

Title (en)
Process for manufacturing hot strip

Title (de)
Verfahren zum Herstellen eines Warmbandes

Title (fr)
Procédé pour produire une bande laminée à chaud

Publication
EP 1038978 B1 20040512 (DE)

Application
EP 00103097 A 20000216

Priority
DE 19913498 A 19990325

Abstract (en)
[origin: EP1038978A1] Hot rolled microalloyed steel strip production, uses inter-stand cooling to allow final rolling passes at a temperature below the recrystallization temperature. Production of hot rolled strip (W) of unalloyed or low alloy steel containing micro-alloying elements, from optionally reheated continuously cast slabs, plates or strip, comprises: (a) feeding strip into the first stand (F1) of a tandem finishing line (FS) at ≥ 30 degrees C above the recrystallization end temperature (TR); (b) continuously rolling the strip in one or more passes in the austenite recrystallization region; (c) cooling the strip between adjacent stands (F1-F7) by cooling devices (K2-K7) to ≥ 20 degrees C below the recrystallization end temperature (TR) at a cooling rate of ≥ 10 degrees C/sec.; and (d) rolling the strip at below the recrystallization end temperature (TR) in several passes with a total deformation (ϵ h) of $\geq 30\%$. An Independent claim is also included for a hot strip line for carrying out the above process.

IPC 1-7
C21D 8/02; **B21B 1/26**

IPC 8 full level
B21B 1/26 (2006.01); **C21D 8/02** (2006.01); **B21B 1/28** (2006.01); **B21B 1/46** (2006.01); **B21B 45/02** (2006.01)

CPC (source: EP)
B21B 1/26 (2013.01); **C21D 8/0226** (2013.01); **B21B 1/28** (2013.01); **B21B 1/46** (2013.01); **B21B 45/0218** (2013.01); **B21B 2201/04** (2013.01); **C21D 8/0236** (2013.01); **C21D 8/0278** (2013.01)

Cited by
DE102013107010A1; CN103447295A; CN110665964A; EP4101552A1; CN105392574A; US10335840B2; WO2015000895A1; WO2022258376A1; EP3016754B1; EP3016754B2

Designated contracting state (EPC)
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU MC NL PT SE

DOCDB simple family (publication)
EP 1038978 A1 20000927; **EP 1038978 B1 20040512**; AT E266741 T1 20040515; DE 19913498 C1 20001012; DE 50006370 D1 20040617; ES 2220272 T3 20041216

DOCDB simple family (application)
EP 00103097 A 20000216; AT 00103097 T 20000216; DE 19913498 A 19990325; DE 50006370 T 20000216; ES 00103097 T 20000216