

# Hot-rolled Steel for Fine Blanking and Precision Tools

热轧精冲及精密工具用钢

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# Preface

## 前言

宝钢股份四个基地，上海宝山基地(总部)、武汉青山基地、南京梅山基地、湛江东山基地，拥有十条先进的热连轧产线。宝钢热轧精冲及精密工具用钢主要集中在宝山基地(2050产线)、梅山基地(1780产线)和青山基地(2250产线)三个基地生产。

宝钢热轧精冲及精密工具用钢团队秉承“积极进口替代，为用户创造价值”的理念，通过近二十年的耕耘，从最初的低碳钢逐步向高碳钢发展，合金含量也逐步提高，现在产品最高碳含量已达1.20%，合金含量高达8%，形成了可涵盖美标、欧标、日标、国标的近百个牌号，品种丰富、种类齐全，极大满足了用户的需求。产品广泛用于汽车零部件、锯片基体制造、园林工具、五金机械、农机等领域。

Baoshan Iron & Steel Co., Ltd. (Baosteel Co., Ltd.) has four production bases, namely the Shanghai Baoshan Base (core), Wuhan Qingshan Base, Nanjing Meishan Base, and Zhanjiang Dongshan Base, which together house ten advanced continuous hot rolling production lines. At present, Baosteel's hot-rolled steel for fine blanking and precision tools is mainly produced in three bases: Baoshan (2050 production line), Meishan (1780 production line), and Qingshan (2250 production line).

The team responsible for Baosteel's hot-rolled steel for fine blanking and precision tools adheres to the concept of "proactively replacing imports and creating value for customers". After nearly 20 years of dedicated efforts, the team has expanded its product range from low-carbon steel to high-carbon steel, with a gradual increase in alloy content. Currently, the maximum carbon content of its products reaches 1.20%, and the alloy content is as high as 8%. The company has developed nearly 100 grades of products that cover American standards, European standards, Japanese standards, and Chinese standards, featuring a rich variety and complete product range, which greatly meets customer needs. These products are widely used in fields such as auto parts manufacturing, saw blade substrate production, garden tools, hardware machinery, and agricultural machinery.

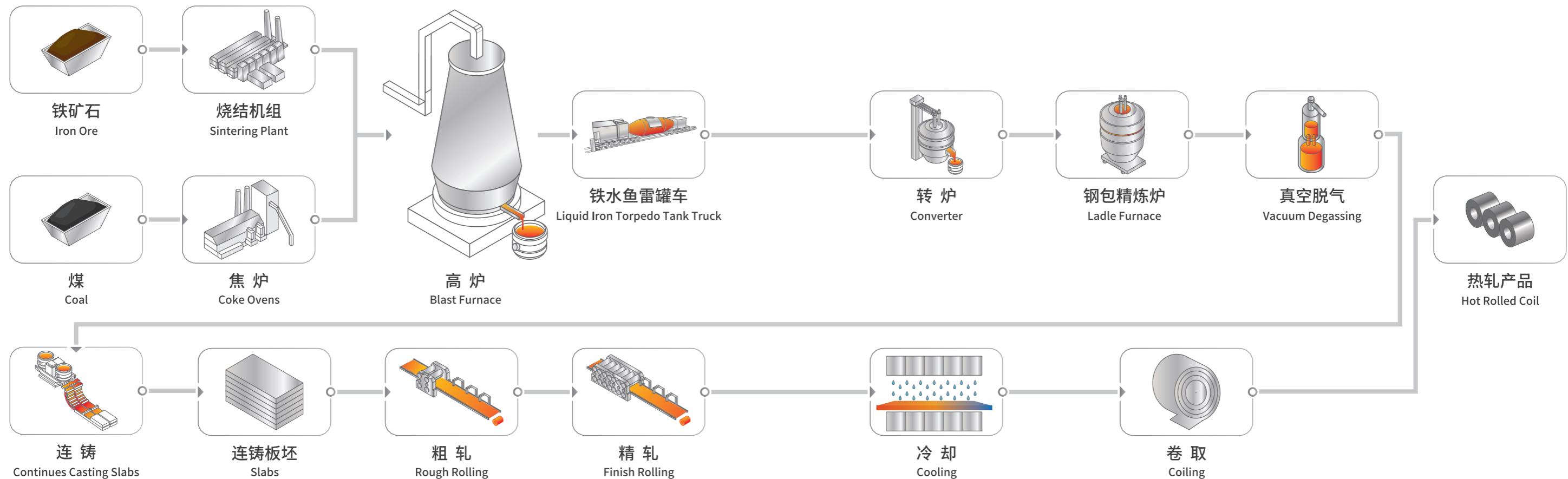
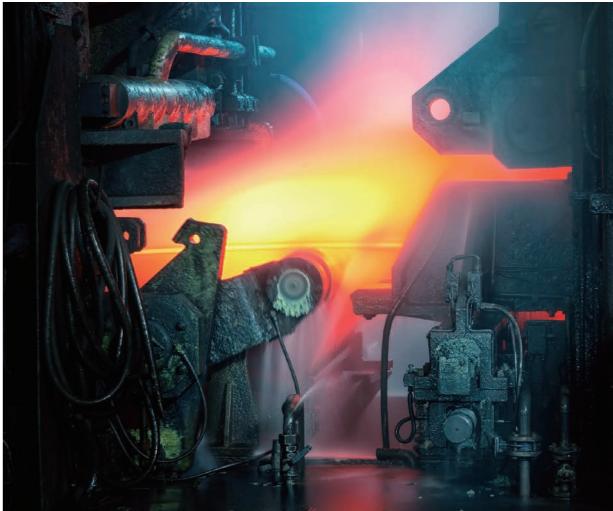
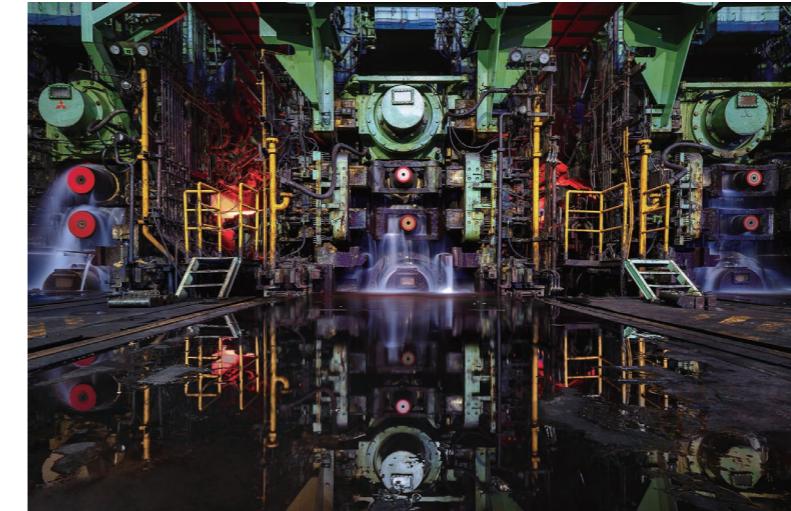


# Manufacturing Process and Delivery Condition

## 制造工艺及交货状态

热轧精冲及精密工具用钢采用氧气转炉冶炼镇静钢，经过精炼后进行连续铸造，连铸板坯送热轧厂再加热并采用控轧控冷工艺轧制成卷，性能质量检测合格后准发交货。部分产品也可根据用户的需求，进行热处理状态交货。供货形式包括直发卷、精整卷，部分材料也可切板交货。

The hot-rolled steel for fine blanking and precision tools is produced by smelting killed steel in an oxygen converter. After refining, continuous casting is carried out. The continuous casting slabs are sent to the hot rolling plant for reheating, and then rolled into coils using the controlled rolling and controlled cooling process. The products are approved for delivery only after passing the performance and quality inspection. Some products can also be delivered in a heat-treated state according to customer requirements. The supply forms include direct-rolled coils and finished coils, and some materials can also be delivered in the form of cut plates.



## Product Advantages

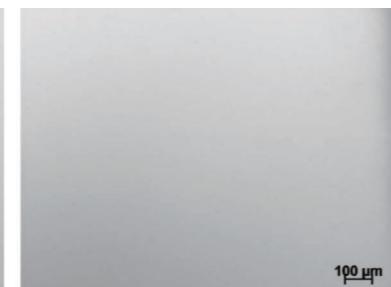
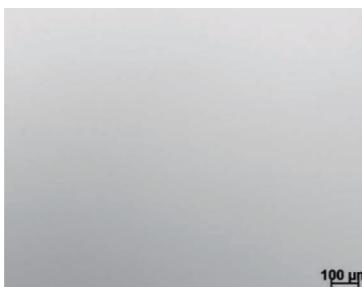
### 产品优势

#### 钢质纯净

Pure Steel Quality

采用严格控制的炉外精炼,去除多余的有害元素和夹杂物,使钢水更纯净,产品的使用寿命大幅提升。

Strictly controlled secondary refining outside the furnace is adopted to remove excess harmful elements and inclusions, making the molten steel purer and significantly extending the service life of the product.

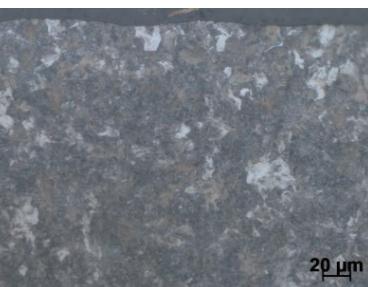


#### 组织均匀

Uniform Structure

产品具备了更加均匀的组织状态,产品易球化,可以从容面对用户各种复杂的成型及热处理工艺。

The product features a more uniform structural state, enabling easy spheroidization and allowing it to cope with various complex forming and heat treatment processes of users with ease.



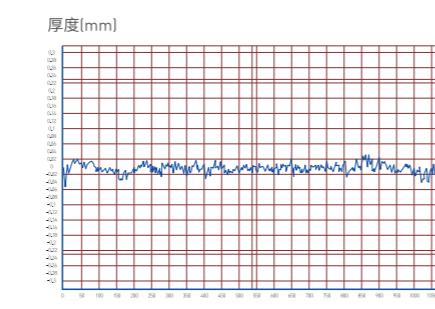
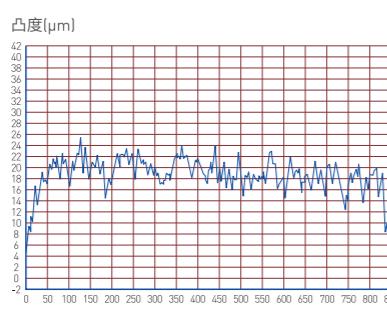
热轧态(16MnCr5和SK85)  
As-hot-rolled state

#### 尺寸精密

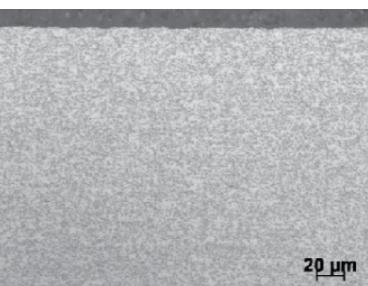
Precise Dimensions

热轧工厂的精确控制,使得产品的尺寸公差达到了世界先进水平,为下游用户提升了产品竞争力。

With the accurate control of hot rolling plants, the dimensional tolerance of the product has reached the world's advanced level, enhancing the product competitiveness for our customers.



凸度及厚度公差  
Crown and tolerance on thickness

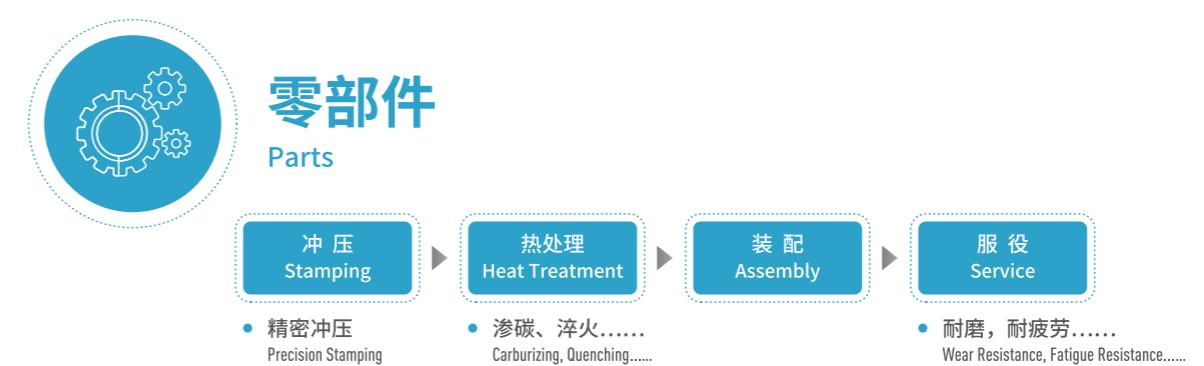
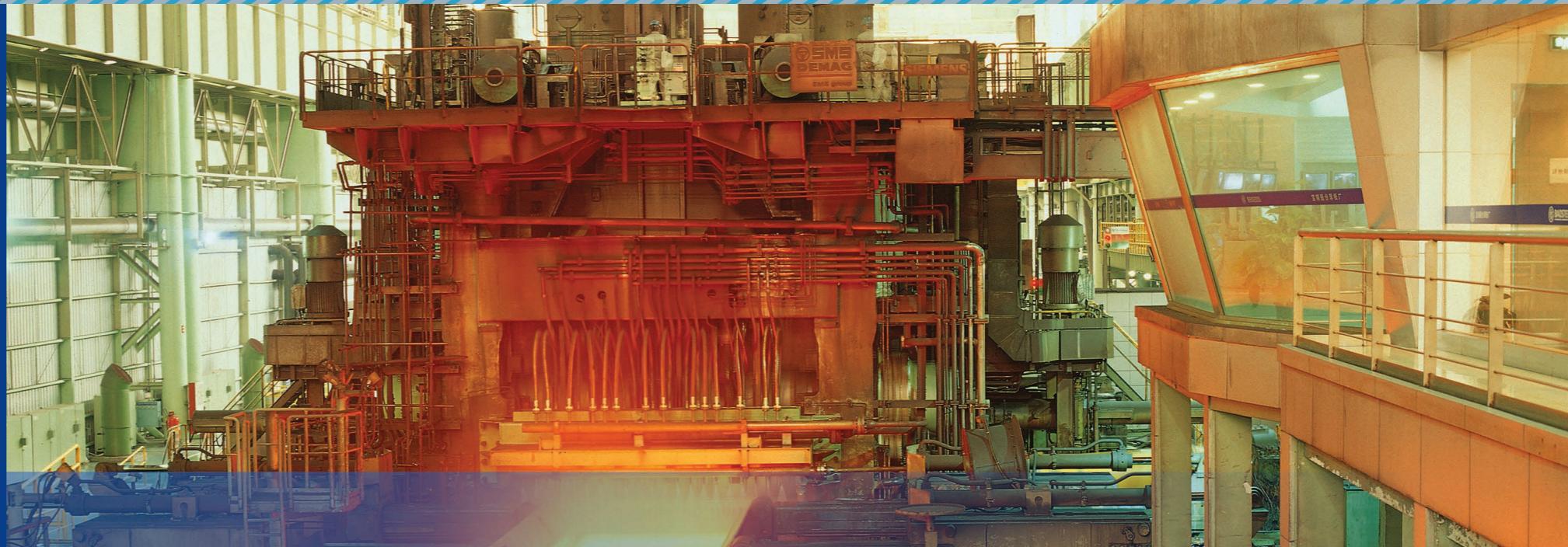


退火态(16MnCr5和SK85)  
As-annealed state



## The User's Main Processing

### 用户主要加工工艺



## Steel Grade and Chemical Composition

### 主要牌号及化学成分

#### ■ 碳素钢 Carbon Steel

牌号	化学成分(质量分数) %						
	C	Si	Mn	P	S	Alt	其他
30	0.27~0.34	0.17~0.37	0.50~0.80	≤0.030	≤0.030		Cu≤0.25
35	0.32~0.39	0.17~0.37	0.50~0.80	≤0.030	≤0.030		Ni≤0.30
45	0.42~0.50	0.15~0.37	0.50~0.90	≤0.030	≤0.030		Cr≤0.20
50	0.47~0.55	0.17~0.37	0.50~0.80	≤0.030	≤0.030		N≤0.008 (供方如能保证, 可不进行分析)
65	0.62~0.70	0.17~0.37	0.50~0.80	≤0.030	≤0.030		
C60E	0.57~0.65	≤0.35	0.60~0.90	≤0.030	≤0.020		Ni≤0.40 Cr≤0.40 Mo≤0.10 Ni+Cr+Mo≤0.63
BJS15C	0.13~0.18	0.15~0.35	0.30~0.70	≤0.020	≤0.010		
BJS20C	0.18~0.23	0.15~0.35	0.30~0.70	≤0.020	≤0.010		
BJS55C	0.52~0.58	0.15~0.35	0.60~0.90	≤0.020	≤0.010		Cu≤0.30
C10	0.08~0.13	≤0.35	0.30~0.60	≤0.025	≤0.015		Ni≤0.20 Cr≤0.20
S10C	0.08~0.13	0.15~0.35	0.30~0.60	≤0.025	≤0.015		Ni+Cr≤0.35
C15	0.13~0.18	≤0.35	0.30~0.60	≤0.025	≤0.015		
S15C	0.13~0.18	0.15~0.35	0.30~0.60	≤0.025	≤0.015		
S20C	0.18~0.23	0.15~0.35	0.30~0.60	≤0.025	≤0.015	≤0.060	Cu≤0.30 Ni≤0.20
S35C	0.32~0.38	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
S45C	0.42~0.48	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
S50C	0.47~0.53	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
S55C	0.52~0.58	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
SK85(SK5)	0.80~0.90	0.10~0.35	0.10~0.50	≤0.025	≤0.015	-	Cu≤0.25 Ni≤0.25
SK95(SK4)	0.90~1.00	0.10~0.35	0.10~0.50	≤0.025	≤0.015		

牌号	化学成分(质量分数) %						
	C	Si	Mn	P	S	Alt	其他
SK120(SK2)	1.15~1.25	0.10~0.35	0.10~0.50	≤0.025	≤0.015		
SAE1018 <sup>a</sup>	0.15~0.20	0.15~0.35	0.60~0.90	≤0.025	≤0.015	≤0.060	Cu≤0.35 Ni≤0.25
SAE1020 <sup>a</sup>	0.18~0.23	0.15~0.35	0.30~0.60	≤0.025	≤0.015		
SAE1022 <sup>a</sup>	0.18~0.23	0.15~0.35	0.70~1.00	≤0.025	≤0.015		
SAE1035 <sup>a</sup>	0.32~0.38	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
SAE1045 <sup>a</sup>	0.43~0.50	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
SAE1050 <sup>a</sup>	0.47~0.55	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
SAE1055 <sup>a</sup>	0.52~0.60	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
SAE1065 <sup>a</sup>	0.65~0.70	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
SAE1070 <sup>a</sup>	0.65~0.80	0.15~0.35	0.60~0.90	≤0.025	≤0.015		
SAE1078 <sup>a</sup>	0.72~0.85	0.15~0.35	0.30~0.60	≤0.025	≤0.015		
C67S	0.65~0.73	0.15~0.35	0.60~0.90	≤0.025	≤0.015	≤0.060	Cr≤0.40、Ni≤0.40 Mo≤0.10
C75S	0.70~0.80	0.15~0.35	0.60~0.90	≤0.025	≤0.015	≤0.060	
40Mn	0.37~0.44	0.17~0.37	0.70~1.00	≤0.025	≤0.015	≤0.060	Cr≤0.25、Ni≤0.25 Cu≤0.25
45Mn	0.42~0.50	0.17~0.37	0.70~1.00	≤0.025	≤0.015		
65Mn	0.62~0.70	0.17~0.37	0.90~1.20	≤0.020	≤0.010		

a 对牌号SAE1018~SAE1078,当用户要求Si≤0.10%时,牌号后增加后缀“AK”

#### ■ 合金钢 Alloy Steel

牌号	化学成分(质量分数) %								
	C	Si	Mn	P	S	Cr	Mo	Ni	其他 <sup>a</sup>
15Cr	0.12~0.17	0.17~0.37	0.40~0.70	≤0.025	≤0.015	0.70~1.00	-	-	
20Cr	0.18~0.24	0.17~0.37	0.50~0.80	≤0.025	≤0.015	0.70~1.00	-	-	
40Cr	0.37~0.44	0.17~0.37	0.50~0.80	≤0.025	≤0.015	0.80~1.10	-	-	
15CrMo	0.12~0.18	0.17~0.37	0.40~0.70	≤0.025	≤0.015	0.80~1.10	0.40~0.55	-	
20CrMo	0.17~0.24	0.17~0.37	0.40~0.70	≤0.025	≤0.015	0.80~1.10	0.15~0.25	-	
30CrMo	0.26~0.33	0.10~0.30	0.40~0.70	≤0.020	≤0.010	0.80~1.10	0.15~0.25	-	
35CrMo	0.32~0.40	0.17~0.37	0.40~0.70	≤0.025	≤0.015	0.80~1.10	0.15~0.25	-	
34CrMo4	0.30~0.37	≤0.40	0.60~0.90	≤0.025	≤0.015	0.90~1.20	0.15~0.30	-	
42CrMo4	0.38~0.45	≤0.40	0.60~0.90	≤0.025	≤0.015	0.90~1.20	0.15~0.30	-	

残余元素<sup>b</sup>

牌号	化学成分(质量分数) %								
	C	Si	Mn	P	S	Cr	Mo	Ni	其他 <sup>a</sup>
SNCM220	0.17~0.23	0.15~0.35	0.60~0.90	≤0.025	≤0.015	0.40~0.60	0.15~0.25	0.40~0.70	
SCM415	0.13~0.18	0.15~0.35	0.60~0.90	≤0.025	≤0.015	0.90~1.20	0.15~0.25	≤0.25	当Cu为残余元素时: Cu≤0.30
SCM435	0.33~0.38	0.15~0.35	0.60~0.90	≤0.025	≤0.015	0.90~1.20	0.15~0.30	≤0.25	
20MnB5	0.17~0.23	≤0.40	1.10~1.40	≤0.025	≤0.015	-	-	-	B:0.0008~0.0050
22MnB5	0.20~0.25	≤0.40	1.10~1.40	≤0.025	≤0.015	≤0.30	-	-	B:0.0008~0.0050
26MnB5	0.23~0.28	≤0.40	1.10~1.40	≤0.025	≤0.015	≤0.30	-	≤0.20	B:0.0008~0.0050
S28CB	0.25~0.30	≤0.40	0.30~0.60	≤0.025	≤0.015	0.30~0.60	-	≤0.20	B:0.0008~0.0050
38MnB5	0.36~0.42	≤0.40	1.15~1.45	≤0.025	≤0.015	-	-	-	B:0.0008~0.0050
27MnCrB5-2	0.24~0.30	≤0.40	1.10~1.40	≤0.025	≤0.015	0.30~0.60	-	-	B:0.0008~0.0050
40MnB	0.37~0.44	0.17~0.37	1.10~1.40	≤0.025	≤0.015	-	-	-	B:0.0008~0.0035 残余元素 <sup>b</sup>
16MnCr5	0.14~0.19	≤0.40	1.00~1.30	≤0.025	≤0.015	0.80~1.10	-	-	-
20CrMnTi	0.17~0.23	0.17~0.37	0.80~1.10	≤0.025	≤0.015	1.10~1.30	-	-	Ti:0.04~0.10 残余元素 <sup>b</sup>
SAE5120H	0.17~0.23	0.15~0.35	0.60~1.00	≤0.025	≤0.025	0.60~1.00	-	-	残余元素 <sup>b</sup>
40CrMn	0.37~0.45	0.17~0.37	0.90~1.20	≤0.025	≤0.015	0.90~1.20	-	-	残余元素 <sup>b</sup>
50Mn2V	0.47~0.55	0.17~0.37	1.40~1.80	≤0.025	≤0.015	≤0.30	-	-	V:0.08~0.16 残余元素 <sup>b</sup>
65Mn-Cr	0.62~0.70	0.17~0.37	0.90~1.20	≤0.025	≤0.015	0.15~0.30	-	-	-
75Cr1	0.72~0.80	0.20~0.45	0.60~0.90	≤0.020	≤0.010	0.30~0.60	-	≤0.25	Cu≤0.25
50CrV [50CrVA]	0.46~0.54	0.17~0.37	0.50~0.80	≤0.025	≤0.015	0.80~1.10	-	≤0.35	V:0.10~0.20 Cu≤0.25
51CrV4 [50CrV4]	0.47~0.55	≤0.40	0.70~1.10	≤0.025	≤0.015	0.90~1.20	-	-	V:0.10~0.25
80CrV2 [8CrV]	0.75~0.85	0.17~0.37	0.30~0.60	≤0.025	≤0.015	0.40~0.70	-	≤0.40	V:0.15~0.25 Mo≤0.10
GCr15	0.95~1.05	0.15~0.35	0.15~0.35	≤0.025	≤0.015	1.35~1.60	≤0.10	≤0.30	Cu≤0.20
X32CrMoV4-1	0.27~0.35	0.17~0.37	0.90~1.10	≤0.025	≤0.015	3.80~4.20	1.10~1.40	0.60~0.80	V:0.30~0.40 Alt≤0.08
D6A	0.43~0.51	0.10~0.30	0.70~1.00	≤0.025	≤0.015	0.90~1.10	0.90~1.10	0.50~0.60	V:0.10~0.20 Alt≤0.10
SAE 8660 MOD	0.61~0.72	0.15~0.35	0.30~0.50	≤0.025	≤0.015	0.45~0.60	0.15~0.25	0.60~0.75	
SAE 8660 MOD-1	0.61~0.72	0.15~0.35	0.30~0.50	≤0.025	≤0.015	0.20~0.35	0.08~0.15	0.20~0.35	
60Si2MnA	0.56~0.64	1.60~2.00	0.70~1.00	≤0.025	≤0.015	≤0.35	-	≤0.35	Cu≤0.25
30CrSiMoVA	0.27~0.35	0.50~0.80	0.50~0.80	≤0.025	≤0.015	1.00~1.30	0.40~0.60	≤0.30	V:0.10~0.25 Cu≤0.25

<sup>a</sup> Alt≤0.060

<sup>b</sup> 作为残余元素时:Cu≤0.25, Ni≤0.30, Cr≤0.30, Mo≤0.10

## Typical Application 典型应用

### BJS20C/20MnB5

应用于汽车座椅调角器零件  
Vehicle Seat Recliner



### 30CrMo

应用于汽车门锁  
Vehicle Door Lock



### 16MnCr5

应用于汽车发动机摇臂  
Vehicle Engine Valve Rocker Arm



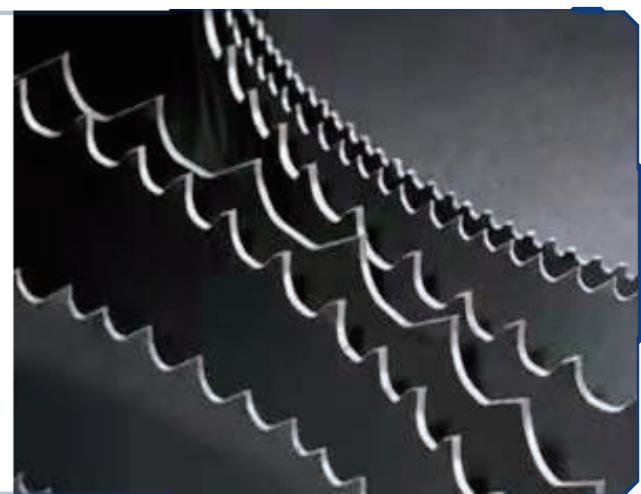
50CrV4/51CrV4

应用于汽车变速箱膜片弹簧和汽车各类卡箍  
Vehicle Diaphragm Springs and Clamp



X32CrMoV4-1

应用于双金属锯片  
Bimetallic Band Saw Blade Body



42CrMo4

应用于汽车座椅调高齿板  
Vehicle Height Profile Tooth Plate



SAE1055

应用于汽车正时链条链片  
Vehicle Engine Timing Chain



75Cr1/8CrV

应用于圆盘锯片  
Circular Saw Blade Body



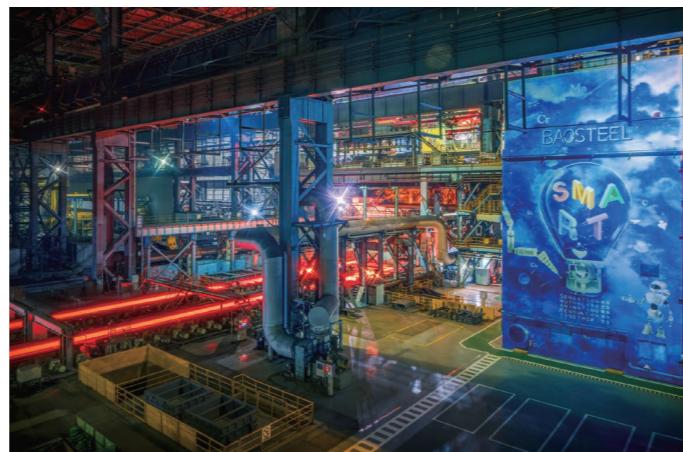
SK85/SK95

应用于纺织机械  
Textile Machinery Spinning Needles



## Qualifications and Certifications

### 资质与认证



宝钢股份四个基地,上海宝山基地(总部)、武汉青山基地、南京梅山基地、湛江东山基地均已通过ISO 9001、IATF 16949质量管理体系、ISO 14001环境管理体系、ISO 45001职业健康安全管理体系、ISO 50001能源管理体系、测量管理体系等认证。更多体系及产品认证信息请参看宝钢股份主页。

<https://www.baosteel.com/product/Certificate>

Baoshan Iron & Steel Co., Ltd. (Baosteel Co., Ltd.) has four production bases, namely the Shanghai Baoshan Base (core), Wuhan Qingshan Base, Nanjing Meishan Base, and Zhanjiang Dongshan Base, all of which have obtained certifications for ISO 9001, IATF 16949 Quality Management System, ISO 14001 Environmental Management System, ISO 45001 Occupational Health and Safety Management System, ISO 50001 Energy Management System, and Measurement Management System. For more information on system and product certifications, please refer to the official website of Baosteel Co., Ltd. at <https://www.baosteel.com/product/Certificate>.



ISO 9001  
质量管理体系证书  
QMS Certificate

IATF 16949  
质量管理体系证书  
QMS Certificate

ISO 14001  
环境管理体系证书  
EMS Certificate

ISO 45001  
职业健康安全管理体系证书  
OHSMS Certificate



ISO 50001 能源管理体系认证证书  
Energy EMS Certificate



测量管理体系认证证书  
Measurement Management System Certificate

# Compliance of Products with Environmental Protection Laws and Regulations

## 产品环保法规合规性

宝钢股份与其原材料供应商一起,根据宝钢股份在钢铁产品制造领域的丰富经验,以及原料供应商提供的原材料信息,借助现有科学及技术条件下的最新技术评估手段,对宝钢钢铁产品的法律法规符合性进行了审慎评估,宝钢热轧四基地产品均符合REACH法规相关条款的规定,并符合欧盟2011/65/EU (RoHS2.0)《关于在电子电气设备中限制使用某些有害物质指令》及其后续修订的指令。最新版产品合规报告参看宝钢股份主页。



<https://www.baosteel.com/product/Certificate>

搜索

近年来,宝钢股份作为中国钢铁行业领军企业,在低碳领域以“双碳”目标为核心,率先发布了热轧EPD报告,并具备了批量低碳产品的生产能力,成为钢铁行业低碳发展的标杆。

Together with its raw material suppliers, Baosteel has conducted a prudent assessment on the compliance of its iron and steel products with relevant laws and regulations. This assessment is based on Baosteel's extensive experience in the manufacturing of iron and steel products, the raw material information provided by raw material suppliers, and by leveraging the latest technical evaluation methods available under current scientific and technological conditions. All products from Baosteel's four hot-rolling bases comply with the relevant provisions of the REACH Regulation, as well as the EU Directive 2011/65/EU (RoHS 2.0) Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment and its subsequent revised directives. For the latest version of the Product Compliance Report, please refer to Baosteel's official website at <https://www.baosteel.com/product/Certificate>.

In recent years, as a leading enterprise in China's iron and steel industry, Baosteel has centered on the "dual carbon" goals in the low-carbon field. It took the lead in releasing the Environmental Product Declaration (EPD) for hot-rolled steel products and has gained the capacity for mass production of low-carbon products, thus becoming a benchmark for the low-carbon development of the iron and steel industry.

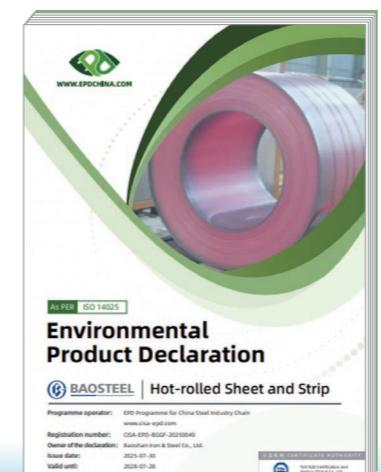


REACH 承诺书  
REACH Commitment Letter

REACH 报告  
REACH Report

ROHS 承诺书  
ROHS Commitment Letter

ROHS 报告  
ROHS Report



热轧 EPD 报告  
Hot-rolled EPD Report



热轧低碳产品质保书样张  
Sample of Hot-rolled low-carbon  
Inspection Certificate

热轧销售部

Hot Rolled Sheet Sales Department

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iBaosteel

<http://www.ibaosteel.com>

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GUANGZHOU BAOSTEEL

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BEIJING BAOSTEEL

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WUHAN BAOSTEEL

CENTRAL CHINA TRADING CO., LTD.

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NORTH-EASTERN TRADING CO., LTD.

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