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• **INTERNATIONAL ROLLING MILL
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(54) **Long slab rolling process and apparatus**

(57) A long slab rolling process and apparatus for producing a plurality of coils from a single slab, comprises at least one continuous caster producing a cast metal slab, means to cut the slab into discrete lengths for rolling, a reheat furnace, a slab welder, an edger, rough and finish rolling mills to produce hot rolled metal strip, a runout cooling table to cool the hot rolled strip, a pair of pinch rolls and a pair of strip deflector tables to deflect the rolled strip downwardly from the rolling line and, in conjunction with a slowing of the speed of the second pinch roll, to form a loop of strip, a flying shear

disposed downstream of the loop and adapted to cut the strip, a part of which is directed onto a first coiler and a remaining portion of which is directed onto a second coiler. In one embodiment of the invention, a second caster and cutter produces second cut slab lengths which are transferred to the reheating furnace after a slab length from the first caster has exited the furnace, and the head end of the second slab length is welded to the tail end of the first slab length.

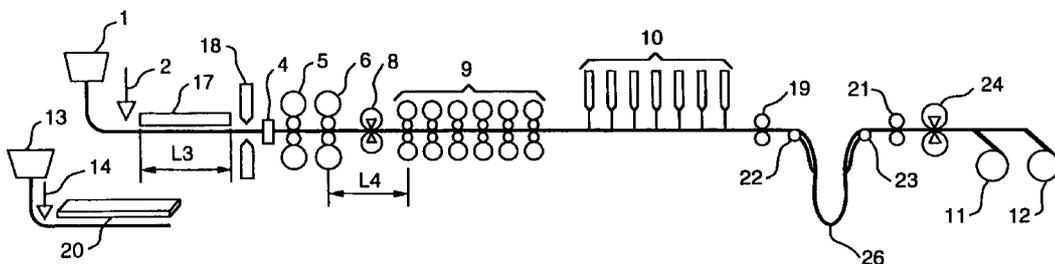


FIG. 2

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EUROPEAN SEARCH REPORT

Application Number
EP 98 10 2462

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| Place of search | | Date of completion of the search | Examiner |
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