

Title (en)
A METHOD OF ROLLING RAILS AND APPARATUS FOR ROLLING RAILS

Title (de)
VERFAHREN ZUM WALZEN VON SCHIENEN UND VORRICHTUNG ZUM WALZEN VON SCHIENEN

Title (fr)
PROCÉDÉ DE LAMINAGE DE RAILS ET DISPOSITIF DE LAMINAGE DE RAILS

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Application
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Abstract (en)
[origin: WO2011063935A2] This invention relates to a method of rolling steel rails comprising : 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 comprising at least one horizontal stand (H) and at least five four-roll universal stands (U), wherein each universal stand (Ux) only contains flat vertical rolls for forming the lower foot portion (2a) and the head portion (3a) of the rail, and wherein each universal stand (Ux) contains 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 in at least one combination of two subsequent stands UI and UI+1 · the rail is worked on the foot and not on the head using the flat vertical rolls in UI and wherein the rail is worked on the head and not on the foot using the flat vertical rolls in UI+1; or · the rail is worked on the head and not on the foot using the flat vertical rolls in UI and wherein the rail is worked on the foot and not on the head using the flat vertical rolls in UI+1. The invention also relates to an apparatus for carrying out said method, and to a product produced therewith.

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