

Title (en)

A METHOD OF ROLLING RAILS, APPARATUS FOR ROLLING RAILS AND RAIL PRODUCED ACCORDING TO SAID METHOD

Title (de)

VERFAHREN ZUM WALZEN VON SCHIENEN, VORRICHTUNG ZUM WALZEN VON SCHIENEN UND GEMÄSS DEM VERFAHREN HERGESTELLTE SCHIENE

Title (fr)

PRODUCTION DE RAILS ROULANTS, APPAREIL POUR RAILS ROULANTS ET RAIL PRODUIT SELON CE PROCÉDÉ

Publication

EP 2408967 A2 20120125 (EN)

Application

EP 10709165 A 20100308

Priority

- EP 2010001426 W 20100308
- EP 09003746 A 20090316
- EP 10709165 A 20100308

Abstract (en)

[origin: WO2010105749A2] This invention relates to a method of rolling steel rails comprising : Providing a rail blank (5), the blank comprising a foot portion (2), a head portion (3) and a web portion (4) connecting the foot portion to the head portion; Finishing the rail blank to form a steel rail (6) in a multi-stand continuous tandem finishing mill, the finishing mill comprising at least three four-roll universal stands (U1, U2 and U3) and at least two two- roll edger stands (E1, E2), wherein the universal stands contain a vertical roll for forming the lower foot portion (2a) and a vertical roll for forming the head portion (3a) of the rail, and two shaped horizontal rolls for forming the sides (6a, 6b) of the rail and particularly the web portion (4a, 4b) of the rail, wherein the rail blank is passed only once through said finishing mill, and wherein at least the vertical rolls in all universal stands for forming the lower foot portion (2a) are flat rolls, and wherein at least one of universal stands contains a flat vertical roll for forming the head portion (3a). The invention also relates to an apparatus for carrying out said method, and to a product produced therewith.

IPC 8 full level

E01B 31/13 (2006.01); **B21B 1/085** (2006.01)

CPC (source: EP)

B21B 1/085 (2013.01); **E01B 31/13** (2013.01); **B21B 13/08** (2013.01)

Citation (search report)

See references of WO 2010105749A2

Cited by

RU2710410C1

Designated contracting state (EPC)

AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO SE SI SK SM TR

Designated extension state (EPC)

AL BA ME RS

DOCDB simple family (publication)

WO 2010105749 A2 20100923; WO 2010105749 A3 20110127; AP 2011005934 A0 20111031; EP 2408967 A2 20120125; RU 2011141776 A 20130427; RU 2530609 C2 20141010; UA 103795 C2 20131125; ZA 201106122 B 20121031

DOCDB simple family (application)

EP 2010001426 W 20100308; AP 2011005934 A 20100308; EP 10709165 A 20100308; RU 2011141776 A 20100308; UA A201112010 A 20100308; ZA 201106122 A 20110819