

Title (en)

METHOD OF AND APPARATUS FOR HOT ROLLING H-STEEL

Title (de)

VERFAHREN UND VORRICHTUNG ZUM WARMWALZEN VON H-STAHLTRÄGERN

Title (fr)

PROCEDE ET DISPOSITIF DE LAMINAGE A CHAUD D'ACIER A PROFIL EN H

Publication

**EP 0760263 A1 19970305 (EN)**

Application

**EP 96906060 A 19960315**

Priority

- JP 9600688 W 19960315
- JP 5910995 A 19950317

Abstract (en)

Object: In order to prevent (1) problems occurred at the time of biting of flanges by rolls, (2) wear of lateral surfaces of horizontal rolls of the fixed-width type as well as need for a frequent roll exchange, (3) wear of lateral surfaces of horizontal rolls of the fixed-width type, and (4) formation of rolling flaws on the inner surfaces of flanges, during tandem rolling through a roll arrangement of UR + E + UF. Constitution: A reverse rolling is carried out with a UR mill having a width WR of horizontal rolls, a UF mill having a width WF of horizontal rolls, and an E mill having a width WE of horizontal rolls under the conditions  $WF > WE$ ,  $WR$ , or  $WE < WF$ ,  $WR$ . <IMAGE>

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