

Title (en)

Method for rolling sheet pile profiles starting from a near net shape casted preliminary section

Title (de)

Arbeitsverfahren zum Walzen Fertigprofilen aus einem endabmessungsnahen, aus einer Stranggusseinrichtung kommenden Vorprofil

Title (fr)

Procédé de laminage pour laminier des profilés de palplanche à partir d' une ébauche de profilés coulée proche à ses dimensions

Publication

**EP 0890395 B1 20020508 (DE)**

Application

**EP 98112633 A 19980708**

Priority

DE 19729991 A 19970712

Abstract (en)

[origin: US6035683A] A method of casting and rolling and a roll stand arrangement for rolling finished sections (sheet piling sections) from a preliminary section which arrives from a continuous casting machine and has approximate final dimensions. The method utilizes roll stand arrangements which operate in a rolling line in a reversing operation. A roughing rolling group has in a first rolling line a runout roller table and a transverse transport device following the runout roller table and in a second rolling line a parallel run-in roller table for a compact tandem stand group. A horizontal stand of the roughing rolling group and/or an intermediate edging stand of the compact tandem stand group each have two selectable grooves, wherein a universal stand on the exit side of the compact tandem group has one or more two-high horizontal stands with grooved rolls. When rolling with this stand arrangement, for adjusting the width and for adjusting the shape of a preliminary section having a H-shaped cross-section while simultaneously reducing the cross-section in the roughing rolling group, further reduction of the cross-section with deformation of section ends for forming interlocks is carried in the compact tandem stand group and a final finish-shaping of the interlocks of the section is carried out in the grooves of the two-high horizontal stands.

IPC 1-7

**B21B 1/08**; **B21B 1/14**

IPC 8 full level

**B21B 1/08** (2006.01); **B21B 1/14** (2006.01); **B21B 1/46** (2006.01)

CPC (source: EP US)

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Cited by

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**US 11270998 A 19980709**; AT 98112633 T 19980708; CA 2242786 A 19980710; DE 19729991 A 19970712; DE 59804024 T 19980708; EP 98112633 A 19980708; ES 98112633 T 19980708