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(54) PROCESS FOR MAKING A STRIP FROM A HOT ROLLED ROD

VERFAHREN ZUM HERSTELLEN EINES BANDES AUS EINEM WARMGEWALZTEN STAAB

PROCEDE DE PRODUCTION D'UNE BANDE DE METAL A PARTIR D'UNE BARRE LAMINEE A
CHAUD

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FR-A- 2 196 207 **US-A- 2 226 948**
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(MITSUBISHI JUKOGYO) 18 October 1982

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Description

1. Field of the Invention

[0001] The present invention relates to a process for producing a rectangular strip from a hot rolled, round rod by passing the rod consecutively through a series of rolling mills. More specifically, the invention relates to a process which employs inter-cooling between consecutive rolling mills as well as strip tension control to produce a strip which exceeds currently achievable maximum width to thickness ratios.

2. Description of the Related Art

[0002] Pinned tubes are employed in many commercial applications as a means to allow heat exchange to occur between mediums of different temperatures without necessitating commingling of the mediums. One common design for finned tubes employs a fin constructed of a continuous strip of metal fin material. In cross section, this strip is rectangular in dimension, having a width exceeding its thickness. To form the finned tube, the strip is helically wound around the exterior surface of a hollow tube and secured thereto so that one of the shorter sides of the cross-sectional rectangular shaped strip is secured adjacent to the tube's exterior surface and the width of the strip extends outward away from and perpendicular to the tube's exterior surface.

[0003] For optimum performance of the finned tube, it is desirable to employ strips having a width to thickness ratio (calculated by dividing the width by the thickness) of approximately 17 to 1. For example, one common strip size has a width of 2.032 centimeters (0.80 inches) and a thickness of 0.1938 centimeters (0.047 inches) resulting in a width to thickness ratio of approximately 17.2 to 1.

[0004] The current method for producing strips of the desired dimensions is to begin with a sheet of continuous cold rolled metal, often carbon steel, of the desired thickness. The sheet is then slit into strips of the desired width. This is briefly described in an article entitled "The Rolling of Round Wire into Flats/Rectangles" published in the October, 1959 issue of FENN Engineering News, a publication by Fenn Manufacturing Co., Newington, Connecticut, U.S.A. During manufacture of the cold rolled sheets, the sheets are uniformly rolled to close tolerances. The price of these sheets reflects the time and effort required to roll them to close tolerances. When the cost of sitting the sheets is added to the cost of the sheets, the total cost to produce strips according to current methods is quite expensive.

[0005] The cost for producing strips could be reduced considerably if the strips could be made from less expensive hot rolled rod instead of from the cold rolled sheets. Current methods for converting a hot rolled rod into a strip generally consists of passing a rod consecutively through a series of rolling mills. This is described

in an article entitled "Wire-Flattening-Theory and Practice" produced by Stanat Precision Machine Company of Schiller Park, Illinois, U.S.A. Each rolling mill further flattens and widens the rod until the desired strip dimension is achieved. However, certain dimensional limitations are encountered when employing currently known methods for converting rods into strips.

[0006] Specifically, current methods for converting a rod into a strip are limited to creation of strips with width to thickness ratios of less than approximately 12 to 1. When current methods are employed to create strips having width to thickness ratios exceeding approximately 12 to 1, for example having ratios of 15 to 1 or 17 to 1, during the rolling process the metal strip develops severe edge fractures. These fractures cause the strip to break. The cause these fractures appear to be two-fold. First, as the metal rod is passed through each consecutive rolling mill, heat is added to the metal until the metal finally reaches a temperature at which it fails, causing it to fracture or break. Second, in addition to the heat stress exerted on the metal, mechanical stress is inflicted on the metal by the tug on the rod from the subsequent rolling mill as it pulls the rod toward the mill. Exerting a significant pulling or tugging force on a rod is the basis upon which rolling of rod has been accomplished in the past, for example, as described in United States Patent No. 2,226,948. This mechanical stress seems to contribute to the metal failure which is observed. Regardless of the cause of the failures, until now the practical upper limit for rolling rod into strips has been the 12 to 1 width to thickness ratio. Because strips having higher width to thickness ratios than 12 to 1 are necessary for construction of finned tubes, production of strips for this use from hot rolled rod has not until now been a viable option.

[0007] The present invention addresses this problem of limited width to thickness ratio by providing a method for producing strips from rods which utilizes cooling and tension controls between adjacent rolling mills in order to minimize tension on the material being rolled so that it is possible to produce strips having width to thickness ratios of up to approximately 17 to 1.

[0008] The present invention is a cold rolling processes, and as such, should be distinguished from hot rolling processes such as those described in EP-A O 314 667.

SUMMARY OF THE INVENTION

[0009] The present invention is a process for creating strips from hot rolled metal rods such that the strip which is produced achieves a width to thickness ratio of approximately 17 to 1. The process consists of cooling the rod after it passes through each consecutive rolling mill to reduce the thermal stress on the rod and employs tension controllers following each consecutive rolling mill in order to control the previous rolling mill and thereby reduce the mechanical stress on the rod. Cool-

ing is preferably accomplished by immersing the rod in a liquid cooling bath and/or by spraying cooling fluid directly on the rod.

BRIEF DESCRIPTION OF THE DRAWINGS

[0010]

Figure 1 is a diagrammatic representation showing the process of the present invention, starting on the left-hand side with a spool of hot rolled rod and ending on the right-hand side with a strip which is rewound into a spool and ready for use or for further processing.

Figure 2 is a cross-sectional view of the rod taken along line 2-2 of Figure 1.

Figure 3 is a cross-sectional view of the partially flattened rod, taken along line 3-3 of Figure 1.

Figure 4 is a cross-sectional view of the further flattened rod, taken along line 4-4 of Figure 1.

Figure 5 is a cross-sectional view of the still further flattened rod, taken along line 5-5 of Figure 1.

Figure 6 is a cross-sectional view of the strip which was created by flattening the rod, taken along line 6-6 of Figure 1.

Figure 7 is an enlarged view of one of the liquid cooling baths and tension controllers depicted in Figure 1.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

[0011] Referring now to the drawings and initially to Figure 1, there is diagrammatically illustrated a process according to a preferred embodiment of the present invention for converting a rod 10, such as a hot rolled rod of carbon steel, into a strip 12 suitable for use as a fin for a finned tube (not illustrated) or for other commercial applications. Beginning on the left-hand side of Figure 1 and moving toward the right-hand side, there is illustrated a spool 14 of rolled up rod 10 which is next unwound through an eye 16. The purpose of the eye 16 is to prevent the rod 10 from becoming tangled or kinked as it unwinds from the spool 14. Next, the rod 10 enters a descaler 18 which removes any scale or oxidation product present on the surface of the rod 10. After being descaled, the rod 10 enters a straightener 20 which straightens the rod 10 in preparation for entering a rolling train portion 22 of the process. The rolling train portion 22 consists of a plurality of rolling mills 24, 26, 28, 30, etc. arranged in series, with each individual rolling mill 24, 26, 28, or 30, being followed by its respective li-

uid cooling bath 34, 36, 38 or 40. This arrangement is best illustrated in Figure 1 where the first rolling mill 24 is followed consecutively by the first liquid cooling bath 34, the second rolling mill 26, the second liquid cooling bath 36, the third rolling mill 28, the third liquid cooling bath 38, etc. until the rolling train portion 22 ends with the final rolling mill 30 followed by the final liquid cooling bath 40. As indicated by employment of spool 14, descaler 18 and cooling baths 34, 36 and 38, the present invention is limited to use as a cold rolling process.

[0012] As illustrated in Figures 2 through 6, as the rod 10 progresses through the rolling train portion 22, it is progressively flattened and widened, resulting in conversion of the rod 10 to the strip 12 as it exits the rolling train portion 22. The strip 12 has a width 42 and a thickness 44 measured perpendicular to its width 42. Referring now to Figure 7, there is shown in enlarged detail a preferred arrangement of the first liquid cooling bath 34. Although the first liquid cooling bath 34 is illustrated and discussed, the remaining liquid cooling baths 36, 38, 40, etc. are similarly arranged. The first liquid cooling bath 34 is filled with a cooling fluid 46, such as water, which enters the first liquid cooling bath 34 via an inlet 48 and exits the first liquid cooling bath 34 via an outlet 50 as will be further explained hereafter.

[0013] As illustrated in Figure 7, the rod 10 exits from the first rolling mill 24 upstream of the first liquid cooling bath 34. The rod 10 then enters the first liquid cooling bath 34 where the rod 10 is cooled by direct contact with the cooling fluid 46. The rod 10 is immersed in the cooling fluid as the rod 10 passes under a roller 52 provided on a tension controller 54 before reemerging from the first liquid cooling bath 34 in order to travel through the second rolling mill 26.

[0014] Although the process is described with cooling of the rod 10 being provided between each adjacent rolling mill 24, 26, 28, and 30, it is anticipated that adequate cooling of the rod 10 may be accomplished with fewer cooling baths 34, 36, 38, and 40, fewer cooling nozzles 58, or fewer other alternate cooling means (not illustrated).

[0015] The roller 52 is in rolling contact with the rod 10 which passes under the roller 52 as the rod 10 travels through the first liquid cooling bath 34. The roller 52 responds to increases in tension in the rod 10 by moving upwardly and responds to decreases in tension in the rod 10 by moving downwardly. This upward and downward movement is illustrated by the arrows shown in Figure 7. This upward and downward movement is translated into an electronic signal which controls the drive speed of the preceding first rolling mill 24, as is illustrated in Figure 7 schematically by a broken line 56 which connects the tension controller 54 and the first rolling mill 24. By controlling the speed of the preceding first rolling mill 24, mechanical stress is decreased on the rod 10 as the rod 10 exits the first rolling mill 24.

[0016] In order to maintain the cooling fluid 46 contained within the first liquid cooling bath 34 at an accept-

able temperature, i.e., at a temperature below the boiling point of the cooling fluid 46, warm cooling fluid 46-W is continuously removed via the outlet 50, cooled by passing it through a conventional heat exchange process 57, and then recirculating cool cooling fluid 46-C back to the first liquid cooling bath 34 via the inlet 48.

[0017] As illustrated in Figures 1 and 7, cooling nozzles 58 are optionally provided at each of the rolling mills 24, 26, 28, and 30. The purpose for these cooling nozzles 58 is to provide additional cooling in the form of cooling fluid 46 which is supplied from a cooling fluid source 60. The cooling fluid 46 enters the cooling nozzles 58 from the cooling fluid source 60 and is emitted from the cooling nozzles 58, impinging directly on the heated rod 10 as the rod 10 passes through each of the rolling mills 24, 26, 28, and 30.

[0018] Alternately, the cooling nozzles 58 may be used solely to provide the necessary cooling of the rod 10, thereby eliminating the need for cooling baths 34-40. Although the cooling nozzles 58 and the cooling baths 34-40 have been described for use with cooling fluid 46, other coolants, not illustrated, such as liquids or gases may be substituted for the cooling fluid, and other alternate cooling means, not illustrated, may be employed instead of either cooling nozzles 58 or cooling baths 34-40.

[0019] Once the strip 12 is produced, the strip 12 is rewound into a spool 62, as illustrated in Figure 1. The spool 62 of strip 12 is then ready for use or for further processing.

Examples of results achieved:

[0020] The following data illustrates the results which have been successfully attained employing this process.

Example 1:

[0021]

Rod Diameter:

1.111 centimeters (7/16")

Number and Size of Rolling Mills:

4 25.4 centimeters (10") Diameter Rolls

Width of Strip:

2.032 centimeters (0.80")

Thickness of Strip:

0.1219 centimeters (0.048")

Width/Thickness Ratio:

17:1

Example 2:

[0022]

Rod Diameter:

1.27 centimeters (1/2")

Number of Rolling Mills:

5 16.51 centimeters (6 1/2")

Diameter Rolls

2.032 centimeters (0.80")

Thickness of Strip:

0.1219 centimeters (0.048")

Width/Thickness Ratio:

17:1

[0023] Although this process has been described in terms of producing carbon steel strips to be used in producing finned tubes, the process is not so limited and may be employed to produce strips of different metal compositions or strips for use in different functional applications.

Claims

1. A cold rolling process for creating a strip (12) from a rod (10) comprising passing a rod (10) through a series of cold processing rolling mills (24-30), cooling the rod (10) as the rod (10) passes between consecutive rolling mills (24-30) and minimising tension on the rod (10) as the rod (10) passes between consecutive rolling mills (24-30).
2. A process according to Claim 1 wherein the cooling of the rod (10) is accomplished by immersing the rod (10) in a cooling fluid (46).
3. A process according to Claim 2 wherein the cooling of the rod (10) is further accomplished by spraying cooling fluid onto the rod (10).
4. A process according to Claim 1 wherein the cooling of the rod (10) is accomplished by spraying cooling fluid (46) onto the rod (10).
5. A process according to any one of the preceding claims wherein the cooling fluid (46) employed is water.
6. A process according to Claim 1 further comprising monitoring tension in the rod (10) immediately downstream of each rolling mill (24-30) with a tension controller (54) and employing the tension controllers (54) to control speed of an adjacent upstream rolling mill (24-28).
7. A process according to Claim 1 further comprising cleaning and straightening said rod (10) prior to passing said rod (10) through said series of cold processing rolling mills (24-30).
8. A process according to either one of Claims 1 and 7 wherein said rod (10) is steel.
9. A process according to Claim 8 wherein the cooling is accomplished by immersing the rod (10) in a cooling bath (34-40) filled with cooling fluid (46).
10. A process according to Claim 9 wherein the cooling

bath (34-40) is filled with water.

11. A process according to Claim 10 wherein the cooling is further accomplished by spraying cooling fluid (46) onto the rod (10) from cooling nozzles (58) located at each rolling mill (24-30). 5
12. A process according to Claim 11 wherein the cooling fluid (46) is water. 10
13. A process according to Claim 8 wherein speed of each of the rolling mills (24-30) is controlled by a tension controller (54) which continuously monitors tension of the rod (10). 15

Patentansprüche

1. Kaltwalzverfahren zum Erzeugen eines Bandes (12) aus einem Stab bzw. einer Stange (10), umfassend: 20

Leiten bzw. Führen eines Stabs (10) durch eine Reihe von Kaltbearbeitungs-Walzwerken (24-30),
Abkühlen des Stabs (10), während der Stab (10) zwischen aufeinanderfolgenden Walzwerken (24-30) hindurchläuft, und
Minimieren der Zugspannung im Stab (10), während der Stab (10) zwischen aufeinanderfolgenden Walzwerken (24-30) hindurchläuft. 25 30

2. Verfahren gemäß Anspruch 1, wobei das Abkühlen des Stabs (10) durch Eintauchen des Stabs (10) in ein Kühlfluid (46) erfolgt. 35
3. Verfahren gemäß Anspruch 2, wobei das Abkühlen des Stabs (10) ferner durch Aufsprühen von Kühlfluid auf den Stab (10) erfolgt. 40
4. Verfahren gemäß Anspruch 1, wobei das Abkühlen des Stabs (10) durch Aufsprühen von Kühlfluid (46) auf den Stab (10) erfolgt. 45
5. Verfahren gemäß einem der vorangehenden Ansprüche, wobei das verwendete Kühlfluid (46) Wasser ist.
6. Verfahren gemäß Anspruch 1, ferner umfassend: 50
Überwachen bzw. Steuern der Zugspannung im Stab (10) unmittelbar stromab jedes Walzwerks (24-30) mit einem Zugspannungsregler (54) und Anwenden des Zugspannungsreglers (54) zur Regelung der Geschwindigkeit eines anschließenden, stromaufseitigen Walzwerks (24-28). 55
7. Verfahren gemäß Anspruch 1, ferner umfassend:

Reinigen und Geraderichten des Stabs (10) vor dem Leiten bzw. Führen des Stabs (10) durch die Reihe von Kaltbearbeitungs-Walzwerken (24-30).

8. Verfahren gemäß einem der Ansprüche 1 und 7, wobei der Stab (10) aus Stahl besteht.
9. Verfahren gemäß Anspruch 8, wobei die Abkühlung durch Eintauchen des Stabs (10) in ein mit Kühlfluid (46) gefülltes Kühlbad (34-40) erfolgt.
10. Verfahren gemäß Anspruch 9, wobei das Kühlbad (34-40) mit Wasser gefüllt ist bzw. wird.
11. Verfahren gemäß Anspruch 10, wobei die Abkühlung ferner durch Aufsprühen von Kühlfluid (46) auf den Stab (10) aus an jedem Walzwerk (24-30) gelegenen Kühlungsduisen (58) erfolgt.
12. Verfahren gemäß Anspruch 11, wobei das Kühlfluid (46) Wasser ist.
13. Verfahren gemäß Anspruch 8, wobei die Geschwindigkeit jedes der Walzwerke (24-30) durch einen Zugspannungsregler (54) gesteuert wird, der fortlaufend die Zugspannung des Stabs (10) überwacht.

Revendications

1. Procédé de laminage à froid destiné à créer une bande de métal (12) à partir d'une barre (10), comprenant le passage d'une barre (10) par une série de laminoirs à froid (24 - 30), le refroidissement de la barre (10) lorsque la barre (10) passe entre des laminoirs consécutifs (24 - 30) et la réduction au minimum de la traction de la barre (10) lorsque la barre (10) passe entre des laminoirs consécutifs (24 - 30).
2. Procédé selon la revendication 1, dans lequel le refroidissement de la barre (10) est réalisé par immersion de la barre (10) dans un fluide de refroidissement (46).
3. Procédé selon la revendication 2, dans lequel le refroidissement de la barre (10) est en outre réalisé par pulvérisation d'un fluide de refroidissement sur la barre (10).
4. Procédé selon la revendication 1, dans lequel le refroidissement de la barre (10) est réalisé par pulvérisation d'un fluide de refroidissement (46) sur la barre (10).
5. Procédé selon l'une quelconque des revendications précédentes, dans lequel le fluide de refroidisse-

ment (46) utilisé est de l'eau.

6. Procédé selon la revendication 1 comprenant en outre le contrôle de la traction dans la barre (10) immédiatement en aval de chaque laminoir (24 - 30) au moyen d'une unité de commande de traction (54) et l'utilisation des unités de commande de traction (54) afin de commander la vitesse d'un laminoir adjacent en amont (24 - 28).
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7. Procédé selon la revendication 1, comprenant en outre le nettoyage et le redressage de ladite barre (10) avant de faire passer ladite barre (10) par ladite série de laminoirs à froid (24 - 30).
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8. Procédé selon l'une quelconque des revendications 1 à 7, dans lequel ladite barre (10) est en acier.
9. Procédé selon la revendication 8, dans lequel le refroidissement est réalisé par immersion de la barre (10) dans un bain de refroidissement (34 - 40) se composant d'un fluide de refroidissement (46).
20
10. Procédé selon la revendication 9, dans lequel le bain de refroidissement (34 - 40) se compose d'eau.
25
11. Procédé selon la revendication 10, dans lequel le refroidissement est en outre réalisé par pulvérisation d'un fluide de refroidissement (46) sur la barre (10) à partir de buses de refroidissement (58) placées sur chaque laminoir (24 - 30).
30
12. Procédé selon la revendication 11, dans lequel le fluide de refroidissement (46) est de l'eau.
35
13. Procédé selon la revendication 8, dans lequel la vitesse de chacun des laminoirs (24 - 30) est commandée par une unité de commande de traction (54) qui contrôle la traction de la barre (10) de manière continue.
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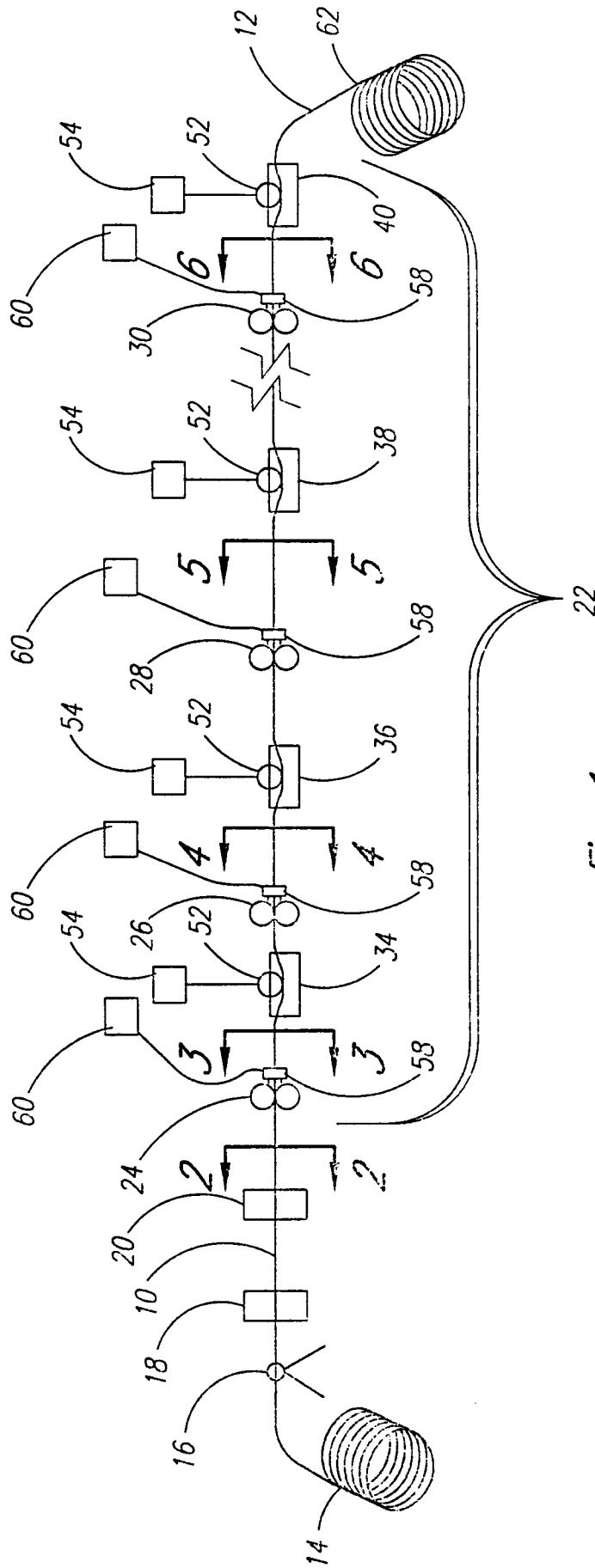


Fig. 1

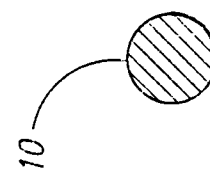


Fig. 2

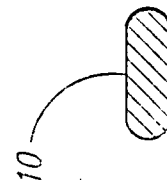


Fig. 3

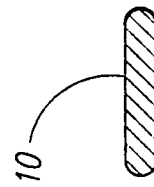


Fig. 4

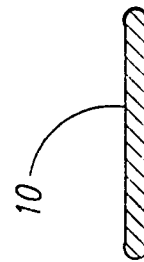


Fig. 5

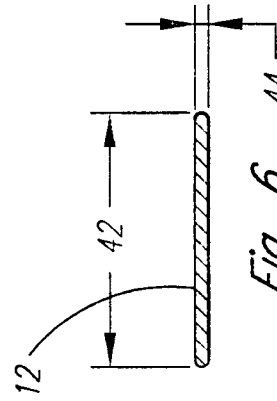


Fig. 6

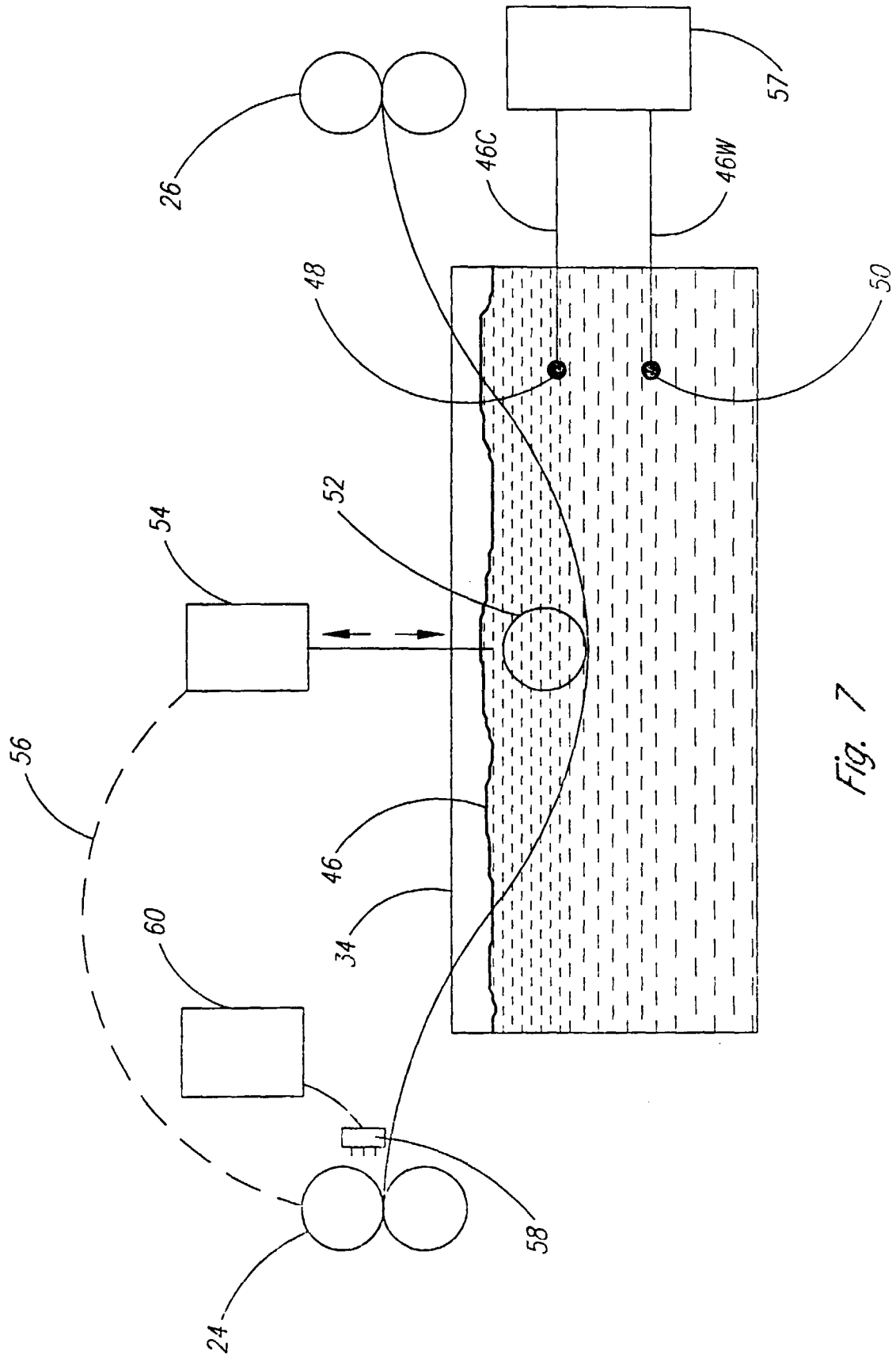


Fig. 7