

## Title (en)

Method for continuously producing, in a line, rolled sheet metal strip of stainless steel with improved surface condition

## Title (de)

Verfahren zur kontinuierlichen Herstellung in einer Linie von einem aus nichtrostendem Stahl gewalzten Blechband mit verbessertem Oberflächenzustand

## Title (fr)

Procédé d'élaboration, sur une ligne, en continu, d'une bande de tôle laminée d'acier inoxydable présentant un état de surface améliorée

## Publication

**EP 0769333 A1 19970423 (FR)**

## Application

**EP 96402086 A 19961001**

## Priority

FR 9512271 A 19951019

## Abstract (en)

The hot rolled stainless steel strip is subjected to a continuous surface treatment process comprising flattening the surface whilst residually elongating the strip by 1-5% in order to crack the oxide coating, pickling to remove the oxide, cold rolling in a max. of three passes, final annealing, final pickling, and skin passing. Also claimed is the industrial line for carrying out the above process, with the pickling station being a spray or electrolytic-type process. In the latter the electrolyte is a neutral salt or phosphoric acid. The cold rolling appts. is at least three cages of multi-cylinders of dia. below 180, pref. below 150 mm.

## Abstract (fr)

Procédé d'élaboration sur une ligne, en continu, d'une bande de tôle laminée d'acier inoxydable présentant un état de surface amélioré caractérisé en ce que la tôle élaborée à chaud, est soumise principalement à : un planage sous traction produisant un allongement résiduel de 1 à 5%, pour fissurer la couche d'oxyde et planer la tôle, un décapage primaire assurant le retrait de la calamine, un laminage à froid en au plus trois passes de laminage, un recuit final, un décapage final, un laminage à froid de type "skin pass". <IMAGE>

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## IPC 8 full level

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## CPC (source: EP KR US)

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## Citation (search report)

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