

Title (en)  
PROCESS AND PLANT FOR MANUFACTURING GRATES

Title (de)  
VERFAHREN UND ANLAGE ZUM HERSTELLEN VON GITTERMATTEN

Title (fr)  
PROCEDE ET INSTALLATION DE FABRICATION DE MATS EN TREILLIS

Publication  
**EP 0981414 A1 20000301 (DE)**

Application  
**EP 99900389 A 19990108**

Priority  
• AT 9900005 W 19990108  
• AT 23598 A 19980210

Abstract (en)  
[origin: WO9941029A1] A process and plant are disclosed for manufacturing grates made of longitudinal and transverse hot-rolled steel rods which cross one another and are welded together at their crossing points. The billet used to form the longitudinal rods is continuously withdrawn in a device (1) over a spill from a wire storage, stretched to improve its mechanical technological properties, then tempered and cut into sections. The longitudinal rods are then arranged in groups, according to the arrangement of the longitudinal rods in the grate to be produced, are moved into the working region of the grate welding machine (4) and introduced therein. The billet for forming the transverse rods is continuously withdrawn in a device (5) over a spill from a wire storage, stretched to improve its mechanical technological properties, then conveyed through a buffer storage, tempered, then each transverse rod separated from the billet is fed to the grate welding machine in time with the welding cycles.

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