thickness with air knives, so the coated thickness is the substrate thickness plus a coating whose weight is itself specified separately and varies across the width; the thickness tolerance therefore has to state whether it applies to the coated or the uncoated product, and the standard fixes that. The line also anneals the strip continuously before coating and cools it afterwards, which affects the flatness: coated strip is more prone to edge wave and centre buckle than cold-rolled strip, and the shape tolerances reflect what a hot-dip line can actually hold. And the width tolerance has to accommodate the trimmed and untrimmed conditions, since much coated strip is sold mill edge. The weight tolerance matters commercially because coated strip is sold by weight and the coating is part of that weight - a difference in coating mass within specification is a difference in the steel delivered for the same money. Issued on 23 August 2024 and in force since 1 March 2025, it replaces GB/T 25052-2010.

This document specifies the classification and designation, dimensions, dimensional tolerances, shapes, measurement of dimensions and shapes, weights and numerical rounding of continuously hot-dip coated steel sheets and strips. This document is applicable to continuous hot-dip coated wide strips and their sheared steel plates (hereinafter referred to as steel plates) and slit wide strips with a nominal thickness not exceeding

2 Normative references

The provisions of the following documents constitute the essential clauses of this document through normative references in this text. Among them, for referenced documents with dates, only the versions corresponding to the dates are applicable to this document; for referenced documents without dates, the latest versions (including all amendments) are applicable to this document.

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

3 Terms and definitions

The following terms and definitions apply to this document.

- 3.1 wide strip Steel strip with a rolling width of not less than 600 mm and delivered in coils.
- 3.2 slit wide strip Steel strip cut longitudinally from a wide strip (3.1) and delivered in coils.
- 3.3 nominal(specified) thickness Ordering thickness of coated products.

4 Classification and codes

- 4.1 The classification and codes according to edge state are as follows:
- 4.2 The classification and codes according to dimensional precision are as follows:
- 4.3 The classification and codes according to flatness precision are as follows:
- 4.4 The classification of dimensional precision and flatness precision corresponding to product forms is shown in Table 1.

5.1 Dimension range

- 5.1.1 The nominal thickness of wide strips, steel sheets and slit wide strips shall not exceed

5.2 Recommended nominal dimensions

- 5.2.1 The nominal thickness of wide strips, steel sheets and slit wide strips is within the range specified in 5.1.
- 5.2.2 The nominal width of wide strips, steel sheets and slit wide strips shall be any dimension in multiples of 10 mm.

6.1 Tolerance on thickness

- 6.1.1 The tolerances on thicknesses of wide strips, steel sheets and slit wide strips with the specified minimum yield strength of less than 260 MPa shall comply with the provisions of Table 2.
- 6.1.2 The tolerances on thickness of wide strips, steel sheets and slit wide strips with the specified minimum yield strength not less than 260 MPa and less than 360 MPa shall comply with the provisions of Table 3.
- 6.1.3 The tolerances on thickness of wide strips, steel sheets and slit wide strips with the specified minimum yield strength of not less than 360 MPa and less than or equal to 420 MPa shall comply with the provisions of Table 4.
- 6.1.5 When the yield strength and tolerance on thickness are not specified in the document specifying the product requirements, the tolerances on thickness of wide strips, steel sheets and slit wide strips shall be negotiated by the supplier and the buyer and shall be indicated in the contract.

6.2 Tolerance on width

- 6.2.1 The tolerances on widths of wide strips and steel sheets with cut edges shall comply with the provisions of Table
- 6. The tolerances on widths of steel sheets and wide strips with mill edges shall be

determined by negotiation between the supplier and the buyer.

6.2.3 If the buyer requires delivery with a high precision width (PW.B), this shall be specified in the contract. If not specified, delivery will be based on the common precision width (PW.A).

6.3 Tolerance on length The tolerances on lengths of steel sheets shall comply with the provisions of Table 8.

7.1 Flatness tolerance

7.1.1 The flatness tolerances of steel sheets shall comply with the provisions of Table

9. If the buyer requires the supply of high precision flatness (PF.B), it shall be indicated in the contract. If not indicated, the supply shall be based on the common precision flatness (PF.A).

7.1.2 When the yield strength and the flatness tolerance are not specified in the document specifying the product requirements, the flatness tolerance of the steel sheet shall be determined by negotiation between the supplier and the buyer and shall be stated in the contract.

7.2 Camber The camber of wide strips and steel sheets shall not exceed 5 mm over any 2,000 mm length; when the length of a steel sheet is less than 2,000 mm, its camber shall not exceed 0.25% of the actual length of the steel sheet. The camber of slit wide strips shall not exceed 2 mm over any 2,000 mm length.

7.3 Out-of-squareness The steel sheet shall be cut into right angles, and the out-of-squareness shall not exceed 1% of the actual width of the steel sheet when measured by the projection method;

7.4 Telescoping Wide strips and slit wide strips shall be firmly rolled, and the telescoping height on one side of the wide strip and slit wide strip rolls shall comply with the requirements of Table 10.

8 Measurement of dimensions and shapes

8.1 Thickness The wide strips and steel sheets with mill edges shall be measured at a distance of not less than 40 mm from the rolled edge; wide strips and steel sheets with cut edges shall be measured at a distance of not less than 25 mm from the sheared edge.

8.2 Width It shall be measured in a direction perpendicular to the center line of the steel sheet, wide strip or slit wide strip.

8.4 Flatness tolerance

8.5 Camber The camber of wide strip, steel sheet and slit wide strip refers to the maximum