

Title (en)

METHOD FOR FORMING AND HARDENING STEEL MATERIALS

Title (de)

VERFAHREN ZUM FORMEN UND HÄRTEN VON STAHLWERKSTOFFEN

Title (fr)

PROCÉDÉ DE MOULAGE ET DE DURCISSEMENT DE MATÉRIAUX D'ACIER

Publication

EP 3497251 A1 20190619 (DE)

Application

EP 17736614 A 20170629

Priority

- DE 102016114658 A 20160808
- EP 2017066077 W 20170629

Abstract (en)

[origin: CA3032551A1] The invention relates to a method for hydroforming and hardening galvanised tubes made from sheet steel. A prefabricated tube is used, the tube having at least one feed opening (5) and a cavity (4). The tube is heated to a temperature above the austenitising temperature (AC3) of the steel alloy in question and, after a desired degree of austenitisation is achieved, is placed into a hydroforming tool and subjected to a pressurised medium, which is injected through the at least one feed opening (5) into the cavity (4) until the tube fills a predefined form (2) of the tool. The method is characterised in that the forming tool is heated to a temperature of 400-650°C, in particular 450-550°C, and the pressure medium is likewise heated and has a temperature of 400-650°C, wherein, after austenitisation, the tube is passively allowed to cool or is actively cooled to a temperature of 400-600°C but a temperature above the martensite start temperature (Ms) of the selected steel alloy, and the tube is cooled for hardening purposes only after final shaping in the forming tool.

IPC 8 full level

C21D 7/13 (2006.01); **B21D 22/02** (2006.01); **B21D 26/033** (2011.01); **C21D 8/10** (2006.01); **C21D 9/08** (2006.01)

CPC (source: EP US)

B21D 26/033 (2013.01 - EP US); **C21D 7/13** (2013.01 - EP US); **C21D 8/10** (2013.01 - EP US); **C21D 8/105** (2013.01 - EP US); **C21D 9/08** (2013.01 - EP US); **C21D 2211/008** (2013.01 - EP US)

Designated contracting state (EPC)

AL 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 RS SE SI SK SM TR

Designated extension state (EPC)

BA ME

DOCDB simple family (publication)

DE 102016114658 A1 20180208; **DE 102016114658 B4 20211014**; CA 3032551 A1 20180215; CA 3032551 C 20240213; CN 109642262 A 20190416; CN 109642262 B 20201113; EP 3497251 A1 20190619; EP 3497251 B1 20200401; ES 2787927 T3 20201019; US 11332800 B2 20220517; US 2019177812 A1 20190613; WO 2018028877 A1 20180215

DOCDB simple family (application)

DE 102016114658 A 20160808; CA 3032551 A 20170629; CN 201780049424 A 20170629; EP 17736614 A 20170629; EP 2017066077 W 20170629; ES 17736614 T 20170629; US 201716324196 A 20170629