

Title (en)  
THICK STEEL PLATE MANUFACTURING METHOD AND MANUFACTURING DEVICE

Title (de)  
VERFAHREN UND VORRICHTUNG ZUR HERSTELLUNG DICKER STAHLPLATTEN

Title (fr)  
DISPOSITIF ET PROCÉDÉ DE FABRICATION D'UNE TÔLE D'ACIER ÉPAISSE

Publication  
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Application  
**EP 14773154 A 20140320**

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Abstract (en)  
An object of the present invention is to provide a method and a facility for manufacturing a steel plate by which a high-quality steel plate having less variation in quality can be ensured. A method for manufacturing a steel plate, including a hot-rolling step, a shape correction step and an accelerated cooling step in this order, the method further includes a temperature adjustment step of performing air cooling such that a surface temperature of the steel plate is lowered below the Ar 3 transformation point or performing water cooling by supplying cooling water to upper and lower surfaces of the steel plate at a water amount density of 0.3 to 2.2 m<sup>3</sup>/m<sup>2</sup>·min between the shape correction step and the accelerated cooling step, to transform the surface of the steel plate and, a descaling step of jetting high pressure water having an energy density of 0.05 J/mm<sup>2</sup> or more to the surfaces of the steel plate after the temperature adjustment step and before the accelerated cooling step.

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