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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 3639-2009

Replace GB/T 3639-2000

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**Cold-drawn or cold-rolled precision seamless steel  
tubes**

**冷拔或冷轧精密无缝钢管**

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**Issued by General Administration of Quality Supervision, Inspection  
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**Standardization Administration of the People's Republic of  
China**

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## Foreword

This national standard is modified in relation to EN 10305-1: 2002 (*Steel tubes for precision applications-Technical delivery conditions part 1: Seamless cold drawn tubes*)( English version).

This standard was re-drafted by EN 10305-1: 2002, a list is given in annex A about the chapter and section number compared with EN 10305-1: 2002.

This standard made some changes the adoption of EN 10305-1: 2002. The technical differences have been incorporated in the body and involved items are signed with single line in margin. A list is given for reference in annex B about these technical differences and causes.

For easy to use, this standard has made the following editorial changes for EN 10305-1: 2002.

- a) "this standard" replace "the European standard" ;
- b) The decimal point "." replace "," ;
- c) Removed the foreword of EN 10305-1: 2002, increasing this standard foreword.

This standard replaces GB/T 3639-2000. Compared with GB/T 3639-2000, the main changes are as follows:

- modified the classification and designation;
- increased order content;
- modified bending steel;
- removed the example of mark;
- increased the brand of the steel;
- modified the smelting process of the steel;
- removed the manufacturing methods of the tube blank;
- modified the mechanical property of the tube blank;
- increased the flattening test;
- increased Drift expanding test;
- increased magnetic flux leakage testing;
- increased annex A, annex B, annex C, annex D.

Annex A, B, C, D of this standard are informative annexes.

This standard is proposed by the China Iron and Steel Association.

This standard is standardized by the National Steel Technical Committee.

Responsible for drafting the standard unit: Baoshan Iron & Steel Co., Ltd...

Unit participated in the drafting of this standard: Jiang Su Fengli Precision Tube Co., Ltd., Jiangyin Jieda Shaped Tube Co., Ltd....

Main drafters of this standard: Yuqing Luo, Yaofei Zhang, Cailing Liu, Yueming Wu, Jianliang Xue, Weichi Chen.

This standard replaced the previously issued standard is:

- GB/T 3639-1983, GB/T 3639-2000.

## **Cold-drawn or cold-rolled precision seamless steel tubes**

### **1 Scope**

This standard specifies classification, designation, dimension, shape, weight, permissible tolerances, technical requirement, test method, test rules, packaging, marking and quality certificate of Cold-drawn or cold-rolled precision seamless steel tubes.

This standard is applicable to manufacturing mechanical structure,

### **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 222 Permissible Tolerances for Chemical Composition of Steel Products

GB/T 223.5 Steel and iron - Determination of acid-soluble silicon and total silicon content – Reduced molybdosilicate spectrophotometric method (GB/T 223.5-2008, ISO 4829-1:1986, ISO 4829-2:1988, MOD)

GB/T 223.12 Methods for chemical analysis of iron, steel and alloy -The sodium carbonate separation-diphenyl carbazide photometric method for the determination of chromium content

GB/T 223.23 Methods for chemical analysis of iron, steel and alloy - the dimethylglyoxime spectrophotometric method for the determination of nickel content

GB/T 223.26 steel and alloy, determination of molybdenum content, thiocyanate spectrophotometric.

GB/T 223.53 Methods for chemical analysis of iron, steel and alloy - the flame atomic absorption spectrophotometric method for the determination of copper content

GB/T 223.59 Methods for chemical analysis of iron, steel and alloy - the reduced molybdoantimonyl phosphoric acid photometric method for the determination of phosphorus content

GB/T 223.63 Methods for chemical analysis of iron, steel and alloy - The sodium



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