

ICS 77.140.45

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

中华人民共和国国家标准

GB/T 709-2006

Replace GB/T 709-1998

**Dimension, Shape, Weight and Tolerances
for Hot Rolled Plates and Strips**

热轧钢板和钢带的尺寸、外形、重量及允许偏差

(ISO 7452:2002(E), Hot-rolled Structural Steel Plates-Tolerance on Dimensions and Shape, ISO 16160:2000(E), Continuously Hot-rolled Steel Products-Dimensional and Shape Tolerances, NEQ)

Issued on Nov 01, 2006

Implemented on Feb 01, 2007

Issued by General Administration of Quality Supervision, Inspection and Quarantine
of the People's Republic of China
Standardization Administration of the People's Republic of China (SAC)

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Foreword

This national standard is not equivalent to ISO 7452:2002 (E), Hot-rolled Structural Steel Plates -Tolerance on Dimensions and Shape; ISO 16160:2000 (E) Continuously Hot-rolled Steel Products -Dimensional and Shape Tolerances.

This national standard replaces of GB/T 709-1988 Dimension, Shape, Weight and Tolerances for Hot Rolled Sheets and Plates.

Compared with the primary standard, this national standard is mainly revised in the following parts:

- Cancel the nominal dimension table of steel plates and strips but specify the dimension range and recommended nominal dimension;
- The steel plate thickness increases to 400mm, and the width increases to 5000mm; The steel strip width increases to 2,200mm;
- Tighten the thickness tolerance for the thicker and wider steel plates as well as the width tolerance of steel strips;
- The plus and minus tolerances of the longitudinal-cutting steel strip is replaced with plus tolerance;
- Adjust the length tolerance;
- The unevenness of the single rolled steel plate, the measured length shall be 1 m or 2m;
- The unevenness of the continuously rolled steel plate shall be stipulated singly and the measured length shall be physical length;
- The measured length of the sickle curvature is changed into any 5,000mm or physical length; specify the sickle curvature of the longitudinal-cutting steel strip;
- Tighten the height of the coiling steel strip tower;
- Specify all kinds of dimensional metrologies and attach measurement graphic illustrations;
- Specify the thickness for weighing the limited tolerance or plus-tolerance steel plate theory.

This national standard is proposed by China Iron & Steel Association.

This national standard is under jurisdiction of China Steel Standardization Technical Committee.

This national standard is drafted by China Metallurgical Information Standardization Research Institute, Angang New Steel Rolling Co., Ltd., Jinan Steel & Iron Co., Ltd., Shougang Corporation, Hunan Hualing Xiangtan Steel & Iron Co., Ltd. Chief drafting staffs: Tang Yifan, Wang Xiaokang, Piao Zhimin, Gao Ling, Wang Liping, Li Xiaoli.

This national standard replaces all the previous versions such as GB 709-1965 and GB 709-1988.

Dimension, Shape, Weight and Tolerances for Hot Rolled Sheets and Plates

1. Scope

This national standard specifies the dimension, shape, weight and tolerances for hot-rolled sheets and plates. This national standard is applicable to the single-sheet rolled steel plate (hereinafter referred to as "single rolled steel plate"), steel strip and its shear steel plates (hereinafter referred to as "continuously rolled steel plate") and longitudinal-cutting steel strip, whose rolling width is not less than 600mm.

2. Normative References

The articles contained in the following documents have become this standard when they are quoted herein. For the dated documents so quoted, all the modifications (excluding corrections) or revisions made thereafter shall not be applicable to this Standard. For the undated documents so quoted, the latest editions shall be applicable to this Standard.

GB/T 8170 Rules for Rounding-off of Numerical Values

3. Terms and Definitions

For the purposes of this national standard, the following terms and definitions are applied.

3.1 Steel plate or sheet

The steel plate or sheet is referred to the hot-rolled flat steel products with instable edges, including directly-rolled single rolled steel plate and the continuously rolled steel plate cutting from the wide steel strip.

3.2 Steel strip

The steel strip is referred to as the wide steel strip whose rolling width is not less than 600mm and that is delivered in coils.

4. Classification and Code Name

4.1 Classification according to the edge conditions

Cut edge EC;

Mill edge EM.

4.2 Classified according to the thickness tolerance

N-type tolerance: the plus tolerance is equal to the minus tolerance;

A-type tolerance: the minus tolerance specified according to the normal thickness;

B-type tolerance: the fixed minus tolerance is 0.3 mm;

C-type tolerance: the fixed minus tolerance is zero, the plus tolerance specified according to the normal thickness.

4.3 Classified according to the thickness precision

Common thickness precision: PT.A;

Higher thickness precision: PT.B.

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