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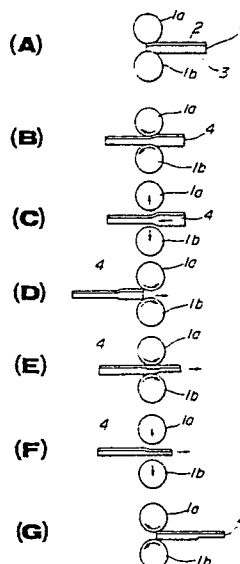
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(54) **Rolling process for clad steel.**

(57) A process for rolling a clad steel satisfactorily reduces the adverse influence of the difference of the deformation resistance of the metal layers composing the clad steel and thereby improves the yield of the rolling process. The rolling process for clad steel includes a step pre-form rolling for a length of 20% to 80% of the overall length of the clad steel. After pre-forming rolling, reduction rolling is performed at a draft substantially equal to or greater than the draft of the pre-form rolling. According to the invention, pre-form rolling process and reduction rolling process are performed for at least two passes.

FIG.1



DOCUMENTS CONSIDERED TO BE RELEVANT			EP 88309025.0
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. X) 5
A	PATENT ABSTRACTS OF JAPAN, unexamined applications, section M, vol. 11, no. 76, March 7, 1987 THE PATENT OFFICE JAPANESE GOVERNMENT page 52 M 569 * Kokai-no. 61-232 004 (HITACHI LTD.) *	1,8	B 21 B 1/38
A	DE - C - 317 588 (HEDDERNHEIMER KUPFERWERKE U. SÜDDEUTSCHE KABELWERKE AG) * Claim *	4	
			TECHNICAL FIELDS SEARCHED (Int. Cl. X) 5
			B 21 B 1/00 B 21 B 3/00 B 21 B 9/00 B 23 K 20/00
The present search report has been drawn up for all claims			
Place of search VIENNA		Date of completion of the search 19-10-1989	Examiner BISTRICH
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	