



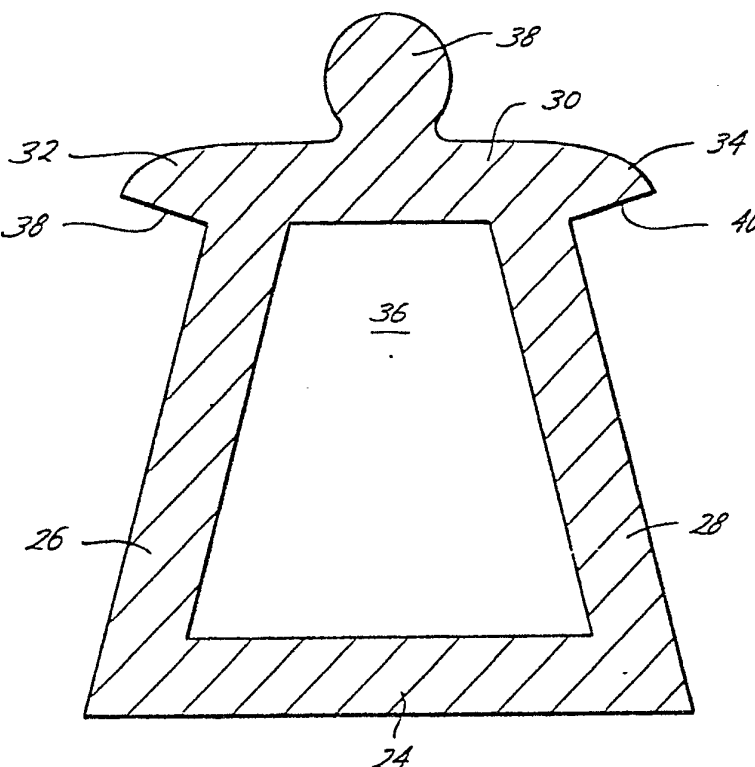
INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ³ : F27D 3/02	A1	(11) International Publication Number: WO 81/00759 (43) International Publication Date: 19 March 1981 (19.03.81)
<p>(21) International Application Number: PCT/US80/01137</p> <p>(22) International Filing Date: 4 September 1980 (04.09.80)</p> <p>(31) Priority Application Number: 074,195</p> <p>(32) Priority Date: 10 September 1979 (10.09.79)</p> <p>(33) Priority Country: US</p> <p>(71) Applicant; and (72) Inventor: CAMPBELL, Frank, Jr. [US/US]; 2274 Broadlawn Drive, Houston, TX 77058 (US).</p> <p>(74) Agent: BLISS, Ronald, G.; Fulbright & Jaworski, 800 Bank of the Southwest Bldg., Houston, TX 77002 (US).</p>	<p>(81) Designated States: AU, BR, JP, SU.</p> <p>Published With international search report</p>	

(54) Title: TRUNCATED TRIANGULAR SKID PIPE

(57) Abstract

A water-cooled skid pipe suitable for supporting metal work pieces in a metallurgical re-heat furnace. The skid pipe has a base member (24), a pair of converging side members (26, 28) and an apex member (30) connecting the uppermost portions of the side members, all such members defining a passageway (36) there-through suitable for conducting a fluid. A pair of shoulders (32, 34) extend outwardly of the junction of each side member (26) or (28) and the apex member (30), which shoulders and apex member prevent the slag from migrating into the seam between the skid pipe and a surrounding insulator. The shoulders (32, 34) further protect any suitable insulator applied around the base member (24) and the converging side members (26, 28) from direct contact by the metal shape. The metal shape can be supported directly by the apex member (30) or a skid member (38) secured atop the apex member (30). The invention can be used outside a furnace as an improved structural support member.



FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	KP	Democratic People's Republic of Korea
AU	Australia	LI	Liechtenstein
BR	Brazil	LU	Luxembourg
CF	Central African Republic	MC	Monaco
CG	Congo	MG	Madagascar
CH	Switzerland	MW	Malawi
CM	Cameroon	NL	Netherlands
DE	Germany, Federal Republic of	NO	Norway
DK	Denmark	RO	Romania
FI	Finland	SE	Sweden
FR	France	SN	Senegal
GA	Gabon	SU	Soviet Union
GB	United Kingdom	TD	Chad
HU	Hungary	TG	Togo
JP	Japan	US	United States of America

1.

TRUNCATED TRIANGULAR SKID PIPE

Technical Field

5 The technical field to which this application relates is the metallurgical reheat furnace in a steel mill.

Background Art

10 In the steel mills and related metallurgical industries, it is customary to form a basic metal shape often called a slab, billet or bloom which is ultimately worked into another form or shape before it leaves the mill. In order to rework the basic shape, it is frequently necessary to reheat the shape in order to make it more
15 malleable during the reworking procedure. A typical metallurgical furnace includes a complex network of vertical and horizontal water-cooled pipes which support an additional network of horizontal circular water-cooled skid pipes which have wear-resistant metal
20 strips along their upper surfaces over which the shapes, in the case of a pusher-type furnace, can be pushed through the furnace during the reheat procedure.

During furnace operations, the movement of the metal shapes along the skid pipes causes large
25 amounts of stress and bending forces to be applied directly to the skid pipe. These forces in combination with the high temperature environment frequently cause the failure or serious degradation of portions of the skid pipe system within the furnace thereby necessitating
30 the shutdown of the furnace for repairs.

The skid pipe, which conventionally includes a circular water-cooled pipe, a refractory around the pipe and some sort of a wear-resistant strip or skid secured to the top of the pipe, must simultaneously
35 provide sufficient support for the metal shapes being pushed across the skid, sufficient resistance to vibrations and coupling effects or moment forces, permit a



sufficient flow of cooled water through it to maintain the skid pipe system at a sufficiently low operating temperature, and retain a refractory around the skid rail, excepting the actual skid itself, which reduces heat loss from the furnace into the pipe.

The industry today generally utilizes a skid pipe comprising a circular water-cooled pipe, a metal skid which is welded to or otherwise attached to the top of the circular pipe and a heavy pre-fired ceramic brick refractory which phenomenon in the metallurgical reheat furnace which results from those portions of the metal shapes which are in contact with the cooler metal skid on the skid pipe which in turn draws a disproportionate amount of heat from the corresponding surface of the metal shape and deposits that heat into the cooling water within. The various shapes of water-cooled pipe which have been utilized in skid pipe systems, however, have in no way resolved the fundamental problem encountered; that is, increasing the ability of the skid pipe to withstand the vibrations, moments and forces exerted upon it during operation and the preventing of slag from migrating into the seams between the skid pipe and insulator thereby causing the the surrounding refractory quickly to be parted from the water-cooled skid pipe thereby permitting unacceptable amount of heat to be transferred into the flowing water and forever lost outside the furnace.

Disclosure of Invention

The present invention relates to a structural member which includes a truncated triangular-shaped pipe, the truncated apex of the pipe having a pair of shoulders which extend outwardly of the walls which upwardly converge. Secured to the top of the apex can be a wear-resistant skid, if the structural member is used as a skid rail, which can be of any shape so long as it permits the metal shape to be pushed along the skid through the furnace during the reheat procedure. When used as a skid pipe the cross-sectional area of the interior passageway of the present invention is preferably nearly the same as the cross-sectional area



of the interior passageway of the present circular pipes in order that the present invention can quickly be incorporated into the existing waterflow patterns of the existing skid pipe networks. The base member, the
5 converging side members and the apex member of the pipe, including the outwardly extending shoulders, are preferably extruded as one piece. The wear-resistant skid rail secured to the apex member of the pipe may also be extruded with the remainder of the pipe in
10 order to be integral therewith and to reduce warping of the skid pipe which often occurs when a welded skid rail cools.

When used as a skid pipe, the upper edges of a surrounding refractory can intimately abut the
15 shoulders of the water-cooled skid pipe. Hence, the shoulders reduce the deleterious effects on a refractory which result when a portion of the metal shape slides off the skid rail onto the remainder of the skid pipe system. Furthermore, the slag and scale which generally
20 collect around the skid and on top of the apex member of the pipe does not directly bear on the seam between the refractory and the shoulder of the pipe thereby reducing greatly the encroachment of the slag into the seam. Hence, the effective life of the refractory,
25 which is in part measured by its ability to remain on the pipe, is greatly enhanced.

The structural member can also be used outside a high temperature environment to replace other structural support members such as double I beams, I
30 beams and the like.

It is therefore an object of the present invention to provide a water-cooled skid pipe which is more resistant to the moments, forces and vibrations occurring during furnace operations than a conventional
35 circular pipe.

Another object of the present invention is to provide a skid pipe which offers increased protection to a surrounding refractory from direct contact by a metal shape.



Still another object of the present invention is to provide a water-cooled skid pipe which greatly reduces the migration of slag into the seam between a surrounding insulator or refractory and the water-cooled skid pipe.

A further object of the present invention is to provide an improved structural member suitable for use as a load bearing support member such as a double I beam.

These and other objects and advantages of the present invention will become apparent when read in light of the drawings, specification and claims below.

Brief Description of the Drawings

Fig. 1 is an elevational view in cross section of a conventional circular skid pipe with a separate skid rail welded to the uppermost portion thereof.

Fig. 2 is an elevational view in cross section of a conventional circular skid pipe, an insulator partially surrounding the pipe, a refractory cement located at each margin of the surrounding refractory, the lower portion of a metal shape resting on top the skid rail and an amount of slag deposited on top one of the refractory cement protectors.

Fig. 3 is an elevational view in cross section of the invention including the outwardly projecting shoulders.

Fig. 4 is an elevational view in cross section of another embodiment of the invention in which the apex member directly supports the metal shape and the shoulders and base member having rounded surfaces.

Best Mode for Carrying Out the Invention

Fig. 1 shows a conventional skid pipe including a circular pipe 2 having a passageway 4 therethrough, and a metal strip or skid rail 6 which is conventionally secured to the circular pipe 2 by a weld 8. A fluid, conventionally cool water, flows through the passageway 4 in order to maintain the temperature of the skid pipe

within operating limits in order to prevent structural failure and scaling of the skid pipe.

As shown in Fig. 2, the skid pipe, excepting the skid rail 6, is insulated by a suitable refractory 12 in order to reduce the heat transfer from the furnace through the pipe and into the cool water which flows outside the furnace thereby causing an irreparable heat loss. The refractory 12 can be secured to the skid pipe by means of, for example, a metal stud 14 welded to the skid pipe which is received by a recess 16 in the insulator. The studs 14 and recesses 16 are conventionally located on both sides of the skid pipe and insulator combination and at sufficiently frequent intervals along the structure to permit support of the insulator 12 by the skid pipe.

As shown in Fig. 2, a metal shape 10, such as a slab, billet or bloom, is supported by the skid rail 6 as the metal shape 10 is pushed along the skid pipe in a longitudinal direction. An amount of slag 20 is deposited by the metal shape 10 onto the skid pipe and collects as a residue which migrates into the seam 21 located between the skid pipe and the refractory 12. Migration of the slag 20 into the seam 21 hastens the degradation of the refractory 12 thereby causing the refractory to separate and fall from the skid pipe. Hence, in a short period of time, the deleterious effects of the slag 20 can cause the removal of the insulator 12 from the skid pipe which in turn greatly increases the heat loss through the skid pipe, the scaling of the skid pipe and even the structural failure of the skid pipe.

A brittle refractory cement 18 is conventionally applied to the skid pipe and the upper margins of the refractory 12 in order to minimize the migration of the slag 20 into the seam 21. The movement of the metal shape 10 along the skid rail 6 induces vibration and flexion of the skid pipe. The vibration and flexion in turn causes the brittle refractory 18 to crack and fall away from its position on the skid pipe. Furthermore,



the metal shape 10 can slide off the skid rail 6 and directly contact the refractory cement 18 thereby causing the refractory cement to separate from the skid pipe and expose the seam 21 to the slag 20. Hence, a
5 skid pipe with greater resistance to flexion and with a means to protect the surrounding insulator 12 from direct contact by the metal shape 10 or from the deleterious effects of the slag 20 is desirable.

The present invention is shown in Figs. 3 and
10 4. In Fig. 3, a truncated triangular skid pipe is shown having a base member 24. A first side member 26 and a second side member 28 extend upwardly from the base member 24 as shown and converge toward one another. The uppermost portions of the side members 26, 28 are
15 connected to an apex member 30. A passageway 36 is defined by the surrounding base member 24, side members 26, 28 and apex member 30, which passageway is suitable for conducting a fluid therein. Preferably, the cross-sectional area of the passageway 36 is not significantly
20 different from the cross-sectional area of the conventional passageway 4 in order that existing furnaces can be retrofitted with a minimum of modification to the flow control system.

A pair of shoulders 32, 34 project outwardly
25 as shown in Figs. 3 and 4 from the uppermost portions of the first and second side members respectively. The shoulders 32 and 34 also project outwardly from the adjacent portions of the apex member and, as shown in Figs. 3 and 4 may appear to be extensions of the apex
30 member 30. A suitable insulator can be applied around the exterior of the base member 24 and the converging side members 26, 28. The refractory preferably will abut the adjacent portions of the shoulders 32, 34.

The shoulders 32, 34 offer significantly more
35 protection to the insulator against a metal shape slipping off the conventional skid rail 38 onto the remainder of the skid pipe. Hence, there is less likelihood that the surrounding insulator will be struck from the skid pipe under such circumstances.



The shoulders 32 and 34 further provide an effective barrier against the deleterious effects of slag accumulation on the skid pipe. The apex member 30 and the shoulders 32 and 34 effectively receive the slag as it is deposited upon the skid pipe. Because the shoulders project outwardly from the side members, the seams 38 and 40 which are located between the shoulders 32 and 34 and a surrounding insulator (not shown) are misaligned from the vertical thereby reducing the tendency of the slag to migrate within the seams. Furthermore, because the need for a brittle refractory cement has been eliminated by the use of the shoulders 32 and 34, the seams 38 and 40 are not exposed later to increased slag migration as the cement falls away.

In Fig. 4, another embodiment of the novel skid pipe is shown. The embodiment of Fig. 4 can be termed a structural member when used outside a high temperature environment and without the necessity of flowing a liquid through the passageway 36. The physical strength advantages of the embodiment of Fig. 4 remain unchanged.

The embodiment in Fig. 4, when used as a skid pipe, discloses that the apex member 30 is the means to contact and support the metal shape. The apex member 30 can be flat, or can be somewhat convex in order to reduce the "shadow effect" upon the supported metal shape. As clearly shown in Fig. 4, the shoulders 32, 34, the first and second ends of the base member 24, and the interior corners of the passageway 36 can be given a radius as opposed to sharply defined corners. Hence, the embodiment as shown in Fig. 4 can easily be extruded as an integral skid pipe, the shoulders 32, 34 being integral with the uppermost portions of the side members 26, 28, respectively and integral with the adjacent portions of the apex member 30, and the side members 26, 28 being integrally secured to the first and second ends respectively of the base member 24. Those skilled in the art will realize that any appropriate skid rail, such as the skid rail 38 as shown in



Fig. 3, or any other supporting shape, can be extruded integrally with the embodiment as shown in Fig. 4.

Because of the novel geometry of the present invention, the new skid pipe and structural member as shown in Figs. 3 and 4 reduces the flexion of the invention as opposed to the conventional circular design known in the prior art. When compared with a standard circular pipe having an inner diameter of 801 mm and an outer diameter of 1143 mm, a comparably sized truncated triangular skid pipe and structural member as shown in Fig. 4 has been calculated to achieve the following results:

EXAMPLE

<u>Property</u>	<u>Truncated Triangular Skid Pipe</u>	<u>Units</u>	<u>Circular Double Strong</u>	<u>Units</u>	<u>N%</u>
water passage area	48.39	cm ²	50.34	cm ²	96.1
face area of metal	75.20	cm ²	52.26	cm ²	143.9
weight/ft w/o water	59.286	Kg/m	41.248	Kg/m	143.7
weight/ft w/water	64.138	Kg/m	46.310	Kg/m	138.5
center of gravity (centroid)	$\bar{x} = 0$ $\bar{y} = 5.92$	cm	$\bar{x} = 0$ $\bar{y} = 5.72$	cm	$\bar{x} = 0$ $\bar{y} = 103.6$
moment of inertia	1138.847	cm ⁴	2039.675	cm ⁴	179.1
section modulus	192.433	cm ³	111.317	cm ³	172.9
radius of gyration	3.891	cm	3.490	cm	111.50
maximum bending moment	8809	Kg/m	5095	Kg/m	172.9
crush strength	319,590	Kg	184,874	Kg	172.9

$$\text{Comparison} = \frac{\text{truncated triangular skid pipe}}{\text{circular double strong pipe}} (100) = \text{N\%}$$



The calculated maximum bending moment and crush strength of the above noted example were obtained for a .3028 meter length of the embodiment as shown in Fig. 4, for a length uniformly loaded at 4218.4 Kg/cm² ultimate stress.

5 The test results clearly show that as compared to a conventional double strong circular pipe, a comparable truncated triangular skid pipe as shown in Fig. 4 has approximately 172.9% the strength of the conventional design.

10 It is clear therefore that the invention as shown and described herein fully meets the objects stated above. The unique geometry of the truncated triangular design with outwardly extending shoulders provides a stronger, more stable skid pipe for operations
15 in a metallurgical reheat furnace. The unique design also provides a high strength, efficiently arranged structural support member for use outside a high temperature environment. When used as a skid pipe, the increased strength and stability reduces the flexion of
20 the skid pipe thereby providing a more rigid skid pipe and reducing the degenerative effect of flexion upon the surrounding insulator. Moreover, the unique outwardly extending shoulders greatly reduce the probability of contact by the metal shape directly upon an insulator
25 around the skid pipe. The unique function of the outwardly extending shoulders further minimize the probability of migration of accumulated slag into the seam between the skid pipe and a surrounding insulator. Hence, not only does the present invention provide for
30 a stronger, more stable support for the metal shape, but it further permits a longer, more useful life of the insulator during furnace operations, thus reducing down time and energy loss.

35 Although a preferred embodiment has been shown and described herein, it is understood that any number of alterations, modifications, reversal of parts and other equivalent structures lie within both the spirit and scope of the claims below.



Industrial Applicability

This invention relates to a structural support member for supporting various metal workpieces as they are passed in a metallurgical reheat furnace in a steel
5 mill.



Claims

1. A water cooled skid pipe for supporting a metal shape in a high temperature environment comprising:

5 a. a base member having first and second ends;

b. first and second side members extending upwardly from the first and second ends respectively of the base member, said upwardly extending side members converging toward one another;

10 c. an apex member connecting the uppermost portions of the converging side members to form a substantially truncated triangular configuration;

15 d. first and second shoulders projecting outwardly from the uppermost portions of the first and second side members respectively and from the apex member;

20 e. a passageway through the skid pipe defined by the base member, first and second side members and the apex member, said passageway suitable for communicating a fluid therethrough; and

25 f. means to contact and support the metal shape.

2. The device in claim 1 wherein the first and second side members are each integrally secured to the base member.

3. The device of claim 1 wherein the uppermost portions of the upwardly extending side members are integrally secured to the apex member.

35 4. The device of claim 1 wherein the first and second shoulders are integrally secured to the apex member and the uppermost portions of the first and second side members respectively.

5. The device of claim 1 wherein the first and second side members are each integrally secured to



the base member, the uppermost portions of the side members are integrally secured to the apex member and the first and second shoulders are integrally secured to the apex member and the uppermost portions of the first and second side members respectively.

6. The device of claim 1 wherein the means (e) is the apex member.

7. The device of claim 1 wherein the means (e) is a skid rail connected to and projecting upwardly from the apex member.

8. A structural member comprising:

a. a base member having first and second ends:

b. first and second side members extending upwardly from the first and second ends respectively of the base member, said upwardly extending side members converging toward one another;

c. an apex member connecting the upper most portions of the converging side members to form a substantially truncated triangular configuration, the apex member, base member, first and second side members defining a passageway therein and

d. first and second shoulders projecting outwardly from the uppermost portions of the first and second side members respectively and from the apex member.

9. The device of Claim 8 wherein the first and the second side members are each integrally secured to the base member.

10. The device of Claim 8 wherein the uppermost portions of the upwardly extending side members are integrally secured to the apex member.

11. The device of Claim 8 wherein the first and second shoulders are integrally secured to the apex member and the uppermost portions of the first and

second side members respectively.

12. The device of Claim 8 wherein the first and second side members are each integrally secured to the base member, the uppermost portions of the side members are integrally secured to the apex member and the first and second shoulders are integrally secured to the apex member and the uppermost portions of the first and second side members respectively.

13. A skid pipe for supporting a metal shape in a high temperature environment comprising:

a. a base member having first and second ends;

b. first and second side members extending upwardly from the first and second ends respectively of the base member, said upwardly extending side members converging toward one another;

c. an apex member connecting the uppermost portions of the converging side members to form a substantially truncated triangular configuration;

d. first and second shoulders projecting outwardly from the uppermost portions of the first and second side members respectively and from the apex member; and

e. a means to cool the skid pipe.

14. The device in claim 13 wherein the means (e) is a passageway through the skid pipe defined by the base member, first and second side members and the apex member, said passageway suitable for communicating a fluid therethrough.



1/2

Fig. 1
PRIOR ART

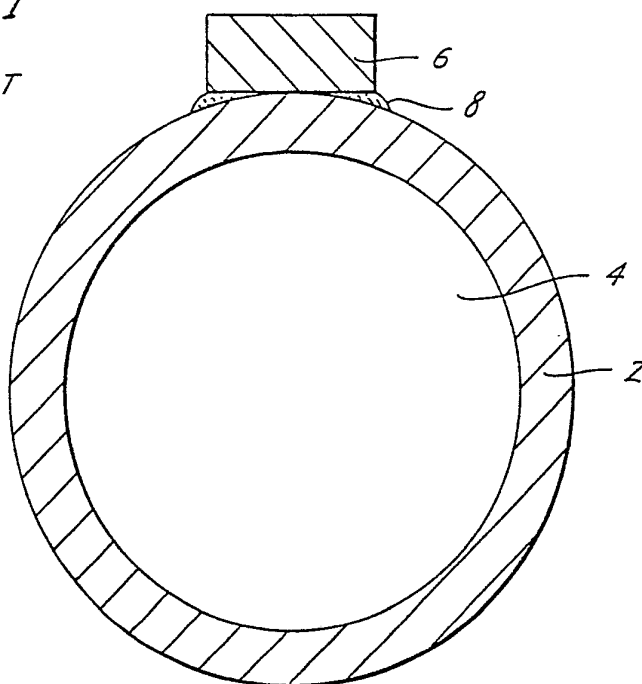
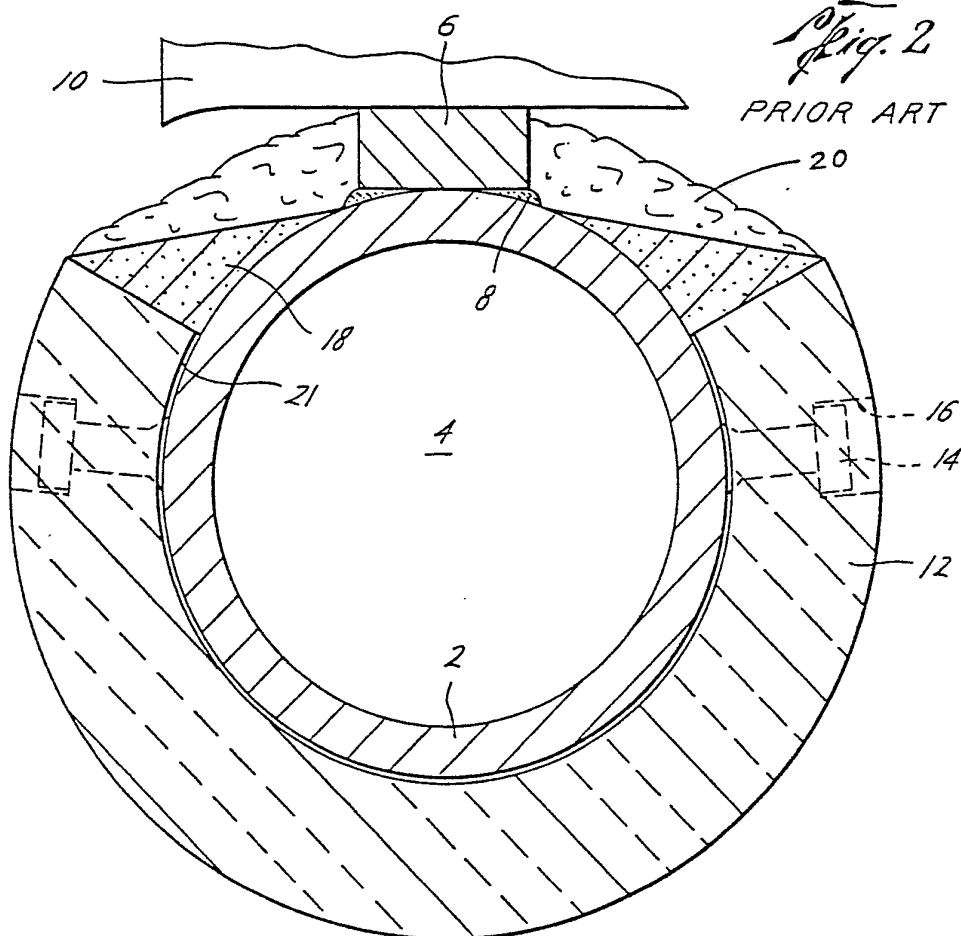


Fig. 2
PRIOR ART



2/2

Fig. 3

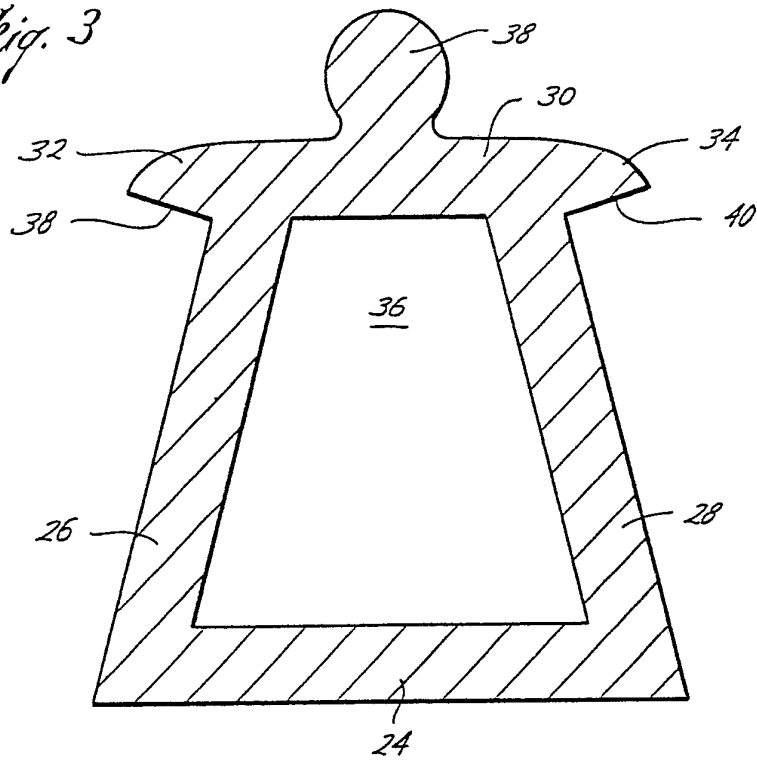
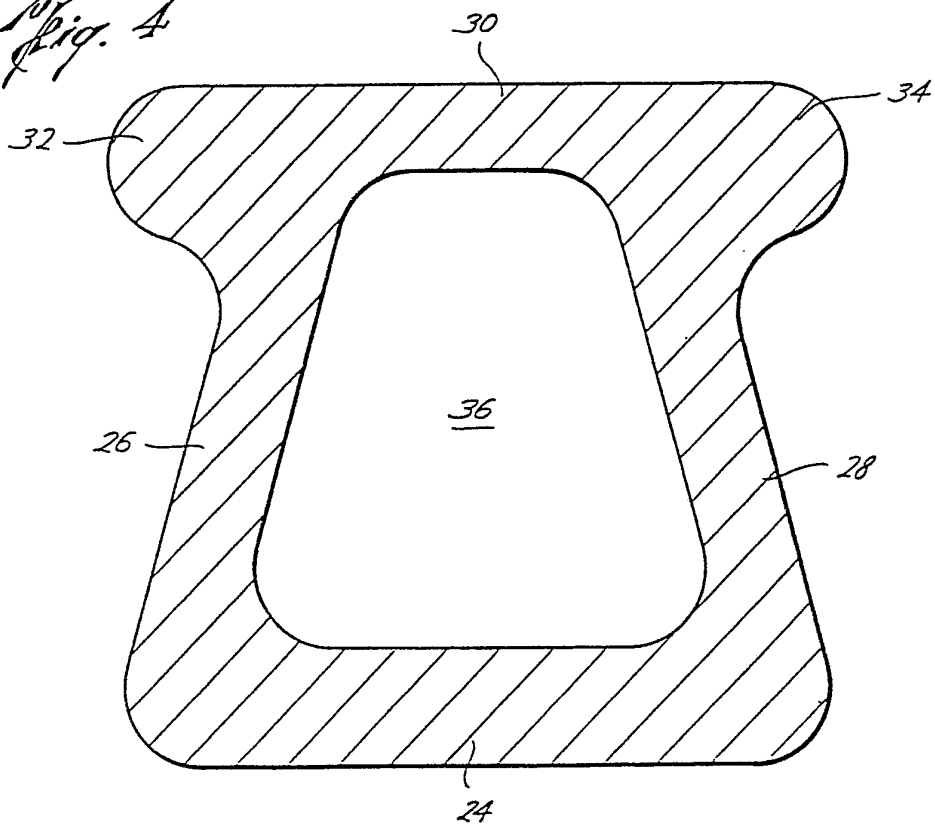


Fig. 4



INTERNATIONAL SEARCH REPORT

International Application No PCT/US80/01137

I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) ³		
According to International Patent Classification (IPC) or to both National Classification and IPC		
INTL. CL ³ F27D 3/02		
U.S. CL 432/234		
II. FIELDS SEARCHED		
Minimum Documentation Searched ⁴		
Classification System	Classification Symbols	
U.S.	432/234 138/147, Digest 11	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁵		
III. DOCUMENTS CONSIDERED TO BE RELEVANT ¹⁴		
Category ⁶	Citation of Document, ¹⁶ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No. ¹⁸
X	US,A, 4,056,350 Published 1 November 1977 KNAA K	1-6,7, 8-14
X	US,A, 3,792,386 Published 12 February 1974 SCHUSTER ET AL	1-14
X	US,A, 4,035,141 Published 12 July 1977 KNAA K	1-14
A	US,A, 3,236,507 Published 22 February 1966 MC KIE	1-14
A	US,A, 3,367,641 Published 6 February 1968 MOLZ	1-14
A	US,A, 3,642,261 Published 15 February 1972 LAWS	1-14
A	US,A, 3,706,448 Published 19 December 1972 SALTER ET AL	1-14
<p>* Special categories of cited documents: ¹⁶</p> <p>"A" document defining the general state of the art</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document cited for special reason other than those referred to in the other categories</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but on or after the priority date claimed</p> <p>"T" later document published on or after the international filing date or priority date and not in conflict with the application, but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance</p>		
IV. CERTIFICATION		
Date of the Actual Completion of the International Search ²	Date of Mailing of this International Search Report ²	
04 December 1980	12 DEC 1980	
International Searching Authority ¹	Signature of Authorized Officer ²⁰	
ISA/US	JOHN J. CAMBY	