Title (en)

METHOD OF CONTROLLING THE TEMPERATURE OF STEEL STRIP IN THE COOLING ZONE OF A CONTINUOUS ANNEALING FURNACE

Publication

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Application

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Abstract (en)

[origin: EP0145485A2] The invention relates to a method of controlling the temperature of a steel strip (1) in the cooling zone of a continuous annealing furnace which is provided with a plurality of cooling rolls (2 to 5) in which a coolant is circulated via a circuit (14 to 18) for cooling the strip as it is brought into contact with the outer peripheral surfaces of the rolls, the coolant temperature being controlled via temperature control means (19 to 21), and a plurality of gas jet coolers (6 to 9) for blowing cooling gas against the strip. In accordance with the invention, the flow rate of the cooling gas, the angle at which the strip is brought into contact with the surfaces of the rolls and the coolant temperature are controlled selectively in the order of, first, at least one of either the flow rate of coolant, or the angle, and then the coolant temperature, so that the strip may be cooled quickly and efficiently to a predetermined temperature irrespective of any change in strip gauge during the continuous annealing of a plurality of strips which are different gauge.

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