

Title (en)  
Process for manufacturing H-shaped steels.

Title (de)  
Verfahren zum Herstellen von H-Stahlprofilen.

Title (fr)  
Procédé pour la fabrication de poutrelles d'acier en H.

Publication  
**EP 0559539 A1 19930908**

Application  
**EP 93400514 A 19930301**

Priority  
JP 4493492 A 19920302

Abstract (en)  
A process for manufacturing H-shaped steels through intermediate hot rolling, and finishing hot rolling to provide H-shaped steels is disclosed. The horizontal roll is divided into two or more pieces in a roll axis direction, the width is adjustable for each pass. The intermediate rolling comprises a first step of forming one or more non-rolled portions on the surface of the web while carrying out reduction in web thickness as well as reduction in the thickness of flanges; a second step of flattening the web surface to expand the inner web width while not only reduction in thickness of the flange but also reduction in thickness of the web are carried out with the other universal mill; alternatively a first step of flattening the web surface while performing reduction in flange thickness with one of the first and second universal mills; a second step of forming one or more non-rolled portions on the web surface and simultaneously reducing the inner web width while not only reduction in thickness of the flange but also reduction in thickness of the web are carried out with the other universal roughing mill; and repeating the first and second steps until a predetermined amount of expansion or reduction is achieved.

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**B21B 1/0886** (2013.01)

Citation (search report)

- [AP] EP 0498733 A2 19920812 - SUMITOMO METAL IND [JP]
- [A] EP 0348913 A2 19900103 - KAWASAKI STEEL CO [JP]
- [AD] PATENT ABSTRACTS OF JAPAN vol. 009, no. 223 (M-411)10 September 1985 & JP-A-60 082 201 ( KAWASAKI SEITETSU ) 10 May 1985
- [A] PATENT ABSTRACTS OF JAPAN vol. 010, no. 331 (M-533)11 November 1986 & JP-A-61 135 403 ( KAWASAKI STEEL ) 23 June 1986
- [AD] PATENT ABSTRACTS OF JAPAN vol. 010, no. 331 (M-533)11 November 1986 & JP-A-61 135 403 ( KAWASAKI STEEL ) 23 June 1986
- [A] PATENT ABSTRACTS OF JAPAN vol. 013, no. 55 (M-795)8 February 1989 & JP-A-63 260 602 ( NIPPON STEEL ) 27 October 1988
- [AD] PATENT ABSTRACTS OF JAPAN vol. 011, no. 393 (M-654)23 December 1987 & JP-A-62 161 403 ( KAWASAKI STEEL ) 17 July 1987
- [AD] PATENT ABSTRACTS OF JAPAN vol. 014, no. 135 (M-949)14 March 1990 & JP-A-02 006 001 ( KAWASAKI STEEL ) 10 January 1990

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