

Title (en)  
PRODUCTION METHOD FOR H-BEAMS

Title (de)  
VERFAHREN ZUR HERSTELLUNG VON H-TRÄGERN

Title (fr)  
PROCÉDÉ DE PRODUCTION POUR DES POUTRELLES EN H

Publication  
**EP 3698894 A1 20200826 (EN)**

Application  
**EP 19751407 A 20190205**

Priority  
• JP 2018022105 A 20180209  
• JP 2019004082 W 20190205

Abstract (en)  
An H-shaped steel product having a larger flange width as compared with conventional ones is efficiently and stably produced by performing flat shaping and rolling of a large-size raw blank without bringing about problems such as elongation in a web height direction and deformation of a flange corresponding part. A rough rolling step includes an edging rolling step, and a flat rolling step of performing rolling of a web part by rotating the material to be rolled after completion of the edging rolling step, upper and lower caliber rolls of at least one caliber of calibers configured to perform the flat rolling step include recessed parts configured to form a raised part at a middle of a web part of the material to be rolled, the recessed parts being provided at roll barrel length middle parts, the caliber configured to perform the flat rolling step further includes a raised part eliminating caliber configured to reduce the raised part and perform inner size widening of the web part of the material to be rolled on the material to be rolled in which the raised part is formed, rolling and shaping in the raised part eliminating caliber is performed on the material to be rolled after forming the raised part in the caliber having the recessed parts configured to form the raised part, and rolling and shaping of forming the raised part is not performed after a reduction of the raised part.

IPC 8 full level  
**B21B 1/088** (2006.01); **B21B 1/08** (2006.01)

CPC (source: EP US)  
**B21B 1/088** (2013.01 - EP US); **B21B 2273/22** (2013.01 - US)

Citation (search report)  
See references of WO 2019156078A1

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Designated extension state (EPC)  
BA ME

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