Title (en)
METHOD FOR SEPARATING ROLLING OF STOCK MATERIAL

Title (de)
VERFAHREN ZUM LÄNGSTRENNWALZEN VON WALZGUT

Title (fr)
PROCEDE DE LAMINAGE DE FLANS PAR SEPARATION

Publication
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Application
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Abstract (en)

[origin: EP1306142A1] The present invention relates to rolling process, particularly to the methods of double feed rolling with its following slitting in the rolling mill line and its following two-strand rolling, and can be implemented at two-high reversing and billet mills. The object of the present invention is to provide simultaneous double feed rolling in square passes, to improve finished product quality, particularly its macrostructure, giving a heavy reduction to ingot core part, to improve mill performance characteristics. Technological effects of the present invention are elimination of the feed twisting round its longitudinal axis in diagonal square passes, decrease of the ingot macrostructure defects due to axial porosity compacting and complete elimination of segregation. Slitting method of billet rolling is the method whereby a heated ingot is successively rolled in box, rhombic and diagonal square passes of the rolling mill. The method is different from the previously known methods because after the box pass the feed is rolled in a forming slitting pass having the shape of two ovals connected by a bridge and after that in rhombic and diagonal square passes it is further rolled into two feeds connected by a bridge, whereby the double diagonal square feed is slit at a breaking pass by means of round groove ridges having the radius R = (0,3...0,45)a, where "a" is a square billet side. 1il. <IMAGE>

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