

Title (en)  
PLANT AND METHOD FOR THE PRODUCTION OF FLAT ROLLED PRODUCTS

Title (de)  
ANLAGE UND VERFAHREN ZUR HERSTELLUNG VON FLACHGEWALZTEN PRODUKTEN

Title (fr)  
INSTALLATION ET PROCÉDÉ DE FABRICATION DE PRODUITS LAMINÉS PLATS

Publication  
**EP 4406669 A1 20240731 (EN)**

Application  
**EP 24154031 A 20240125**

Priority  
IT 202300001272 A 20230127

Abstract (en)  
Rolling plant (10) and method for producing a strip (P) starting from a slab (50) having a certain starting thickness, comprising at least one walking beam heating furnace (16) configured to heat at least the slab (50) to a starting temperature, and a rolling train (25) operatively disposed in line with at least one roughing stand (23) and configured to reduce the thickness of an intermediate rolled product (51) at exit from the roughing stand (23), until the final strip (P) is obtained; the rolling train (25) comprising at least one pre-finishing stand (26) for obtaining a pre-finished rolled product (52), and a plurality of finishing stands (31) for obtaining the final strip (P); the plant (10) comprising load cells (40) directly associated with the pre-finishing stand (26) for detecting the rolling force applied on the pre-finished rolled product (52), a rapid heating device (28), interposed between the pre-finishing stand (26) and the finishing stands (31), for heating the pre-finished rolled product (52), and a command and control unit (44) connected both to the load cells (40) and also to the rapid heating device (28) and configured at least to selectively activate the latter (28), at least as a function of the rolling force detected by the load cells (40).

IPC 8 full level  
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**B21B 37/74** (2013.01 - EP)

Citation (search report)  
• [A] WO 2013046347 A1 20130404 - MITSUBISHI HITACHI METALS [JP], et al  
• [A] KR 20120110354 A 20121010 - HYUNDAI STEEL CO [KR]  
• [A] JP 2001321812 A 20011120 - SUMITOMO METAL IND  
• [A] DE 4402402 A1 19950803 - SCHLOEMANN SIEMAG AG [DE]  
• [A] US 2017326605 A1 20171116 - YAMASAKI YUKIHIRO [JP], et al

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**EP 4406669 A1 20240731**; CN 118403892 A 20240730; US 2024253100 A1 20240801; WO 2024157294 A1 20240802

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