

Title (en)

Process for manufacturing steel flat products from aluminium alloyed multi phase steel

Title (de)

Verfahren zum Herstellen von Stahl-Flachprodukten aus einem mit Aluminium legierten Mehrphasenstahl

Title (fr)

Procédé pour la fabrication de produits plats à partir d'un acier à plusieurs phases allié en aluminium

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Application

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Priority

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Abstract (en)

The method for the production of flat steel products useful for automotive industry, comprises casting a steel into a cast strip having a thickness of 1-4 mm, hot-rolling the cast strip in-line into a hot-rolled strip having a thickness of greater than 1.5 mm in a continuous process at a final hot-rolling temperature at 850-1000[deg] C, and coiling the hot-rolled strip at a coiling temperature of 350-480[deg] C to obtain a hot-rolled strip, which has a minimum tensile strength R_m of 800 MPa and a minimum breaking elongation A₈₀ of 5%. The method for the production of flat steel products useful for automotive industry, comprises casting a steel into a cast strip having a thickness of 1-4 mm, hot-rolling the cast strip in-line into a hot-rolled strip having a thickness of greater than 1.5 mm in a continuous process at a final hot-rolling temperature at 850-1000[deg] C, and coiling the hot-rolled strip at a coiling temperature of 350-480[deg] C to obtain a hot-rolled strip, which has a minimum tensile strength R_m of 800 MPa and a minimum breaking elongation A₈₀ of 5%. The steel forms a complex phase structure. The shaping degree is greater than 20%. The width of the hot-rolled strip is more than 1.600 mm. The hot-rolled strip is cold-rolled with a thickness of 0.5-1.4 mm at 750-850[deg] C to obtain a cold-rolled strip, which has a minimum tensile strength of 800 MPa and a minimum breaking elongation A₅₀ of 10%. The cold- or hot-rolled strip is provided with a metallic coating, which is galvanizing. The hot-rolled temperature is 900-1000[deg] C and the coiling temperature is 390-480[deg] C, when a minimum breaking elongation A₈₀ of the obtained hot-rolled strip is 10%. The hot-rolled temperature is 850-1000[deg] C and the coiling temperature is 350-390[deg] C, when a minimum tensile strength of the obtained hot-rolled strip is 1000 MPa.

Abstract (de)

Die Erfindung betrifft ein Verfahren, mit dem sich hochfeste Stahl-Flachprodukte über eine große Bandbreite von geometrischen Abmessungen bei vermindertem Herstellungs- und Herstellungsaufwand erzeugen lassen. Dazu wird erfindungsgemäß ein ein Mehrphasengefüge bildender Stahl, der (in Gew.-%) 0,10 - 0,14 % C, 1,30 - 1,70 % Mn, bis zu 0,030 % P, bis zu 0,004 % S, 0,10 - 0,30 % Si, 0,90 - 1,2 % Al, bis zu 0,0070 % N, 0,070 - 0,130 % Ti, 0,040 - 0,060 % Nb, 0,140 - 0,260 % Mo und als Rest Eisen und unvermeidbare Verunreinigungen enthält, zu einem gegossenen Band mit einer Dicke von 1 - 4 mm vergossen, das gegossene Band in einem kontinuierlichen Arbeitsablauf mit einem Umformgrad von mehr als 20 % in-Line bei einer im Bereich von 850 - 1000 °C liegenden Warmwalzendtemperatur zu einem Warmband mit einer Dicke von 0,5 - 3,2 mm warmgewalzt und das Warmband bei einer 350 - 480 °C betragenden Haspeltemperatur gehaspelt, so dass ein Warmband erhalten wird, dessen Zugfestigkeit R_m mindestens 800 MPa bei einer Bruchdehnung A₈₀ von mindestens 5 % beträgt.

IPC 8 full level

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