

Title (en)  
PROCESS FOR HOT ROLLING STEEL STRIPS AND HOT ROLLING TRAIN

Title (de)  
VERFAHREN ZUM WARMWALZEN VON STAHLBÄNDERN UND WARMWALZSTRASSE

Title (fr)  
PROCÉDÉ DE LAMINAGE À CHAUD DE BANDES D'ACIER ET TRAIN DE LAMINAGE À CHAUD

Publication  
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Application  
**EP 11715225 A 20110418**

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Abstract (en)  
[origin: WO2011138159A1] The invention relates to an apparatus and a process for hot rolling steel strips (3) in a plurality of successive roll stands (F1-F5), wherein the steel strips are finish-rolled to the end thickness in one or more roll stands firstly in the austenitic state and then, after liquid cooling, in the ferritic state. In order to ensure that the steel strip actually reaches the ferritic state after cooling, it is provided that the end thickness of the steel strip (3) is less than 3 mm, that the difference between the outlet temperature of the steel strip from the last roll stand (F3) before liquid cooling and the equilibrium austenite boundary temperature is set by the pilot control or regulation of the outlet temperature to no more than 70 K, preferably no more than 50 K, preferably less than 25 K, and that the liquid cooling takes place between two roll stands depending on the length (Lc) of a cooling section (1) by the application, in the cooling section and on both sides of the steel strip (3), of at least in each case a quantity of liquid  $Qu > 284/(Lc1.42)$  litres per minute and per metre of strip width, in particular  $Qu > 2 \cdot 284/(Lc1.42)$  litres per minute and per metre of strip width, but not more than  $Qu = 7 \cdot 284/(Lc1.42)$  litres per minute and per metre of strip width, preferably  $Qu 1.42$  litres per minute and per metre of strip width.

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