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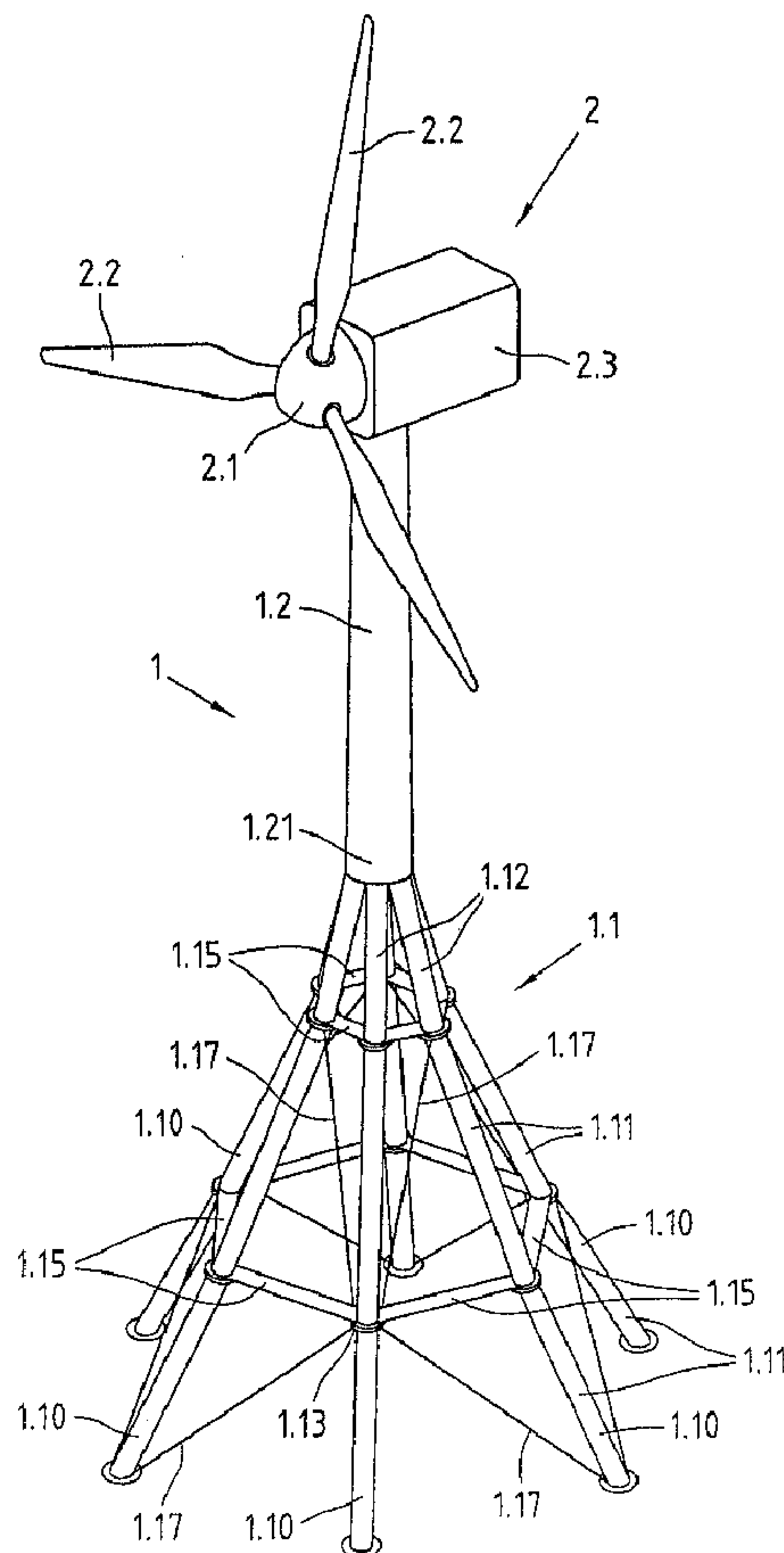
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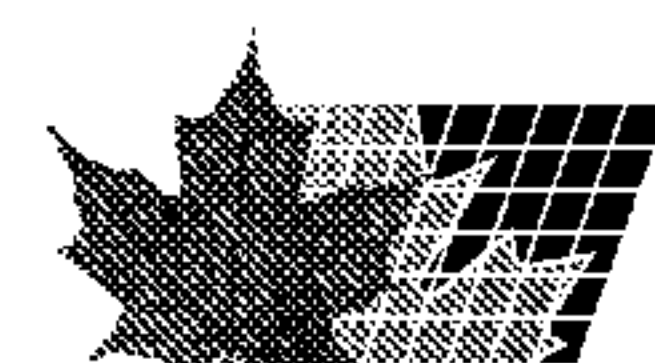
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(54) **Title: MODULAR TOWER OF A WIND POWER PLANT**



(57) **Abrégé/Abstract:**

The invention relates to a tower of a wind power plant, having a lower part in the form of a lattice tower or truss tower with at least two corner bars, and an upper part in the form of a cross-sectionally substantially round tubular tower, wherein each particular



(57) Abrégé(suite)/Abstract(continued):

corner bar is put together from a plurality of steel tube profiles that are connected together in the longitudinal direction. In order to achieve good transportability and easier assembly of the components of such a tower, the invention proposes a modular tower concept. According to the invention, each particular corner bar is in this case put together from at least three steel tube profiles which are provided with perforated flanges for holding screws, wherein the corner bars are connected together by cross struts and/or tension struts attached to the flanges, and wherein the steel tube profiles of each particular corner bar are spirally welded steel tube profiles.

A b s t r a c t

The invention relates to a tower of a wind power plant, having a lower part in the form of a lattice tower or truss tower with at least two corner bars, and an upper part in the form of a cross-sectionally substantially round tubular tower, wherein each particular corner bar is put together from a plurality of steel tube profiles that are connected together in the longitudinal direction. In order to achieve good transportability and easier assembly of the components of such a tower, the invention proposes a modular tower concept. According to the invention, each particular corner bar is in this case put together from at least three steel tube profiles which are provided with perforated flanges for holding screws, wherein the corner bars are connected together by cross struts and/or tension struts attached to the flanges, and wherein the steel tube profiles of each particular corner bar are spirally welded steel tube profiles.

Modular tower of a wind power plant

The invention relates to a tower of a wind power plant, having a lower part in the form of a lattice tower or truss tower with at least two corner bars, and an upper part in the form of a cross-sectionally substantially round tubular tower, wherein each
5 particular corner bar is put together from a plurality of steel tube profiles that are connected together in the longitudinal direction.

Developments in wind energy plants to be erected inland are leading to ever higher hub heights of above 100 m in order to utilize greater and more constant wind speeds
10 and thus to improve the efficiency of these wind energy plants. However, higher tubular towers having larger and more powerful rotors and generators require at the same time an increase in the wall thicknesses and diameters of the tower segments in order to meet the greater structural-mechanical demands that result therefrom, such as rigidity, protection against buckling and fatigue strength. However, the increase in
15 the diameters of the tower segments also results in it no longer being possible to transport the prefabricated tubular tower segments with the conventional transversely oriented construction type on many roads on account of restrictions, for example bridge clearance heights of 4.4 m.

20 A possible solution, which is proposed for example in DE 603 17 372 T2 and also in WO 2009/048955 A1, is what is referred to as the longitudinally oriented construction type, in particular in the lower tower region, in the case of which the diameters of the finished tubular tower segments are ultimately more than 4.4 m. In this case, tubular tower sections are first put together from a plurality of arcuate shell
25 segments at the construction site, i.e. at the location of the wind turbine, and the tubular (annular) tower segments produced in this way are connected to form the overall tower. In order to avoid welding at great heights, the shell segments in the tower construction known from DE 603 17 372 T2 are provided with perforated

horizontal and vertical flanges which allow the shell segments to be connected by screws. However, this solution has a number of disadvantages. For example, in the case of large shell segments, deformations are to be expected on account of the dead weight of the shell segments, it being possible for said deformations to result in
5 handling or fitting problems during assembly. On the other hand, in the event of subdivision into a large number of small shell segments, the number of screwed connections to be produced is relatively high, thereby increasing the assembly and also maintenance costs for re-tightening the screws.

10 In addition to wind power plants having a tubular tower and wind power plants having a lattice tower (truss tower), wind power plants having towers with a hybrid construction type, which have a lower lattice tower (truss tower) and an upper tubular tower connected thereto, are also known. DE 10 2006 056 274 A1 discloses a
15 tower of the type mentioned at the beginning, which has a lattice tower with at least three corner bars in its lower part and a cross-sectionally round tubular tower in its upper part, wherein the upper connection region of the lower part is connected to the lower connection region of the upper part by means of a transition body in the transition region. The transition body is in this case formed in a manner of a truncated conical casing, wherein the corner bars extend into the transition region and are at
20 least sectionally welded to the truncated conical casing in the transition region between the upper connection region of the lower part and the lower connection region of the upper part. The lattice tower has intersecting struts which connect the corner bars of the lattice tower together. The corner bars of the lattice tower are formed from standardized hollow profiles, preferably from steel tubes.

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An embodiment of the present invention provides a tower of the type mentioned at the beginning, which, while having good transportability of its components, affords cost-effective production and easier assembly of its components.

30 In order to achieve this object, embodiments of the invention provide a tower of a wind power plant or wind energy plant, having a lower part in the form of a lattice tower or truss tower with at least two corner bars, and an upper part in the form of a

cross-sectionally substantially round tubular tower, wherein each particular corner bar is put together from a plurality of steel tube profiles that are connected together in the longitudinal direction, wherein each particular corner bar is put together from at least three steel tube profiles which are provided with perforated flanges for holding
5 screws, wherein the corner bars are connected together by cross struts and/or tension struts attached to the flanges, and wherein the steel tube profiles of each particular corner bar are spirally welded steel tube profiles.

The upper part of the tower, which is embodied in the form of a cross-sectionally
10 substantially round tubular tower, preferably begins from a height of 60 m. This upper part of the tower can be realized in a conventional, transversely oriented construction type, since the diameter that meets the structural-mechanical demands should to this extent normally be beneath the limit of 4.4 m that is critical from a logistical point of view. The lower part of the tower, which is in the form of a lattice tower or truss tower
15 with at least two, preferably three corner bars, wherein each particular corner bar is put together from at least three steel tube profiles that are connected together in the longitudinal direction and are provided with perforated flanges for holding mechanically detachable connecting means, simplifies the transport and assembly of the tower. Since the forces to be absorbed are distributed to a number of corner bars,
20 the latter can be dimensioned in a considerably narrower manner than the corresponding lower part of a conventional, cross-sectionally substantially round tubular tower. The corner bars can be handled in a much easier manner from a logistical point of view. The number of individual steel tube profiles provided with flanges can in this case be varied and is dependent on the hub height and the weight of
25 the wind power plant, which consists substantially of a generator, gearing and rotor blades. For example, the lattice tower of the hybrid tower can have four, five or six corner bars. The subdivision of each particular corner bar into at least three steel tube profiles which are connected together in the longitudinal direction by mechanically detachable connecting means at the flanges considerably simplifies the transport and
30 assembly of the components of a hybrid tower for a wind power plant. The profile diameter of the steel tubes used for each particular corner bars is in this case preferably substantially identical along the overall length of the corner bar. The steel

tube profile is merely cut in a different manner depending on the attachment angle to the flanges. This identical-part strategy (identical-part construction) results in reduced unit costs. Mechanically detachable connecting means should be understood in the present context as meaning, among other things, screws, bolts and lockbolts.

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The steel tube profiles that are used for the corner bars of the tower are produced by spiral welding. In difference to the production of longitudinally welded steel tube profiles, in which each tube diameter requires a particular sheet width, spiral tube production is distinguished by the fact that steel tubes having different tube diameters can be produced from one strip width or sheet width. The use of steel tube profiles produced by spiral welding is advantageous from an economic point of view. The steel sheets used in this case are preferably hot-rolled, micro-alloyed steel sheets which have an upper yield strength (R_{eH}) of at least 355 N/mm^2 or 420 N/mm^2 . The steel tube profiles (corner bars) of the tower are particularly preferably produced from high-strength steel sheets having an upper yield strength (R_{eH}) of for example at least 500 N/mm^2 or 700 N/mm^2 . As a result, the weight of the steel tube profiles (corner bars) can be reduced, with the result that the transport and assembly are further simplified.

20 The wall thicknesses and diameters of the steel tube profiles are dependent in particular on the tower height and the number of corner bars. The steel tube profiles that are used for the corner bars of the tower have for example a wall thickness in the range from 15 mm to 30 mm and an outside tube diameter in the range from 500 mm to 1800 mm, preferably in the range between 500 mm and 1200 mm.

25

In order to reliably absorb transverse forces that arise in the lower part of the tower, the individual corner bars are connected together by cross struts and/or tension struts attached to the flanges. The flanges of the steel tube profiles thus have a multiple attachment function; they serve to longitudinally attach the steel tube profiles forming each particular corner bar and additionally serve to transversely attach and/or diagonally attach the corner bars together, wherein each of these

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attachment means is executed preferably by means of screw connection. On account of this multiple attachment function, the flanges of the wind energy plant tower can also be referred to as multi-attachment flanges.

5 The cross struts are preferably formed from substantially horizontally extending steel profiles. These can be, for example, bend pieces or rolled profiles, in particular angled struts or struts in the form of a U-profile. In addition, these cross struts are preferably formed in an identical manner in as much as they all have the same cross-sectional profile and the same cross-sectional dimensions. However, the cross struts are cut to
10 different lengths, namely dimensioned in a shorter manner, with increasing tower height.

By way of tension struts attached to the flanges, the stability of the overall tower according to the invention can likewise be ensured or further increased. The
15 transverse struts can in this case be embodied as steel cables, preferably pretensioned steel cables, or as bend pieces or rolled profiles. When steel cables are used as tension struts, these can be easily transported to the installation site of the tower in the reeled state. Furthermore, tolerance problems can be ruled out with regard to the steel cables, since the steel cables can be cut to length as required at the location of the
20 tower. In an advantageous configuration of the tower according to embodiments of the invention, one or more of the diagonal struts, for example steel cables, are each provided with a tensioning device for length adaptation.

In a further preferred configuration of embodiments of the invention, the connecting
25 points or ends of the steel tube profiles are provided with flaps which have through-holes or through-bores for attaching cross struts and/or diagonal struts.

The flaps can be separately manufactured parts which are each welded to a flange at the end of the steel tube profile. Alternatively, however, the flap can also be formed in
30 one piece with the flange. In the second case, the flap is produced, for example, by being formed from the steel-sheet blank that defines the flange. In both cases, the flap

and the flange can be welded to the steel tube profile, wherein the flap is then oriented substantially perpendicularly to the flange.

In the case of the preferred use of bend pieces or rolled profiles as tension struts, it is possible to connect the tension struts together at their crossing point in order to

5 further increase the stability of the overall tower. The tension struts are in this case connected at the crossing point for example by screws or other detachable mechanical connecting means. This connection can advantageously already be carried out during the prefabrication of the tower components.

10 Further preferred and advantageous configurations of the wind power plant tower according to embodiments of the invention are described herein.

The invention is explained in more detail in the following text by way of a drawing that illustrates a number of exemplary embodiments and in which, schematically:

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Fig. 1 shows a perspective illustration of a wind power plant tower according to the invention;

Fig. 2 shows an enlarged illustration of the lower part of the tower from Fig. 1;

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Fig. 3 shows a perspective illustration of a lower section of the lattice tower or truss tower of a wind power plant tower according to a further exemplary embodiment;

25 Fig. 4 shows an enlarged illustration of the detail A of the lattice tower or truss tower from Fig. 3;

Fig. 5 shows an enlarged illustration of the detail B of the lattice tower or truss tower from Fig. 3; and

30

Fig. 6 shows a front view of a section of the lattice tower or truss tower from Fig. 3 in the region of the connection of the steel tube profiles of two corner bars.

- 5 The tower 1, illustrated in the drawing, of a wind power plant 2 is constructed from a lower part 1.1 in the form of a lattice tower or truss tower and an upper part 1.2 in the form of a cross-sectionally round tubular tower.

Mounted on the upper end of the tubular tower 1.2 is a wind power plant (wind
10 energy plant) 2 which is mounted so as to be rotatable about a substantially vertically extending axis. The wind power plant 2 comprises a rotor 2.1 having rotor blades 2.2 which are preferably rotatable about their respective longitudinal axis and are thus adjustable in an infinitely variable manner, and a generator arranged in the nacelle housing 2.3, the shaft of said generator being connected to the rotor 2.1 for conjoint
15 rotation via a transmission and a clutch.

In the exemplary embodiment shown here, the lattice tower or truss tower 1.1 has six corner bars 1.10. However, it can also have more or fewer than six corner bars. In any case, it has at least three corner bars 1.10, their horizontal distance increases from the
20 upper tubular tower 1.2 in the direction of the ground or foundation. The preferably substantially rectilinear corner bars 1.10 thus form a three- or more-legged tower structure, the legs of which are spread at an acute angle with respect to one another.

Each of the corner bars 1.10 is put together from at least three steel tube profiles 1.11,
25 1.12 which are connected together in the longitudinal direction and to this end are provided at their connecting points with perforated flanges 1.13 for holding for example screws (not shown). The flanges 1.13 are configured for example as annular flanges. Each particular flange or annular flange 1.13 has a plurality of through-holes 1.14 which are arranged in a regularly spaced apart manner on a common reference
30 circle (cf. Fig. 2).

Preferably, the steel tube profiles 1.11, 1.12 that are used for the corner bars 1.10 are identical parts which are spirally welded. The arcuate steel sheets or steel sheets formed in a round shape which are used for the production thereof are for example hot-rolled steel sheets having a yield strength of at least 350 N/mm^2 . However,
5 higher-strength steel sheets can also be used to produce the steel tube profiles of the corner bars 1.10, for example steel sheets having a yield strength in the range from 500 to 700 N/mm^2 .

The steel tube profiles 1.11, 1.12 of each particular corner bar 1.10 preferably have a
10 wall thickness in the range from 15 mm to 30 mm. Their diameter is for example in the range from 500 mm to 1800 mm. Preferably, the steel tube profiles 1.11, 1.12 that are used for the corner bars 1.10 are produced from standard tubes.

Each particular annular flange 1.13 is preferably attached cohesively to one of the
15 ends of the steel tube profile 1.11, 1.12 used to construct a corner bar 1.10, for example by means of fillet welding. However, a force-fitting and/or form-fitting connection between the annular flange 1.13 and the associated steel tube end for example by way of a screw connection, in the case of which the steel tube end is provided with an external thread and the annular flange with a corresponding
20 internal thread, is also possible.

Each particular annular flange 1.13 is arranged in a horizontal plane. To this end, the ends, provided with the annular flanges 1.13, of the steel tube profiles 1.11, 1.12 are cut obliquely such that each particular cut end of the steel tube profile 1.11, 1.12 ends
25 in a substantially horizontal manner in the fully assembled state of the lattice tower or truss tower 1.1.

The corner bars 1.10 are connected together by cross struts 1.15. To this end, use is made of the same annular flanges 1.13 which connect the steel tubes 1.11, 1.12,
30 preferably standard tubes, together.

The cross struts 1.15 are formed from steel profiles and extend substantially horizontally. Those cross struts 1.15 which are arranged at the same height are embodied as identical parts. The length of the cross struts 1.15 depends in this case on their attachment height. With increasing tower height, the length of the cross struts
5 1.15 attached to the annular flanges 1.13 decreases.

The tower 1 according to embodiments of the invention, at least the lower lattice tower part 1.1 thereof, thus has a modular structure, using standardized steel profiles 1.11, 1.12, 1.15.
10

The cross struts 1.15 are embodied for example as U-profiles (cf. Fig. 2). However, they can also have some other profile shape, for example an L-profile or T-profile.

The ends of each particular cross strut 1.15 preferably have end sides 1.16 that are
15 formed in a concave or dovetail manner or are polygonally indented. As a result, the bearing surface or contact surface between the cross strut 1.15 and annular flange 1.13 can be enlarged (cf. Fig. 2).

In order to ensure or further increase the required stability of the overall tower 1,
20 provision can be made of additional tension struts 1.17 which are fastened in each case in the flange region such that they extend diagonally in the truss which is defined by two adjacent corner bars 1.10 and two cross struts 1.15 extending substantially parallel to one another.

25 The tension struts 1.17 are formed for example from wire cables. The ends of the wire cables 1.17 are fastened to the through-openings 1.14 in the annular flanges 1.13 via suitable fastening means. For the length adaptation thereof, the tension struts or wire cables 1.17 can each be provided with a tensioning device (not shown). The tension struts or wire cables 1.17 and the bolts are not illustrated in Fig. 2 for the sake of
30 clarity.

The upper tower part 1.2, which is configured as a cross-sectionally round tubular tower, starts from a height of for example about 60 m. It can be embodied in a conventional, transversely oriented construction type and accordingly be put together from a plurality of annular tube segments.

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The tubular tower 1.2 of the tower 1 is preferably embodied as a conical steel tube tower. Alternatively, however, it can also be embodied as a cylindrical steel tube tower.

10 At its end facing the truss tower or lattice tower 1.1, the tubular tower 1.2 has a conical or truncated conical-casing-shaped longitudinal section. The upper ends of the corner bars 1.10 are attached to this lower section 1.21 of the tubular tower 1.2. The upper steel tubes 1.12 of the corner bars 1.10 can in this case extend into the truncated conical-casing-shaped or conical longitudinal section 1.21 of the tubular
15 tower 1.2 and are then connected to the inner side of the tubular tower 1.2, for example welded thereto. However, at its lower end, the tubular tower 1.2 can also have a circular-disc-shaped or annular-disc-shaped connecting plate (not shown) having a plurality of fastening holes at which the upper steel tubes 1.12 of the corner bars 1.10 are attached or screwed via annular flanges fastened thereto.

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The height of the overall tower 1 put together from the lattice tower 1.1 and the tubular tower 1.2, or the hub height of the rotor 2.1 is for example about 110 m.

Fig. 3 illustrates a further exemplary embodiment of the lower part 1.1, configured as
25 a lattice tower or truss tower, of a wind power plant tower. The upper part of the tower, which, in a similar manner to in Fig. 1, is formed from a cross-sectionally substantially round tubular tower, is not shown in Fig. 3.

In this exemplary embodiment, the lattice tower or truss tower 1.1 has at least two
30 corner bars 1.10 which are each put together from at least three steel tube profiles 1.11, 1.12 that are connected together in the longitudinal direction. To this end, the steel tube profiles 1.11, 1.12 are provided at their connecting points with perforated

flanges 1.13 for holding detachable mechanical connecting means, for example screws. Each of the flanges 1.13 according to Fig. 4 has a plurality of through-holes 1.14 for holding the connecting means.

5 Furthermore, flaps 1.18 are provided at the connecting points or ends of the steel tube profiles 1.11, 1.12. The flap 1.18 and the flange 1.13 are welded to the steel tube profile 1.11 and 1.12, wherein the flap 1.18 is oriented substantially perpendicularly to the flange 1.13.

10 If the flap 1.18 is manufactured as a separate part, it is preferably also welded to the flange 1.13 (cf. Fig. 4). However, it is also within the scope of the invention to form the flap 1.18 and the flange 1.13 together in one piece. In this case, the flap 1.18 would be produced for example by being formed from the steel-sheet blank that defines the flange 1.13.

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Each particular flap 1.18 likewise has a plurality of through-holes 1.19 for holding detachable mechanical connecting means. The flaps 1.18 serve for attaching tension struts 1.17. Furthermore, cross struts 1.15 can also be attached to the flaps 1.18.

Alternatively or in addition, the cross struts 1.15 can also be attached to the flanges
20 1.13, however.

The exemplary embodiment according to Figures 3 and 4 affords the possibility of cutting the ends of the steel tube profiles 1.11, 1.12 to length substantially perpendicularly (at right angles) to the longitudinal axis, i.e. chamfering of the tube
25 ends – as illustrated in Fig. 2 – is not provided here. The attachment of the cross struts 1.15 to the steel tube profiles 1.11, 1.12 is then possible, in spite of their substantially right-angled cut ends or the substantially perpendicular orientation of the flanges 1.13 with respect to the steel tube profile longitudinal axis, without bending the ends of the cross struts 1.15, since the latter are in this case attached to the flaps 1.18. The flaps
30 1.18 thus make it possible to compensate the attachment angle between the cross strut 1.15 and the steel tube profile longitudinal axis at any desired inclination angles of the steel tube profile longitudinal axis (corner bar longitudinal axis).

The tension struts 1.17, which are embodied as bend pieces or rolled profiles in the exemplary embodiment according to Figures 3 to 6, are preferably connected together in their intersecting region 1.20. In order to connect or fix the tension struts 1.17 in
5 the intersecting region 1.20, mechanical detachable connecting means, for example screws are again used. The connection or pre-fixing of the tension struts 1.17 in the intersecting region 1.20 can already take place during prefabrication of the tension struts 1.17, with the result that the assembly of the lattice tower or truss tower 1.1 at the installation site of the tower is simplified or shortened.

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The embodiment of the tower according to the invention is not limited to the exemplary embodiments illustrated in the drawing. Rather, numerous variants are conceivable which, even in the case of a configuration that deviates from the exemplary embodiment shown, make use of the invention specified in the
15 accompanying claims. Thus, for example instead of steel cables 1.17, it is also possible for steel profile bars, for example L-profile-shaped bend pieces, to be attached as tension struts to the flanges 1.13 of the corner bar tubes 1.11, 1.12.

C l a i m s

1. A tower of a wind power plant, having a lower part in the form of a lattice tower or truss tower with at least two corner bars, and an upper part in the form of a cross-sectionally substantially round tubular tower, wherein each corner bar is put together from a plurality of steel tube profiles that are connected together in the longitudinal direction, wherein each corner bar is put together from at least three steel tube profiles which are provided with perforated flanges for holding screws, wherein the corner bars are connected together by cross struts and/or tension struts attached to the flanges, and wherein the steel tube profiles of each corner bar are spirally welded steel tube profiles.
2. The tower according to Claim 1, wherein each flange is in the form of an annular flange and is arranged substantially in a horizontal plane.
3. The tower according to Claim 2, wherein ends, provided with the annular flanges, of the steel tube profiles are cut obliquely such that each cut end of the steel tube profile ends in a substantially horizontal manner in a fully assembled state of the lattice tower or truss tower.
4. The tower according to any one of Claims 1 to 3, wherein each flange is cohesively connected to the steel tube profile.
5. The tower according to any one of Claims 1 to 4, wherein the steel tube profiles that form a height section of the lattice tower or truss tower are embodied as identical parts.
6. The tower according to any one of Claims 1 to 5, wherein the cross struts are formed from substantially horizontally extending steel profiles.

7. The tower according to Claim 6, wherein the substantially horizontally extending steel profiles are embodied as identical parts.
- 5 8. The tower according to any one of Claims 1 to 7, wherein ends of each cross strut have end sides that are formed in a concave or dovetail manner or are polygonally indented.
9. The tower according to any one of Claims 1 to 8, wherein the tension struts are formed from diagonally extending wire cables.
- 10 10. The tower according to any one of Claims 1 to 9, wherein one or more of the tension struts are provided in each case with a tensioning device for adapting the length of the tension strut.
- 15 11. The tower according to any one of Claims 1 to 10, wherein the steel tube profiles of each corner bar have a tube wall thickness in a range from 15 mm to 30 mm.
12. The tower according to any one of Claims 1 to 11, wherein the steel tube profiles of each corner bar have a diameter in a range from 500 mm to 1800 mm.
- 20 13. The tower according to any one of Claims 1 to 12, wherein the tubular tower is embodied as a conical or cylindrical steel tube tower.
- 25 14. The tower according to any one of Claims 1 to 13, wherein the tubular tower has a conical or truncated conical-casing-shaped longitudinal section at its end facing the lattice tower or truss tower.

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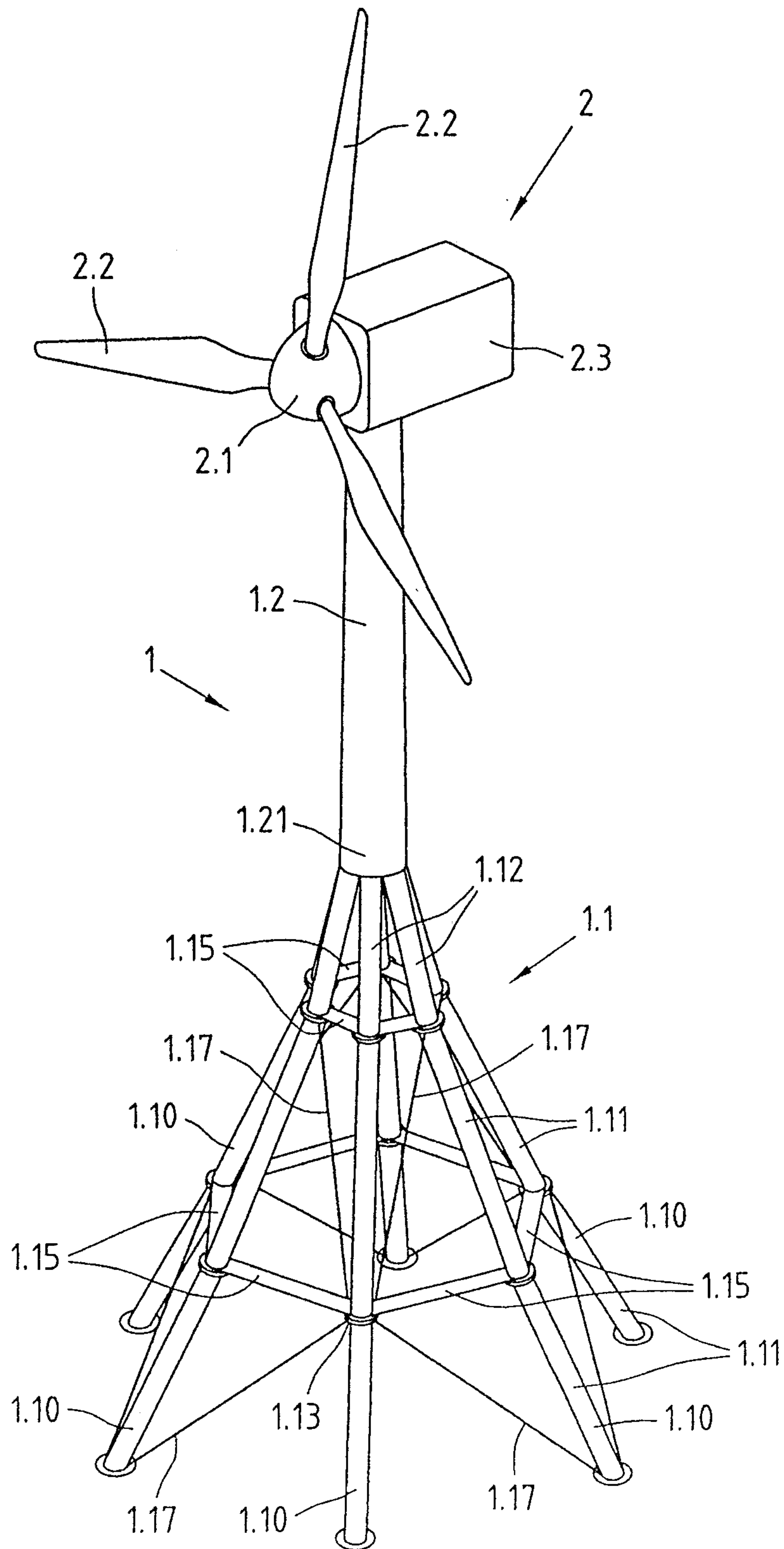


Fig.1

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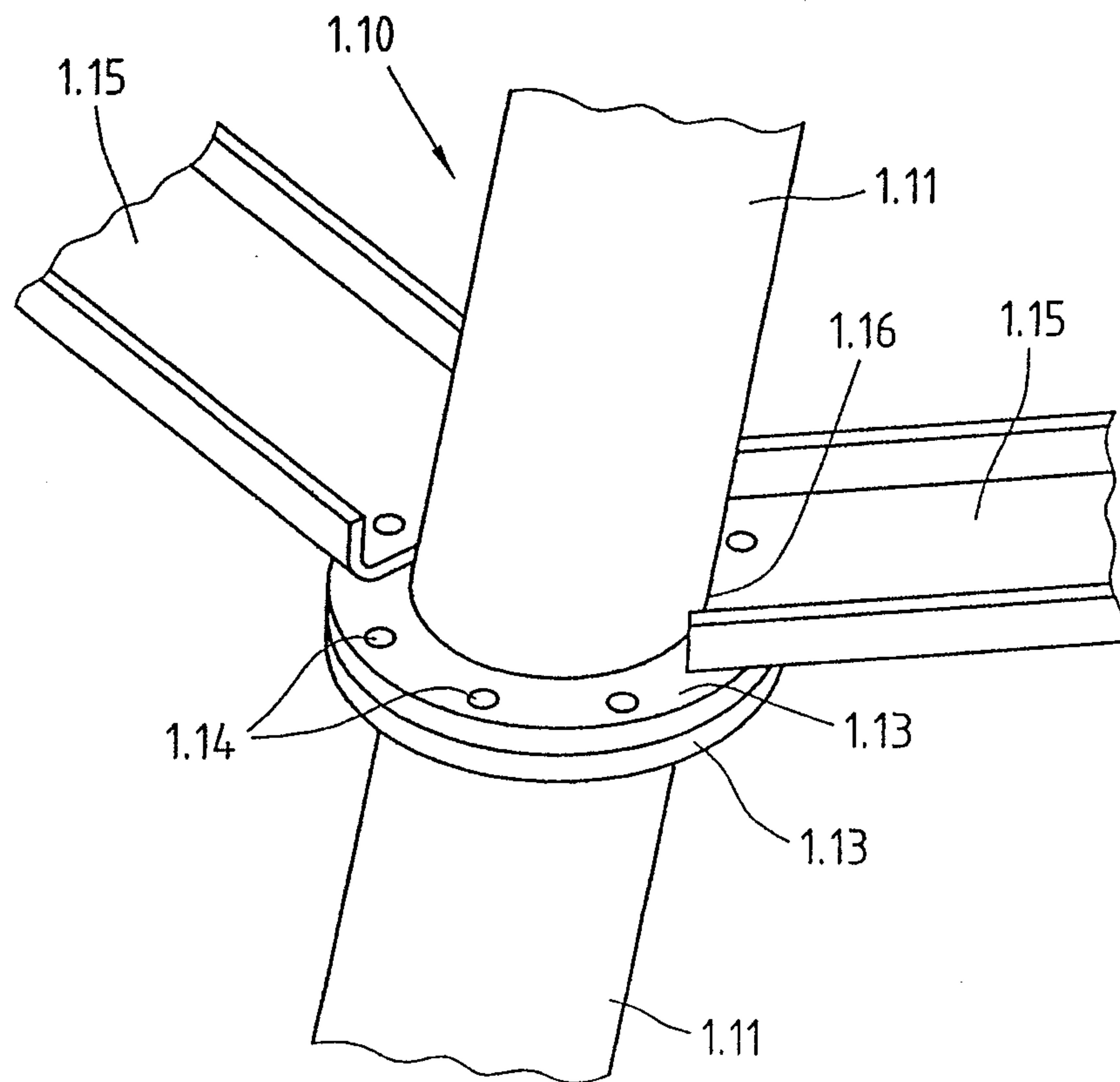


Fig.2

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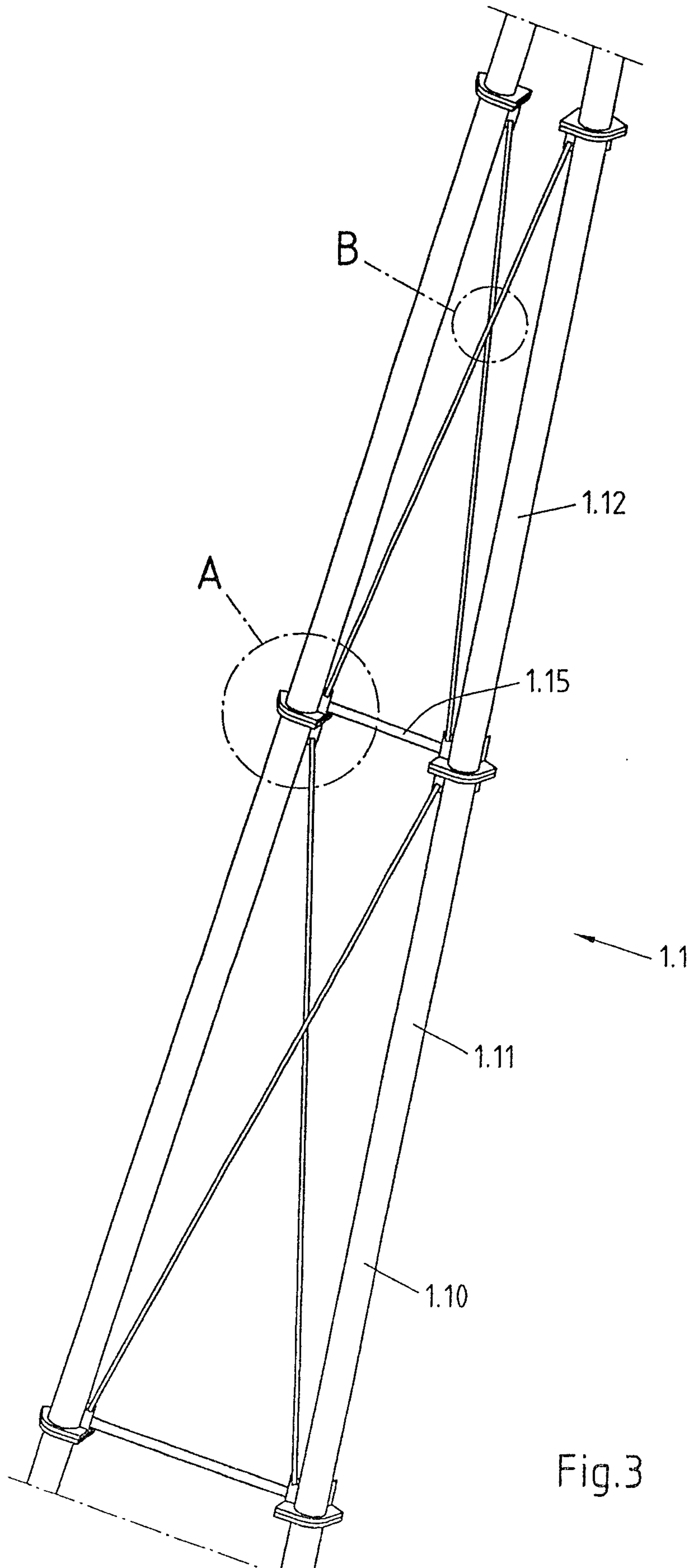


Fig.3

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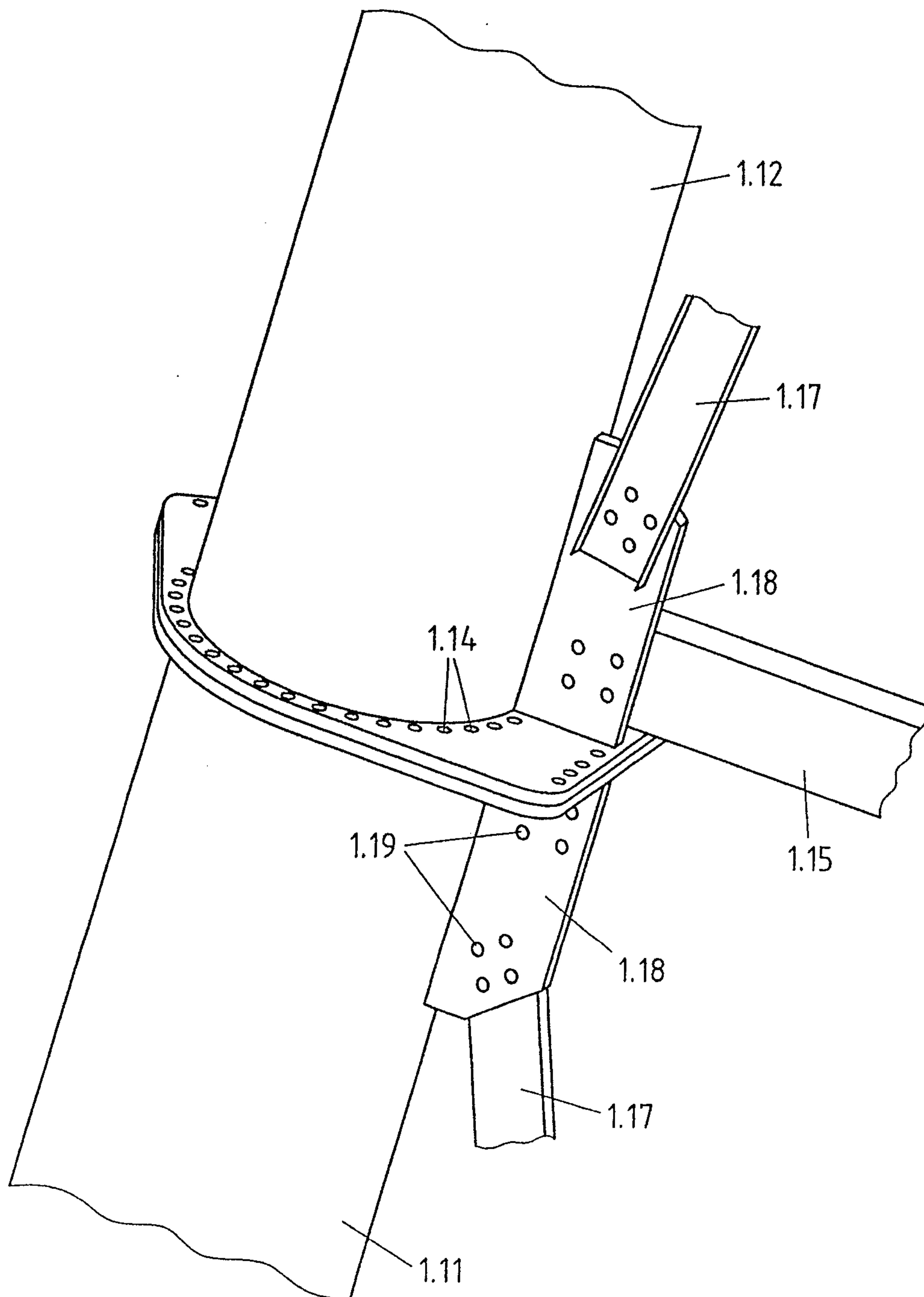


Fig. 4

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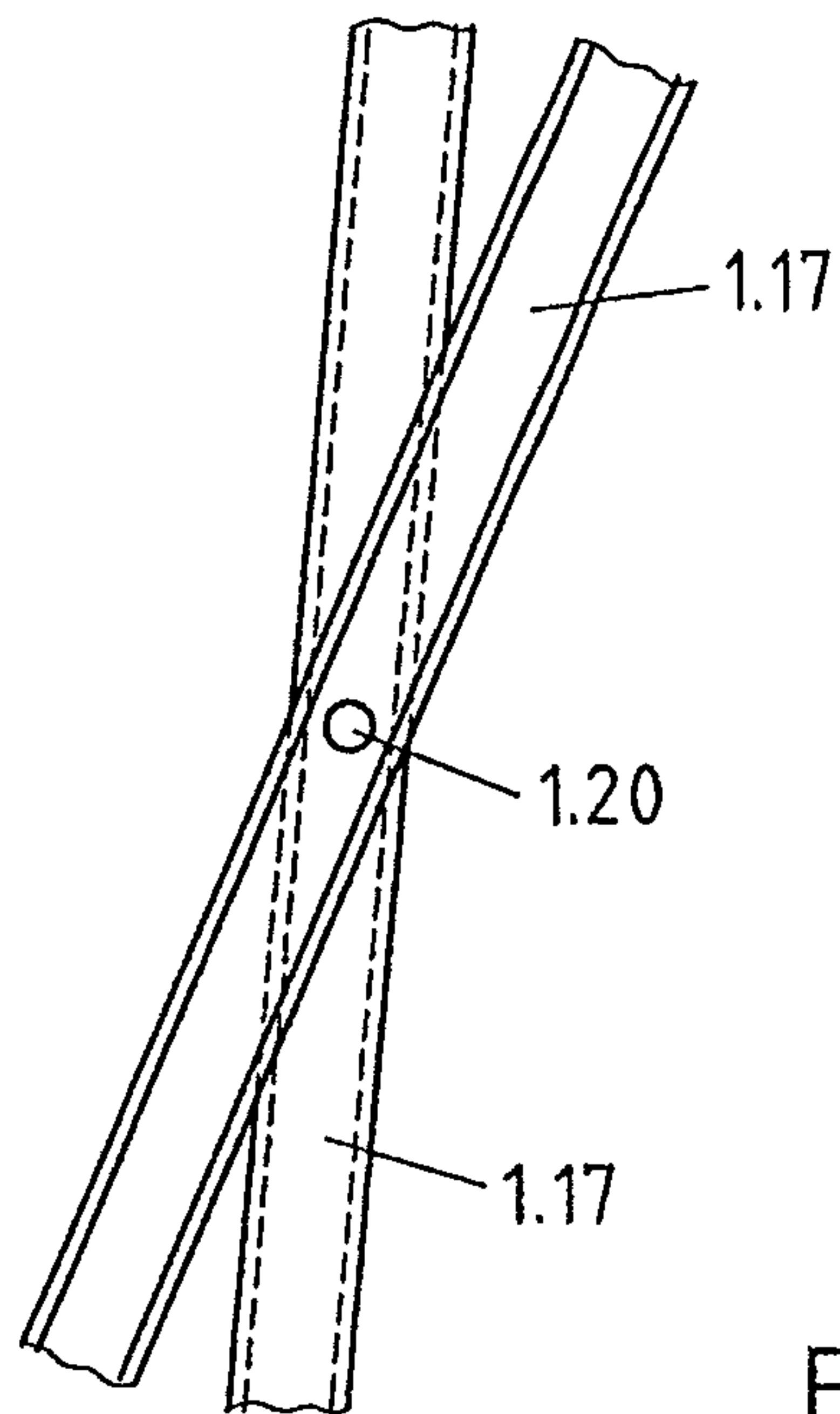


Fig.5

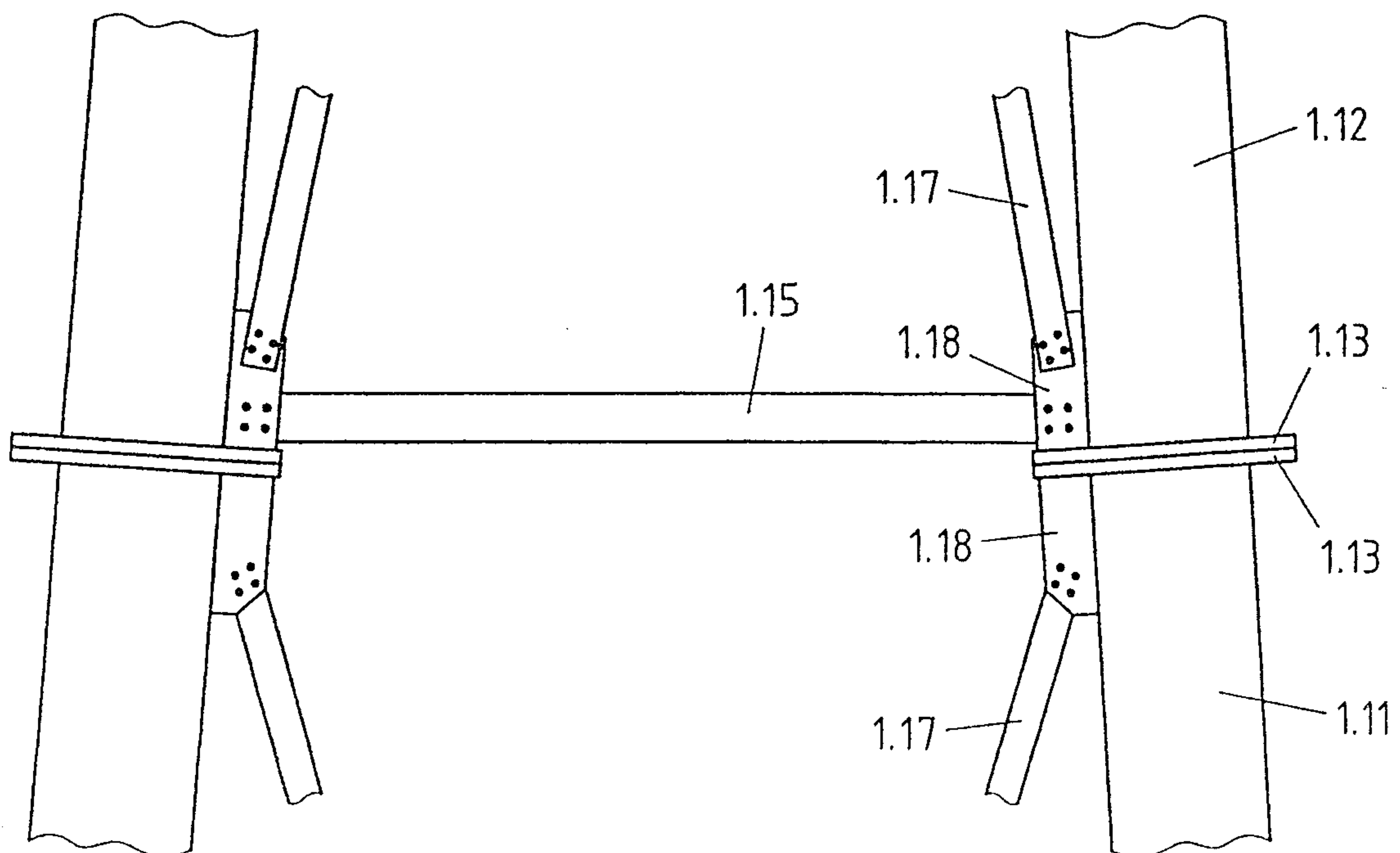


Fig.6

