

Title (en)

METHOD FOR COOLING WORK PIECES ESPECIALLY SHAPE-ROLLED PRODUCTS FROM RAIL STEEL

Title (de)

VERFAHREN ZUR KÜHLUNG VON WERKSTÜCKEN INSBESONDERE VON PROFILWALZPRODUKTEN AUS SCHIENENSTÄHLEN

Title (fr)

PROCEDE DE REFROIDISSEMENT DE PIECES, EN PARTICULIER DE PRODUITS LAMINES PROFILES EN ACIER QUALITE RAIL

Publication

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Application

EP 02776916 A 20020725

Priority

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Abstract (en)

[origin: WO03012151A1] The invention relates to a method for producing especially shape-rolled products from rail steels that have a finely perlitic and/or ferritic/perlitic structure after cooling. The inventive method is characterized by guiding the work piece through a cooling stretch that is composed of individual independent cooling modules (2a-e) having independently adjustable cooling parameters. Between said cooling modules (2a-e) intermediate zones (5a-e) are provided for relieving the stress of the structure, comprising means for determining the actual temperature (TACTUAL) of the respective work piece in said intermediate zones (5a-e). Depending on the respective actual temperature values (TACTUAL) of the work piece in an intermediate zone (5a-e) the specific cooling parameters, especially the cooling intensity, of the respective subsequent cooling module (2b-e) are controlled in order to safeguard a defined temperature of the work piece during the entire passage through the cooling stretch (1), the defined temperature (TDESIRE) of the work piece being above a critical temperature at which the bainitic portions of the structure are formed.

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See references of WO 03012151A1

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