



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

GB/T 8164-1993

**Steel strips for welded steel pipe
(English Translation)**

Issued on: February 17, 1993

Implemented on: October 1, 1993

Issued by: State Technical Supervision Bureau

Table of Contents

1 Subject contents and applicable scope	3
2 Normative references	3
3 Classification and code	4
4 Size, shape and weight	5
5 Technical requirements	7
6 Test methods	8
7 Acceptance rules	9
8 Package, marks and quality certificate	9
Additional information	9

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

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

4.1.2.1 Thickness tolerance of steel strips of which the width is less than 600

mm shall comply with the provisions in Table 3.

4.1.3 For steel strips of which the length is not less than 50 m, the allowed delivery length shall be 30~50 m short foot; however, its amount shall not exceed 5% of the total weight of a batch delivery.

4.2 Strip camber

Hot-rolled steel strip is not greater than 3 mm per meter.

4.3 Steel strips shall be delivered according to actual weight. The weight of each roll shall not be greater than 2 t; it may be greater than 2 t, after agreed by both parties.

5.1 Brands and chemical composition of steel strips for welded steel pipe shall

comply with the provisions on Steel No. 08, 10, 15, 20 in GB 699; Q195, Q215, Q235 in GB 700; and GB 1591.

5.2 Mechanical performance of steel strips shall comply with the provisions in Table 4.

5.3 Cracks, scarring, bubbles, inclusions, transverse scratches and other

defects on steel strip surface shall be cleared.

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.

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.

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.

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).

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.