

Title (en)
METHOD FOR HOT ROLLING STEEL STRIP

Title (de)
VERFAHREN ZUM WARMWALZEN VON STAHLBAND

Title (fr)
PROCÉDÉ POUR LAMINER À CHAUD DES FEUILLARDS D'ACIER

Publication
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Application
EP 14736716 A 20140701

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Abstract (en)
[origin: WO2015000895A1] The invention relates to a method and a plant for hot rolling steel strip (S), wherein the plant has a hot rolling relay (2) which comprises a plurality of roll stands (F1 - F7) which are successively passed through in the conveying direction (F) of the steel strip (S) to be hot rolled, and a cooling section (5) for intensively cooling the hot-rolled steel strip (S) emerging from the last roll stand (F7) of the rolling relay (2). By way of the invention, it is possible, on the basis of such a conventional hot rolling plant, to produce in an operationally reliable manner hot strips with a final thickness of more than 15 mm that satisfy even the highest requirements placed on their toughness. This is achieved according to the invention in that the start of the cooling section (5), as seen in the conveying direction (F) of the steel strip (S) to be hot rolled, is moved to before the end of the hot rolling relay (2), and in that the cooling section (5) starts following the last roll stand (F5) which is passed through before entering the cooling section (5) and in which hot rolling of the steel strip (S) to be hot rolled in each case takes place.

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Citation (opposition)
Opponent :
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• EP 1038978 B1 20040512 - THYSSENKRUPP STAHL AG [DE]
• E. MUTHMANN, ET AL: "Manufacturing of Large Steel Components for Nord Stream Project", 3R INTERNATIONAL. SPECIAL EDITION. STEEL PIPES, 1 February 2010 (2010-02-01), pages 26 - 31, XP055757377

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