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(54) **COLD ROLLED STEEL SHEET, METHOD OF MANUFACTURING AND VEHICLE**
KALTGEWALZTES STAHLBLECH, VERFAHREN ZUR HERSTELLUNG UND FAHRZEUG
TÔLE EN ACIER LAMINÉE À FROID, PROCÉDÉ DE FABRICATION ET VÉHICULE

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Description

[0001] The invention deals with cold rolled steel sheets presenting at the same time, high mechanical properties, a good formability and a good ability to receive a coating.

[0002] In particular, said steel sheets require a tensile strength TS above or equal to 1000 - 50xAl MPa, a uniform elongation UEI above or equal to 15%, a hole-expansion HE above or equal to 20% and a reactive surface allowing wetting and coating adhesion.

[0003] Moreover, some embodiments of said steel sheets containing high amounts of silicon or aluminium can have a low density and be more than 10% lighter compared to so-called Advanced High Strength Steels like Dual Phase, multiphase, bainitic or TRIP (Transformation Induced Plasticity) concepts.

[0004] In the automotive industry in particular, there is a continuous need to lighten vehicles while increasing safety. Thus, several families of steels like the ones mentioned above offering various strength and formability levels have been proposed.

[0005] Firstly, steels have been proposed that have micro-alloy elements which hardening is obtained simultaneously by precipitation and by refinement of the grain size. The development of such steels has been followed by the above-mentioned Advanced High Strength Steels.

[0006] For the purpose of obtaining even higher tensile strength levels, steels exhibiting TRIP behaviour with highly advantageous combinations of properties (tensile strength/formability) have been developed. These properties are associated with the structure of such steels, which consists of a ferritic matrix containing bainite and residual austenite.

The residual austenite is stabilized by an addition of silicon or aluminium, these elements retarding the precipitation of carbides in the austenite and in the bainite. The presence of residual austenite gives an undeformed sheet high ductility.

[0007] To achieve an even higher tensile strength, that is to say a level greater than 800-1000 MPa, multiphase steels having a predominantly bainitic structure have been developed. However, the formability and hole expansion properties are insufficient for next generation of automotive parts.

[0008] European application EP2128293 discloses a cold rolled steel sheet comprising, by weight percent, C: 0.2 to 0.8, Mn: 2 to 10, Al: 3 to 15, Si: 0.1 to 2.0, Cr: 0.1 to 0.3, B: 0.0005 to 0.003, Ti: 0.01 to 0.2, Nb: 0.005 to 0.2, balance Fe and impurities. The microstructure contains 13.5% of retained austenite, the remainder being ferrite and kappa precipitates. By controlling the Mn/Al ratio a duplex ferrite austenite microstructure is obtained while kappa precipitation is restricted.

[0009] International application WO2009/142362 discloses a cold rolled steel sheet and a hot dip galvanized steel sheet, which has improvement in delayed fracture resistance, a tensile strength of 980 MPa or more and an elongation of 28% or more by adding a suitable amount of Al for raising the stability of retained austenite and resistance against delayed fracture into an optimum composition that can increase the amount of retained austenite. In one or more aspects of this prior art, there are provided a high strength cold rolled steel sheet and a galvanized steel sheet, each of which consists of 0.05 to 0.3 weight percent C, 0.3 to 1.6 weight percent Si, 4.0 to 7.0 weight percent Mn, 0.5 to 2.0 weight percent Al, 0.01 to 0.1 weight percent Cr, 0.02 to 0.1 weight percent Ni and 0.005 to 0.03 weight percent Ti, 5 to 30ppm B, 0.01 to 0.03 weight percent Sb, 0.008 weight percent or less S, balance Fe and impurities. However such steels are difficult to coat due to high content of alloying elements.

[0010] International application WO2012/147898 aims at providing a high-strength steel having excellent hole expansion as well as stability of material properties, and a method for manufacturing the same, the high-strength steel plate having a TS of at least 780 MPa and a TSxEL of at least 22,000 MPa % in a low-C steel composition. The high-strength steel has good formability and stability of material properties has an ingredient composition including, in terms of mass%, 0.03%-0.25% C, 0.4%-2.5% Si, 3.5%-10.0% Mn, 0.1% or less P, 0.01% or less S, 0.01%-2.5% Al, 0.008% or less N, and Si + Al at least 1.0%, the remainder being Fe and unavoidable impurities, the steel structure having, by area ratio, 30%-80% ferrite, 0%-17% martensite, and, by volume ratio, 8% or more of residual austenite, and the average crystalline particle diameter of the residual austenite being 2 μ m or less. However such steels are difficult to coat due to high content of alloying elements.

[0011] Eventually, application EP2383353 discloses a steel with an elongation at break A80 of minimum 4% and a tensile strength of 900-1500 MPa. It comprises iron and unavoidable impurities and carbon (up to 0.5%), manganese (4-12%), silicon (up to 1%), aluminum (up to 3%), chromium (0.1-4%), copper (up to 2%), nickel (up to 2%), nitrogen (up to 0.05%), phosphorus (up to 0.05%), and sulfur (up to 0.01%), and optionally at most 0.5% of one or more elements comprising vanadium, niobium or titanium. The flat rolled steel product made of the steel, comprises 30-100% of martensite, tempered martensite or bainite and residual quantity of austenite. However, such steel will present low ductility levels leading to poor formability of the steel sheet obtained.

[0012] The invention aims at providing a cold rolled steel sheet presenting simultaneously:

- a tensile strength TS above or equal to 1000 - 50xAl MPa,
- a uniform elongation UEI above or equal to 15%,

- a hole-expansion HE above or equal to 20%, and
- a reactive surface allowing wetting and coating adhesion.

[0013] The invention covers, as a first object a cold rolled steel sheet comprising, by weight percent:

$0.1 \leq C \leq 0.5\%$
 $3.5 \leq Mn \leq 10.0\%$
 $Al \leq 9.0\%$
 $Si \leq 5.0\%$
 $0.5 \leq Si+Al \leq 9.0\%$
 $Ti \leq 0.2\%$
 $V \leq 0.2\%$
 $Nb \leq 0.2\%$
 $B \leq 0.0035$
 $Cr \leq 1\%$
 $S \leq 0.004 \%$
 $P \leq 0.025\%$

the remainder of the composition being iron and unavoidable impurities resulting from the smelting and the microstructure contains 10% to 50% of austenite, 25% to 90% of ferrite, less than 5% of Kappa precipitates and less than 25% of martensite, said sheet presenting from top surface the successive following layers:

- a top layer of pure metallic iron which thickness ranges from 50 to 300 nm and
- a first under-layer made of metallic iron which contains also one or more precipitates of oxides chosen among Mn, Si, Al, Cr and B, which thickness ranges from 1 to 8 μm .

[0014] The invention can also cover further additional characteristics, taken alone or in combination:

- a cold rolled steel sheet according to the invention further comprising a second under-layer, lying under the first under-layer, made of ferrite, which thickness ranges from 10 to 50 μm ,

[0015] In a preferred embodiment, the invention covers a cold rolled steel sheet which composition has

- a cold rolled steel sheet which composition has a manganese content of 5.0 to 9.0 %,
- a cold rolled steel sheet which composition has a carbon content of 0.1 to 0.3 %, a range of 0.15 to 0.25 % being further preferred,
- a cold rolled steel sheet which composition has an aluminium content of 1.5 to 9 %, a range of 5 to 8 % being further preferred,
- a cold rolled steel sheet which composition has a silicon content equal or under 1.5 %, a silicon content equal or under 0.3 % being further preferred,

[0016] In another preferred embodiment, the steel according to the invention covers:

- a cold rolled steel sheet which microstructure contains between 15 and 40 % of austenite, a range between 20 and 40 % of austenite being further preferred and a range of 25 and 40 % of austenite being most preferred.
- a cold rolled steel sheet which microstructure contains between 50 and 85% of ferrite,
- a cold rolled steel sheet which microstructure contains less than 15% of martensite, such martensite being possibly tempered,
- a cold rolled steel sheet which microstructure contains no kappa precipitates,

[0017] Ideally, the cold rolled steel sheet according to the invention presents a tensile strength TS above or equal to 1000 - 50 x %Al in MPa, a uniform elongation UEI above or equal to 15% and a hole expansion HE above or equal to 20%.

[0018] Another object of the invention is a metallic coated steel sheet obtained by coating a cold rolled steel sheet according to the invention, such coating being done by a process chosen among hot dip coating, electrodeposition and vacuum coating, possibly followed by a heat-treatment. In a preferred embodiment, such metallic coated steel sheet is galvanized.

[0019] The cold rolled and possibly coated steel sheet according to the invention can be

- manufactured by any adequate method. It is preferred that such method be compatible with usual continuous annealing lines and has a low sensitivity to variation of process parameters.

[0020] Another object of the invention is a process to produce a cold rolled steel sheet comprising the following steps:

Feeding and de-scaling a hot rolled strip or a thin slab which composition is according to the invention

The hot rolled strip or thin slab is then cold rolled with a cold rolling ratio between 30% and 75% so as to obtain a cold rolled steel sheet,

The steel sheet then undergoes a heating, at a heating rate H_{rate} at least equal to 1°C/s , up to the annealing temperature T_{anneal} lying between $T_{min}=721-36^{\circ}\text{C}-20^{\circ}\text{C}\cdot\text{Mn}+37^{\circ}\text{C}\cdot\text{Al}+2^{\circ}\text{C}\cdot\text{Si}$ (in $^{\circ}\text{C}$) and $T_{max}=690+145^{\circ}\text{C}-6.7^{\circ}\text{C}\cdot\text{Mn}+46^{\circ}\text{C}\cdot\text{Al}+9^{\circ}\text{C}\cdot\text{Si}$ (in $^{\circ}\text{C}$) during 30 and 700 seconds followed by a soaking at said temperature, the heating from 550°C up to T_{anneal} and at least first part of the soaking taking place in an oxidizing atmosphere so as to produce an iron oxide top layer with a thickness between 100 and 600 nm, said iron oxide layer being then fully reduced.

such reduction takes places during the second part of the soaking, in a reducing atmosphere containing between 2% and 35% of H_2 and having a dew point under -10°C , so as to fully reduce said iron oxide layer, the steel sheet being further cooled at a cooling rate $V_{cooling2}$ above 5°C/s and below 70°C/s down to room temperature.

[0021] Optionally, the second part of the soaking takes place in an atmosphere which dew point is under -30°C .

[0022] In another embodiment, the steel sheet is cooled down at $V_{cooling2}$ to a temperature T_{OA} between 350°C and 550°C and kept at T_{OA} for a time between 10 and 300 seconds and then the steel sheet is further cooled at a cooling rate $V_{cooling3}$ of 5°C/s to 70°C/s down to room temperature.

[0023] In another embodiment the reduction can also take places after cooling of said steel sheet at a cooling rate $V_{cooling2}$ above 5°C/s and below 70°C/s down to room temperature, it is then done by chemical pickling.

[0024] Ideally, the coating is done by a process chosen among hot dip coating, electro-deposition and vacuum coating, possibly followed by a heat-treatment.

[0025] Preferably, the metallic coating is done by galvannealing heat treatment.

[0026] There exists different ways to obtain the hot rolled strip, one of them is a process comprising the following steps:

- casting steel which composition is according to the invention so as to obtain a slab,
- reheating the slab at a temperature T_{reheat} between 1100°C and 1300°C ,
- hot rolling the reheated slab at a temperature between 800°C and 1250°C to obtain a hot rolled steel strip,
- cooling the hot rolled steel strip at a cooling speed $V_{cooling1}$ of at least 10°C/s until the coiling temperature $T_{coiling}$ lower or equal to 700°C ,
- coiling the hot rolled strip cooled at $T_{coiling}$.

[0027] In another embodiment, the hot rolled strip is obtained by a process called compact strip processing known per se and leading to a thin slab, avoiding therefore the hot rolling step.

[0028] In another embodiment, the hot rolled strip is further annealed using a process chosen among batch annealing between 400°C and 600°C between 1 and 24 hours and continuous annealing between 650°C and 750°C between 60 and 180s.

[0029] In a preferred embodiment, using direct fire furnace for heating, the atmosphere for iron reduction contains between 20 and 35% H_2 , the balance being nitrogen and unavoidable impurities.

[0030] In a preferred embodiment, using radiant tubes furnace for heating, the atmosphere for iron reduction contains between 2 and 8% H_2 , the balance being nitrogen and unavoidable impurities.

[0031] Optionally, the cold rolled and annealed steel is tempered at a temperature T_{temper} between 200 and 400°C for a time t_{temper} between 200 and 800s.

[0032] In another embodiment, the cold rolled and annealed steel undergoes a phosphate conversion treatment.

[0033] In another embodiment, the steel that did not go through a reductive atmosphere during annealing is then pickled at the exit of the continuous annealing line using typical pickling baths such as formic acid, hydrochloric acid, sulphuric acid or others to erase the present surface oxides resulting in a mainly metallic surface. The invention covers also a vehicle comprising a structural part made out of a steel sheet according to the invention.

[0034] Other features and advantages of the invention will appear through the following paragraphs of the detailed description.

[0035] The figures joined are given by way of examples and shall not be taken as limiting the scope of the present invention.

[0036] The figures are such that:

- Figure 1 illustrates the microstructure of example A2 after cold-rolling and annealing. The dark phase is the austenite, white phase is the ferrite,
- Figure 2 illustrates the tensile curve of example A2 after cold-rolling and annealing,
- Figure 3 shows GDOS profile of the example A6 that has been produced out of the invention,
- Figure 4 shows GDOS profile of the example A3 that has been produced according to the invention,
- Figure 5 shows the result of the 3-point bending test on the A6 example,
- Figure 6 shows the result of the 3-point bending test on the A3 example,
- Figure 7 shows the result of the 3-point bending test on the A4 example,
- Figure 8 shows the thermal path of the annealing cycle according to the example A2,
- Figure 9 shows the Al impact on the stability of tensile strength for steel D (0.2 C 5 Mn)

[0037] According to the invention, the chemical composition of the steel is balanced to reach the properties targets. Following chemical composition elements are given in weight percent.

[0038] Aluminum content must be below 9.0%, as it must be kept strictly less than this value to avoid a brittle intermetallic precipitation.

[0039] Aluminum additions are interesting for many aspects so as to increase the stability of retained austenite through an increase of carbon in the retained austenite. Moreover, the inventors have shown that, surprisingly, even though Al is supposed to stabilize ferrite, in the present invention, the higher the Al content, the better the stability of the austenite formed during annealing.

[0040] The improved robustness during annealing addition of Al leads to lower variation of austenite fraction as a function of temperature during annealing on continuous annealing lines.

[0041] Al is the most efficient element, able to open a large feasibility window for continuous annealing since it favours the combination of full recrystallization at annealing temperatures T_{anneal} above the non-recrystallization temperature as well as austenite stabilization.

[0042] Al also allows reducing the steel density up to 10%. Moreover, such element reduces detrimental effects of high strength steels, such as spring-back, hydrogen embrittlement and rigidity loss. As shown in figure 9, above 1.5% of Al, the steel robustness is improved and delta tensile strength is equal or below 10 MPa/°C of annealing temperature. It has however an impact of the tensile strength that can be reached. It decreases the tensile strength by 50 MPa by percent of added aluminium.

[0043] Just as aluminum, silicon is an element for reducing the density of steel. Silicon is also very efficient to increase the strength through solid solution. However its content is limited to 5.0%, because beyond this value, brittleness issues are met during cold-rolling.

[0044] According to the invention, the carbon content is between 0.10 and 0.50%. Carbon is a gamma-former element. It promotes, with the Mn, the onset of austenite. Below 0.10%, the mechanical strength above 1000 - 50xAl in MPa is difficult to achieve. If the carbon content is greater than 0.50%, the cold-rollability is reduced and the weldability becomes poor.

[0045] Manganese must be between 3.5% and 10.0%. This element, also austenite-stabilizer, is used to stabilize enough austenite in the microstructure. It also has a solid solution hardening and a refining effect on the microstructure. For Mn content less than 3.5%, the stabilization of the retained austenite in the microstructure is not sufficient to enable the combination of the uniform elongation above 15% and the tensile strength above 1000 - 50 x %Al in MPa. Above 10.0%, weldability becomes poor. Segregations and inclusions deteriorate the damage properties.

[0046] Micro-alloy elements such as titanium, vanadium and niobium may be added respectively in an amount less than 0.2%, in order to obtain an additional precipitation hardening. In particular titanium and niobium are used to control the grain size during the solidification. One limitation, however, is necessary because beyond, a saturation effect is obtained.

[0047] Chromium is tolerated up to 1%. Above that limit, detrimental surface oxides may appear.

[0048] Above a sulphur content of 0.004 %, the ductility is reduced due to the presence of excess sulfides such as MnS which reduce the ductility, in particular during hole-expansion tests.

[0049] Phosphorus is an element which hardens in solid solution but which reduces the spot weldability and the hot ductility, particularly due to its tendency to segregation at the grain boundaries or co-segregation with manganese. For these reasons, its content must be limited to 0.025 %, and preferably 0.015 %, in order to obtain good spot weldability.

[0050] The maximum boron content allowed by the invention is 0.0035 %. Above such limit, a saturation level is

expected as regard to grain refinement.

[0051] The balance is made of iron and inevitable impurities.

[0052] To reach the targeted properties, the microstructure of the steel sheet of the invention must contain, as surface fraction, 10% to 50% of austenite, 25% to 90 % of ferrite, kappa precipitates below 5% and martensite lower than 25%.

[0053] Austenite is a structure that brings ductility, its content must be above 10% so that the steel of the invention is enough ductile with uniform elongation above 15% and its content must be below 50% because above that value the mechanical properties balance deteriorates.

[0054] Ferrite in the invention is defined by a cubic center structure obtained from recovery and recrystallization upon annealing whether from preceding ferrite formed during solidification or from bainite or martensite of the hot rolled steel. Its content must be between 25 and 90% so as to have $(1000 - 50 \times \%Al)$ in MPa minimum of tensile strength and at least 15% of uniform elongation.

[0055] Kappa in the invention is defined by precipitates whose stoichiometry is $(Fe,Mn)_3AlC_x$, where x is strictly lower than 1. The surface density of precipitates Kappa can go up to 5%. Above 5%, the ductility decreases and uniform elongation above 15% is not achieved. In addition, uncontrolled precipitation Kappa around the ferrite grain boundaries may occur, increasing, as a consequence, the efforts during hot and/or cold rolling. Preferentially, the surface density of Kappa precipitates should be less than 2%. As the microstructure is uniform, the surface fraction is equal to the volume fraction.

[0056] Martensite is a structure formed during cooling after the soaking from the unstable austenite. Its content must be limited to 25% so that the hole expansion remains above 20%. In a preferred embodiment, such martensite is tempered, either after or before the coating step, depending on the type of coating.

[0057] Another main characteristic of the steel sheet according to the invention lies in its reactive surface, which can be described as comprising the successive following layers:

- a top layer of pure metallic iron which thickness ranges from 50 to 300 nm and
- a first under-layer made of metallic iron which contains also one or more precipitates of oxides chosen among Mn, Si, Al, Cr and B, which thickness ranges from 1 to 8 μm .

[0058] Such a structure guarantees reactivity during the phosphate conversion treatment of the bare steel, a good wetting and adherence of metallic coatings such as zinc or aluminium coatings. This improves the ability for electro-deposition of paint.

[0059] As long as such surface is obtained, any suitable manufacturing method can be employed.

[0060] By example, one method to produce the steel according to the invention implies casting steel with the chemical composition of the invention.

[0061] The cast steel is reheated between 1100°C and 1300°C. When slab reheating temperature is below 1100°C, for $Al < 4wt\%$, the rolling loads increase too much and hot rolling process becomes difficult; for $Al \geq 4wt\%$, the last hot rolling pass is hardly kept above 800°C due to thermal losses during the rolling process. Above 1300°C, oxidation is very intense, which leads to scale loss and surface degradation.

[0062] The reheated slab can then be hot rolled with a temperature between 1250°C and 800°C, the last hot rolling pass taking place at a temperature T_{lp} above or equal to 800°C. If T_{lp} is below 800°C, hot workability is reduced.

[0063] The steel is cooled at a cooling speed $V_{cooling1}$ of at least 10°C/s until the coiling temperature $T_{coiling}$ lower or equal to 700°C. If the cooling speed $V_{cooling1}$ is below 10°C/s, in the case where $Al \geq 4wt\%$, and $Mn \geq 4wt\%$, there is a precipitation of harmful Kappa precipitates at the interfaces between ferrite and austenite.

[0064] $T_{coiling}$ must be lower or equal to 700°C, If the coiling temperature is above 700°C, there is a risk to form a coarse microstructure consisting of:

- coarse ferrite and bainite structure when Al content is below 4wt%
- Kappa carbides at the interfaces between ferrite and austenite when Al content is above or equal to 4wt%Al and Mn above 4%Mn

[0065] The steel is then cold rolled with a cold rolling ratio between 30% and 75% so as to obtain a cold rolled steel. Below 30%, the recrystallization during subsequent annealing is not favoured enough and the uniform elongation above 15% is not achieved due to a lack of recrystallization. Above 75%, there is a risk of edge cracking during cold-rolling.

[0066] Then, the steel is heated at a heating rate H_{rate} at least equal to 1°C/s up to the annealing temperature T_{anneal} . If the heating rate is below 1°C/s, the force for recrystallization is too low, hindering the achievement of the target microstructure;

[0067] During the heating, from 550°C up to the end of soaking at T_{anneal} , the steel goes through an oxidizing atmosphere so as to produce predominantly an iron oxide with a thickness between 100 and 600 nm.

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- If the iron oxide is thinner than 100nm, the iron oxide will disappear too early, allowing again external selective oxidation of the alloying elements during the subsequent reductive annealing, hindering reactivity of the surface during the coating process

- If the iron oxide is above 600nm, the risk of non-adherent iron oxides is given polluting the hearth roll of the furnace by pick-up issues and leading thus by indentation to surface defects. A thickness greater than 600nm can also lead to an only partial reduction of the iron oxide during the soaking or cooling, or soaking and cooling step when a reductive atmosphere is applied.

[0068] If radiant tubes are used in the furnace for heating, the atmosphere for iron reduction shall contain between 2 and 8% H₂, the balance being nitrogen and unavoidable impurities.

- If the H₂ content is lower than 2%, reduction ability of the atmosphere is too low to reduce completely the iron oxide.

- If the H₂ content is higher than 8%, the reduction process is complete, but no more economically viable.

[0069] The steel is then annealed at a temperature T_{anneal} between T_{min} °C and T_{max} °C during 30 and 700 seconds. Controlling the annealing temperature is an important feature of the process since it enables to control the austenite fraction and its chemical composition. The annealing temperature should be high enough to form more than the 10% retained austenite required in the final microstructure and to avoid precipitation of more than 5% Kappa carbides. The annealing temperature should not be too high to avoid the formation of more than 50% austenite and to avoid grain coarsening leading to a tensile strength below 1000-50xAl (%) when Al ≥ 4wt%. The annealing temperature should also be sufficiently high to enable the sufficient recrystallization of the cold-rolled structure. As the phase transformations depend on the chemical composition, the preferred T_{anneal} is defined as the following preferably:

[0070] The annealing temperature T_{min} is defined such as: T_{min} = 721 - 36°C - 20*Mn + 37*Al + 2*Si, (in °C). Below this temperature, the minimum austenite fraction is not formed, or its stability is too high, leading to a limited tensile strength. The annealing temperature T_{max} is defined such as: T_{max} = 690 + 145°C - 6.7*Mn + 46*Al + 9*Si (in °C). Above T_{max}, there is also a risk to form too many martensite, leading to a limited uniform elongation and hole expandability.

- During the soaking at T_{anneal} down to 600°C, the steel goes through an atmosphere containing between 2% and 35% H₂, the balance being nitrogen and unavoidable impurities, so as to reduce the iron oxide formed upon heating applying a dew point below the critical dew point for iron oxidation typically below - 10°C.

- If the H₂ content is lower than 2%, reduction ability of the atmosphere is too low to reduce completely the iron oxide.

- If the H₂ content is higher than 35%, the reduction process is complete, but no more economically viable.

[0071] Preferably, the dew point during iron reduction is below -30°C, so as to allow fast reduction kinetics.

[0072] In a preferred embodiment, H₂ content is higher than 20% but lower than 35%.

- in another embodiment, the reduction step is by-passed and the iron oxide is removed by pickling (formic acid, chlorhydric acid, sulphuric acid) after the whole annealing treatment is completed. This is because, if the steel does not go through a reductive atmosphere, slight re-oxidation may take place and this layer shall be removed. In the invention:

- First part of the soaking means the heating and up to 90% of the soaking time

- While the second part of the soaking means the remaining soaking time and the cooling from the annealing temperature down to 600°C.

[0073] The steel is then cooled at a cooling rate V_{cooling2} of typical annealing lines, preferably, this cooling rate is above 5°C/s and below 70°C/s. If the cooling rate is below 5°C/s, there is a risk to form more than 5% of Kappa carbides when Al content is above 4wt%. The cooling atmosphere contains between 2% and 35% H₂ so as to avoid re-oxidation of the reduced iron oxide formed applying a dew point below the critical dew point for iron oxidation typically below -10°C.

- Optionally, the steel is cooled down at V_{cooling2} to a temperature T_{OA} between 350°C and 550°C and kept at T_{OA} for a time between 10 and 300 seconds. It was shown that such a thermal treatment to facilitate the Zn coating by

hot dip process for instance does not affect the final mechanical properties.

[0074] The steel is further cooled at a cooling rate V_{cooling3} of typical annealing lines down to room temperature, preferably, this cooling rate is above 5°C/s and below 70°C/s to obtain a cold rolled and annealed steel.

[0075] In another embodiment, after maintaining the steel at T_{OA} , the steel is hot dip coated with Zn or Zn alloys meaning that Zn content is the highest in the alloy in percent.

[0076] In another embodiment, after maintaining the steel at T_{OA} , the steel is hot dip coated with Al or Al alloys meaning that Al content is the highest in the alloy in percent.

[0077] Optionally, the cold rolled and annealed steel is tempered at a temperature T_{temper} between 200 and 400°C for a time t_{temper} between 200 and 800 seconds. This treatment enables the tempering of martensite, which might be formed during cooling after the soaking from the unstable austenite. The martensite hardness is thus decreased and the hole expandability is improved. Below 200°C, the tempering treatment is not efficient enough. Above 400°C, the strength loss becomes high and the balance between strength and hole expansion is not improved anymore.

[0078] In another embodiment, the cold rolled and annealed steel undergoes a phosphate conversion treatment.

[0079] In another embodiment, the cold rolled and annealed steel is coated by Zn, Zn-alloys, Al or Al alloys applied by electrodeposition or vacuum technologies. Zn alloys and Al alloys meaning that respectively, Zn and Al are major constituents of the coating.

Semi-finished products have been developed from a steel casting. The chemical compositions of semi-finished products, expressed in weight percent, are shown in Table 1 below. The rest of the steel composition in Table 1 consists of iron and inevitable impurities resulting from the smelting.

Steel	C	Mn	Al	Si	Cr	Si+Al	Comment
A	0.21	8.2	7.4	0.26	0.02	7.66	Invention
B	0.2	3.8	0	1.5	0.3	1.5	Invention
C	0,15	<u>1,9</u>	0,05	0,2	0,2	<u>0.25</u>	Comparative example
D	0,196	5,01	1,03	0,012	<0,010	1,042	Invention
E	0,189	5,01	2,85	0,02	<0,010	2,87	Invention
F	0,2	4	6,2	<0,050	<0,010	6,2	Invention
G	0,19	6,2	6	<0,050	<0,010	6	Invention
H	0,12	5,15	2,31	0,509	<0,010	2,819	Invention

Steel	S	P	Ti	V	Nb	Comment
A	<0.005	<0.025	<0,010	<0,010	<0,010	Invention
B	<0.005	<0.025	<0,010	<0,010	<0,010	Invention
C	<0.005	<0.025	<0.01	<0.01	<0.01	Comparative example
D	0,002	0,022	<0,010	<0,010	<0,010	Invention
E	0,0021	0,02	<0,010	<0,010	<0,010	Invention
F	0,0031	0,02	<0,010	<0,010	<0,010	Invention

G	0,004	0,017	<0,010	<0,010	<0,010	Invention
H	<0.005	0,017	<0,010	<0,010	<0,010	Invention

Table 1: Chemical composition (wt%).

[0080] These steels are boron free.

[0081] The products have first been hot-rolled. The hot rolled plates were then cold rolled and annealed. The production conditions are shown in Table 2 with the following abbreviations:

- T_{reheat} : is the reheating temperature
- T_{lp} is the finishing rolling temperature
- V_{cooling1} : is the cooling rate after the last rolling pass.
- T_{coiling} : is the coiling temperature
- Rate: is the rate of cold rolling reduction
- H_{rate} : is the heating rate
- T_{anneal} : is the soaking temperature during annealing.
- t_{anneal} : is the soaking duration during annealing.
- V_{cooling2} : is the cooling rate after the soaking.
- t_{OA} : is the time during which the plate is maintained at a temperature T_{OA}
- V_{cooling3} : is the cooling rate below T_{OA} .

Table 2: Hot-rolling and cold-rolling and annealing conditions

	T _{reheat} (°C)	T _{lp} (°C)	V _{cooling1} (°C/s)	T _{cooling} (°C)	Rate (%)	H _{rate} (°C/s)	T _{anneal} (°C)	t _{anneal} (s)	V _{cooling2} (°C/s)	T _{OA} (°C)	t _{OA} (s)	V _{cooling3} (°C/s)
A1	1180	905	50	500	74	15	830	136	50	-	-	50
A2	1180	964	50	500	74	15	850	136	50	-	-	50
A3	1180	964	50	500	74	15	790	136	50	-	-	50
A4	1180	964	50	500	74	15	900	136	50	-	-	50
A5	1180	964	50	500	74	15	850	136	50	-	-	50
A6	1180	964	50	500	74	15	900	136	50	-	-	50
A7	1180	964	50	500	74	15	900	136	50	-	-	50
A8	1180	964	50	500	74	15	830	136	50	-	-	50
B1	1250	900	30	550	50	5	790	130	20	470	38	20
B2	1250	900	30	550	50	5	790	130	20	470	38	20
B3	1250	900	30	550	50	5	675	130	20	470	38	20
C1	1250	900	30	550	60	10	800	60	20	460	10	20
D1	1250	930	15	600	50	16	710	120	20	400	300	5
E1	1250	930	15	600	50	16	770	120	20	400	300	5
F1	1200	950	60	450	75	15	900	136	50	410	500	20
F2	1200	950	60	450	75	15	900	136	50	410	500	20
F3	1200	950	60	450	75	15	900	136	50	410	500	20
F4	1200	950	60	450	75	15	900	136	50	410	500	20
G1	1200	950	60	450	75	15	850	136	50	410	500	20
G2	1200	950	60	450	75	15	850	136	50	410	500	20
H1	1250	900	10	600	50	10	770	120	20	410	500	5

[0082] The products were annealed under different annealing atmospheres. In Table 3, the annealing atmospheres are presented, and the indication of pickling in formic acid after the complete continuous annealing cycle. "Yes" if a pickling treatment was applied, "No" if no pickling treatment was applied.

[0083] If the annealing atmosphere from 550°C up to the end of soaking at T_{anneal} was oxidizing for iron by adjusting the dew point and the hydrogen content, the indication "Oxidizing" was set in the column "Atmosphere from 550°C up to the end of soaking at T_{anneal} "; If the atmosphere was reducing for iron, "Reducing" was set. Additionally, the H₂ content and the dew point of the annealing atmosphere are given.

[0084] If the annealing atmosphere during the soaking at T_{anneal} down to 600°C was reducing for iron oxide, the indication "Reducing" was set in the column "Atmosphere during the soaking at T_{anneal} down to 600°C". If the annealing atmosphere was oxidizing for iron, "oxidizing" is indicated. Additionally, the H₂ content and the dew point of the annealing atmosphere are given.

[0085] In table 3 here below, EG stands for electro-galvanized while GI stands for galvanized.

Table 3: Annealing conditions to create the proper reactive surface after annealing, balance N2

Steel	Atmosphere from 550°C up to the end of the first part of the soaking	Atmosphere during the second part of soaking at T_{anneal} down to 600°C	Pickling in formic acid after the continuous annealing	coating type
A1	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
A2	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
A3	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
A4	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
A5	Oxidizing - Dew point +30°C, 5%H ₂	Oxidizing - Dew point +30°C, 5%H ₂	No	EG
A6	Reducing - Dew point -40°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
A7	Oxidizing - Dew point +30°C, 5%H ₂	Oxidizing - Dew point +30°C, 5%H ₂	Yes	EG
A8	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	GI
B1	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	GI
B2	Reducing - Dew point -40°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	GI
B3	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	GI
C1	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	GI
D1	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
E1	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
F1	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
F2	Reducing - Dew point -40°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG

(continued)

5	Steel	Atmosphere from 550°C up to the end of the first part of the soaking	Atmosphere during the second part of soaking at Tanneal down to 600°C	Pickling in formic acid after the continuous annealing	coating type
	F3	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	GI
10	F4	Reducing - Dew point -40°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	GI
	G1	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
15	G2	Reducing - Dew point -40°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG
	H1	Oxidizing - Dew point +30°C, 5%H ₂	Reducing - Dew point -40°C, 5%H ₂	No	EG

[0086] Samples A6, B2, F2, F4 and G2 have been annealed under a regular reducing atmosphere (dew point = -40°C, 5%H₂) giving rise to bad surface reactivity. The GDOS profile of such surfaces is characterized by a first zone where the Fe signal is very low while the O signal is high, reaching more than 50% at the free surface. In that zone, Mn enrichment is also detected. Below that layer the Fe signal increases and the O signal decreases at a rate of about 1% per nanometer. This oxygen signal tail is typical of the presence of an external selective oxide layer, which oxygen atoms are partly sputtered and partly implanted into the substrate during the measurement. Some superficial pollution is visible due to the transfer of the samples from the annealing simulator to the GDOS analysis. At figure 3, In (A) some superficial pollution is visible due to the transfer of the samples from the annealing simulator to the GDOS analysis.

[0087] Table 4 presents the following characteristics:

- Ferrite: "OK" refers to the presence of ferrite with a volume fraction between 25 and 90% in the microstructure of the annealed sheet. "KO" refers to comparative examples where ferrite fraction is outside this range.
- Austenite: "OK" refers to the presence of austenite with a volume fraction between 10 and 50% in the microstructure of the annealed sheet. "KO" refers to comparative examples where austenite fraction is outside this range.
- Martensite: "OK" refers to the presence or not of martensite with a volume fraction less than 25% in the microstructure of the annealed sheet. "KO" refers to comparative examples where martensite fraction is above 25%.
- K: "OK" refers to the presence or not of precipitates in the microstructure Kappa with a surface fraction of less than 5%. This measurement is performed with a scanning electron microscope. When it says "KO", fraction of kappa precipitates is above 5%.
- UTS (MPa) refers to the tensile strength measured by tensile test in the longitudinal direction relative to the rolling direction.
- UEI (%) refers to the uniform elongation measured by tensile test in the longitudinal direction relative to the rolling direction.
- HE (%): refers to the hole expansion ratio according to the norm ISO 16630 2009. The method of determining the hole expansion ratio HE% is used to evaluate the ability of a metal to resist to the forming of a cut-edge. It consists in measuring the initial diameter D_i of the hole before forming, then the final hole diameter D_f after forming, determined at the time of through-cracks observed on the edges of the hole. It then determines the ability to hole expansion HE% using the following formula:

$$HE\% = 100 \times \frac{(D_f - D_i)}{D_i}$$

Under this method, the initial hole diameter is of 10 millimetres.

Table 4: Properties of cold-rolled and annealed sheets

Steel	Ferrite	Austenite	martensite	K	TS (MPa)	UEI (%)	HE (%)
A1	OK (81%)	OK (17%)	OK (0%)	OK (2%)	831	15	30%

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(continued)

Steel	Ferrite	Austenite	martensite	K	TS (MPa)	UEI (%)	HE (%)
A2	OK (80%)	OK (20%)	OK	OK (0%)	800	15	42
A3	OK	OK (15%)	OK (0%)	<u>KO</u> (>5%)	Not measured	Not measured	Not measured
A4	OK	OK (25%)	OK	OK (0%)	730	20	Not measured
A5	OK (80%)	OK (20%)	OK	OK (0%)	800	15	42
A6	OK	OK (25%)	OK	OK (0%)	730	20	Not measured
A7	OK	OK (25%)	OK	OK (0%)	730	20	Not measured
A8	OK (81%)	OK (17%)	OK (0%)	OK (2%)	831	15	30%
B1	<u>KO</u>	<u>KO (8%)</u>	<u>KO (92%)</u>	OK (0%)	Not measured	Not measured	Not measured
B2	<u>KO</u>	<u>KO (8%)</u>	<u>KO (92%)</u>	OK (0%)	Not measured	Not measured	Not measured
B3	OK (60%)	OK (30%)	OK (10%)	OK (0%)	1092	17	30
C1	OK (40%)	<u>KO (0%)</u>	OK (10%)	OK (0%)	<u>820</u>	<u>14</u>	23
D1	OK (50%)	OK (28%)	OK (22%)	OK (0%)	1075	22,8	Not measured
E1	OK (66%)	OK (32%)	OK (2%)	OK (0%)	1023	24,4	Not measured
F1	OK (79%)	OK (21%)	OK (0%)	OK (0%)	723	25	Not measured
G1	OK (74%)	OK (26%)	OK (0%)	OK (0%)	702	20	Not measured
H1	OK (69%)	OK (23%)	OK (8%)	OK (0%)	965	16	Not measured

[0088] B1 has not been measured due to brittle behaviour. For C1, the rest of the microstructure (50%) is made of bainite. C1 presents a tensile strength of 820MPa which is too low for the invention.

[0089] Table 5 presents the results of coatability by electro deposition of a Zinc coating.

[0090] The targeted surface and subsurface micro structure is indicated as "OK" if the surface is made of an external layer of metallic iron, thickness ranging from 50 to 300 nm, covering an internal layer made of metallic iron and containing precipitates of internal oxides of Mn, Al, Si, Cr and B and other elements more oxidizable than iron, which thickness ranges from 1 to 8 μm , superimposed onto a decarburized layer, mainly made of ferrite, which thickness ranges from 10 to 50 μm . If the surface and subsurface differs from the targeted surface, the microstructure is judged insufficient "KO".

[0091] The coating quality is characterised by the covering ratio and the coating adherence.

[0092] The covering ratio is indicated as "OK", when full coverage is observed by the naked eye, and "KO" if coating defects such as uncoated areas or bare spots are observed.

[0093] The coating adherence was tested in a 3-point bending test (180°) on 1mm sheets using a 3mm punch with a tip of 1.5mm in radius. The adherence is judged excellent "OK" if no peeling of the zinc coating is observed after applying and withdrawing of an adhesive "scotch" tape. If peeling or flaking of the coating is observed, the adherence is judged insufficient "KO".

Table 5: Surface properties of cold-rolled and annealed and coated sheets

	Targeted surface and subsurface micro structure	Covering ratio	Coating adherence	Coating type	
A1	OK	OK	OK	EG	Invention
A2	OK	OK	OK	EG	Invention
A3	OK	OK	OK	EG	Invention
A4	OK	OK	OK	EG	Invention
A5	<u>KO</u>	<u>KO</u>	<u>KO</u>	EG	reference
A6	<u>KO</u>	<u>KO</u>	<u>KO</u>	EG	reference
A7	OK	OK	OK	EG	Invention
A8	OK	OK	OK	GI	Invention

(continued)

	Targeted surface and subsurface micro structure	Covering ratio	Coating adherence	Coating type	
5	B1	OK	OK	GI	Invention
	B2	KO	KO	GI	reference
	B3	OK	OK	GI	Invention
	C1	OK	OK	GI	Invention
10	D1	OK	OK	EG	Invention
	E1	OK	OK	EG	Invention
	F1	OK	OK	EG	Invention
15	F2	KO	KO	EG	reference
	F3	OK	OK	GI	Invention
	F4	KO	KO	GI	reference
	G1	OK	OK	EG	Invention
20	G2	KO	KO	EG	reference
	H1	OK	OK	EG	Invention

[0094] In figure 5, the coating adherence was tested in a 3-point bending test (180°) on 1mm sheets using a 3mm punch with a tip of 1.5mm in radius. Non-adherence of zinc coating is observed for steel example A6 (out of the invention). At (a), a coated part is visible, which was under low solicitation during the bending test. At (b), the steel substrate is visible after peeling off of coating; this part was under high solicitation in the bending test.

[0095] Sheets A1, A2, A3, A4, A7, A8, B1, B3, C1, D1, E1, F1, F3, G1 and H1 are sheets whose chemical composition and processing method are according to the invention.

[0096] For the sample A3, the production has been carried out under an oxidizing atmosphere (dew point=+30°C) followed by a reducing atmosphere. The surface is made of a first layer where the Fe GDOS signal reaches a maximum and the oxygen one a minimum as shown in figure 4. This layer (B) is made of metallic iron. The second layer (C) is characterized by a continuous decrease of the oxygen signal at a slow rate, around 1 % per 100 nm and corresponds to a zone where internal selective oxides of Mn and Al have precipitated. It extends up to an oxygen level of 5% which corresponds here to a thickness of 4 μm. In (A) some superficial pollution is visible due to the transfer of the samples from the annealing simulator to the GDOS analysis.

[0097] For sample A3, the coating adherence was tested in a 3-point bending test (180°) on 1mm sheets using a 3mm punch with a tip of 1.5mm in radius. Very good adherence of the zinc coating is observed for steel example A3 (within the invention) as shown in figure 6. At (c), a coated part is visible, which was under low solicitation during the bending test. At (d), the coating is showing excellent adherence, this part was under high solicitation in the bending test.

[0098] The coating adherence was also tested in a 3-point bending test (180°) on 1mm sheets using a 3mm punch with a tip of 1.5mm in radius for A4 as shown in figure 7. Very good adherence of the zinc coating is observed for steel example A4 (within the invention). At (e), a coated part is visible, which was under low solicitation during the bending test. At (f), the coating is showing excellent adherence, this part was under high solicitation in the bending test.

[0099] The microstructure of the sheet A1 is illustrated by Figure 1. Its tensile curve is shown on Figure 2.

[0100] B2 is not according to the invention, due to untargeted microstructure and coating method. Its annealing temperature is out of target.

[0101] A5 did not undergo a pickling step while it has undergone only oxidation during annealing; as a consequence coating adherence and covering ratio are bad.

[0102] A6, B2, F2, F4 and G2 have undergone only reduction during the annealing; as a consequence, coating adherence and covering ratio results are bad.

[0103] For the steels according to the invention, in addition to good coatability via electro-galvanization (EG) or galvanization, the tensile strengths are higher than 1000-50xAl MPa, and their uniform elongation is greater than 15%. Furthermore, hole expansion is above 20% also.

[0104] The steel sheets according to the invention will be beneficially used for the manufacture of structural or safety parts in the automobile industry.

Claims

1. Cold rolled steel sheet comprising, by weight percent:

$0.1 \leq C \leq 0.5\%$
 $3.5 \leq Mn \leq 10.0\%$
 $Al \leq 9.0\%$
 $Si \leq 5.0\%$
 $0.5 \leq Si+Al \leq 9.0\%$
 $Ti \leq 0.2\%$
 $V \leq 0.2\%$
 $Nb \leq 0.2\%$
 $B \leq 0.0035$
 $Cr \leq 1\%$
 $S \leq 0.004\%$
 $P \leq 0.025 \%$

the remainder of the composition being iron and unavoidable impurities resulting from the smelting and the micro-structure contains 10% to 50% of austenite, 25% to 90% of ferrite, less than 5% of Kappa precipitates and less than 25% of martensite, said sheet presenting from top surface the successive following layers:

- a top layer of pure metallic iron which thickness ranges from 50 to 300 nm and
- a first under-layer made of metallic iron which contains also one or more precipitates of oxides chosen among Mn, Si, Al, Cr and B, which thickness ranges from 1 to 8 μm .

2. Cold rolled steel sheet of claim 1, further comprising a second under-layer, lying under said first under-layer, made of pure ferrite, which thickness ranges from 10 to 50 μm .

3. Cold rolled steel sheet of claim 1 or 2, the steel composition having a manganese content of 5.0 to 9.0 %.

4. Cold rolled steel sheet according to anyone of claims 1 to 3, the steel composition having a carbon content of 0.1 to 0.3 %.

5. Cold rolled steel sheet according to anyone of claims 1 to 4, the steel composition having a carbon content of 0.15 to 0.25 %.

6. Cold rolled steel sheet according to anyone of claims 1 to 5, the steel composition having an aluminium content of 1.5 to 9 %.

7. Cold rolled steel sheet according to anyone of claims 1 to 6, the steel composition having an aluminium content of 5 to 8 %.

8. Cold rolled steel sheet according to anyone of claims 1 to 7, the steel composition having a silicon content equal or under 1.5 %.

9. Cold rolled steel sheet according to anyone of claims 1 to 8, the steel composition having a silicon content equal or under 0.3 %.

10. Cold rolled steel sheet according to anyone of claims 1 to 9, the steel microstructure containing between 25 and 40 % of austenite.

11. Cold rolled steel sheet according to anyone of claims 1 to 10, the steel microstructure containing between 50 and 85% of ferrite.

12. Cold rolled steel sheet according to anyone of claims 1 to 11, the steel microstructure containing less than 15% of martensite.

13. Cold rolled steel sheet according to anyone of claims 1 to 12, the steel microstructure containing no kappa precipitates.

14. Cold rolled steel sheet according to anyone of claims 1 to 13 presenting a tensile strength TS above or equal to 1000 - 50 x %Al in MPa, a uniform elongation UEI above or equal to 15% and a hole expansion HE above or equal to 20%.

15. Metallic coated steel sheet obtained by coating a cold rolled steel sheet according to anyone of claims 1 to 14, such coating being done by a process chosen among hot dip coating, electrodeposition and vacuum coating, possibly followed by a heat-treatment.

16. Metallic coated steel sheet according to anyone of claims 1 to 15, wherein said sheet is galvanized.

17. Method of manufacturing a cold rolled steel sheet according to claims, comprising the following steps:

- feeding and descaling a hot rolled strip or a thin slab which composition is according to claims 1 to 9,
- cold rolling the hot rolled strip or thin slab with a cold rolling ratio between 30% and 75% so as to obtain a cold rolled steel sheet,
- heat treating the steel sheet that undergoes a heating, at a heating rate H_{rate} at least equal to 1°C/s, up to the annealing temperature T_{anneal} lying between $T_{min}=721-36\cdot C-20\cdot Mn+37\cdot Al+2\cdot Si$ (in °C) and $T_{max}=690+145\cdot C-6.7\cdot Mn+46\cdot Al+9\cdot Si$ (in °C) during 30 and 700 seconds followed by a soaking at said temperature, the heating from 550°C up to T_{anneal} and at least first part of the soaking taking place in an oxidizing atmosphere so as to produce an iron oxide top layer with a thickness between 100 and 600 nm, said iron oxide layer being then fully reduced.

18. Method according to claim 17 wherein, such reduction takes places during the second part of the soaking, in a reducing atmosphere containing between 2% and 35% of H₂ and having a dew point under -10°C, so as to fully reduce said iron oxide layer, the steel sheet being further cooled at a cooling rate $V_{cooling2}$ above 5°C/s and below 70°C/s down to room temperature.

19. Method according to claim 18, wherein the second part of the soaking takes place in an atmosphere which dew point is under -30°C.

20. Method according to anyone of claims 17 to 19, wherein:

- the steel sheet is cooled down at $V_{cooling2}$ to a temperature T_{OA} between 350°C and 550°C and kept at T_{OA} for a time between 10 and 300 seconds and then
- the steel sheet is further cooled at a cooling rate $V_{cooling3}$ of 5°C/s to 70°C/s down to room temperature.

21. Method according to claims 17 or 20 wherein, such reduction takes places after cooling of said steel sheet at a cooling rate $V_{cooling2}$ above 5°C/s and below 70°C/s down to room temperature and is done by chemical pickling.

22. Method of manufacturing a metallic coated steel sheet according to anyone of claims 17 to 21, comprising the steps of coating done by a process chosen among hot dip coating, electrodeposition and vacuum coating, possibly followed by a heat-treatment.

23. Method according to claim 22, wherein such metallic coated steel sheet undergoes a galvannealing heat treatment.

24. Method according to anyone of claims 17 to 23, wherein said hot rolled strip is obtained by a process comprising the following steps:

- casting steel which composition is according to claims so as to obtain a slab,
- reheating the slab at a temperature T_{reheat} between 1100°C and 1300°C,
- hot rolling the reheated slab at a temperature between 800°C and 1250°C to obtain a hot rolled steel strip,
- cooling the hot rolled steel strip at a cooling speed $V_{cooling1}$ of at least 10°C/s until the coiling temperature $T_{coiling}$ lower or equal to 700°C,
- coiling the hot rolled strip cooled at $T_{coiling}$.

25. Method according to claim 24, wherein the hot rolled steel strip is further annealed using a process chosen among batch annealing between 400°C and 600°C between 1 and 24 hours and continuous annealing between 650°C and 750°C between 60 and 180s.

26. Vehicle comprising a structural part made out of a steel sheet according to anyone of claims 1 to 16.

Patentansprüche

1. Kaltgewalztes Stahlblech, in Gewichtsprozenten umfassend:

$0,1 \leq C \leq 0,5\%$
 $3,5 \leq Mn \leq 10,0\%$
 $Al \leq 9,0\%$
 $Si \leq 5,0\%$
 $0,5 \leq Si+Al \leq 9,0\%$
 $Ti \leq 0,2\%$
 $V \leq 0,2\%$
 $Nb \leq 0,2\%$
 $B \leq 0,0035$
 $Cr \leq 1\%$
 $S \leq 0,004\%$
 $P \leq 0,025\%$,

wobei der Rest der Zusammensetzung Eisen und unvermeidbare Verunreinigungen ist, die aus dem Schmelzen resultieren, und die Mikrostruktur 10% bis 50% Austenit, 25% bis 90% Ferrit, weniger als 5% an Kappa Fällungsprodukten und weniger als 25% Martensit enthält, wobei das Blech von der oberen Fläche her die aufeinanderfolgenden Schichten aufweist:

- eine Deckschicht aus reinem metallischen Eisen, dessen Dicke zwischen 50 und 300 nm liegt, und
- eine erste Unterschicht aus metallischem Eisen, die auch ein oder mehrere Fällungsprodukte von Oxiden, ausgewählt aus Mn, Si, Al, Cr und B enthält, dessen Dicke zwischen 1 und 8 μm liegt.

2. Kaltgewalztes Stahlblech nach Anspruch 1, außerdem eine zweite, aus reinem Ferrit hergestellte Unterschicht umfassend, die unter der ersten Unterschicht liegt, und deren Dicke zwischen 10 und 50 μm liegt.

3. Kaltgewalztes Stahlblech nach Anspruch 1 oder 2, wobei die Stahlzusammensetzung einen Mangangehalt von 5 bis 9% aufweist.

4. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 3, wobei die Stahlzusammensetzung einen Kohlenstoffgehalt von 0,1 bis 0,3% aufweist.

5. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 4, wobei die Stahlzusammensetzung einen Kohlenstoffgehalt von 0,15 bis 0,25% aufweist.

6. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 5, wobei die Stahlzusammensetzung einen Aluminiumanteil von 1,5 bis 9% aufweist.

7. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 6, wobei die Stahlzusammensetzung einen Aluminiumanteil von 5 bis 8% aufweist.

8. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 7, wobei die Stahlzusammensetzung einen Siliziumgehalt gleich oder weniger als von 1,5% aufweist.

9. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 8, wobei die Stahlzusammensetzung einen Siliziumgehalt gleich oder weniger als von 0,3% aufweist.

10. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 9, wobei die Stahlmikrostruktur zwischen 25% und 40% Austenit enthält.

11. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 10, wobei die Stahlmikrostruktur zwischen 50% und 85% Ferrit enthält.

12. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 11, wobei die Stahlmikrostruktur zwischen weniger als 15% Martensit enthält.
13. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 12, wobei die Strahlmikrostruktur keine Kappa Fällungsprodukte enthält.
14. Kaltgewalztes Stahlblech nach einem der Ansprüche 1 bis 13 mit einer Zugfestigkeit TS größer oder gleich 1000 - 50 x %Al in MPa, einer gleichmäßigen Dehnung UEI größer oder gleich 15% und einer Lochaufweitung HE größer oder gleich 20%.
15. Metallisch beschichtetes Stahlblech, das durch Beschichten eines kaltgewalzten Stahlblechs nach einem der Ansprüche 1 bis 14 erhalten wird, wobei das Beschichten mittels eines Verfahrens durchgeführt wird, das ausgewählt ist aus Feuerbeschichten, Galvanisieren und Vakuumbeschichten, möglicherweise gefolgt von einer Wärmebehandlung.
16. Metallisch beschichtetes Stahlblech nach einem der Ansprüche 1 bis 15, wobei das Blech verzinkt ist.
17. Verfahren zum Herstellen eines kaltgewalzten Stahlblechs nach Ansprüchen, umfassend die folgenden Schritte:
 - Zuführen und Entzundern eines heißgewalzten Streifens oder eines dünnen Blocks mit einer Zusammensetzung nach den Ansprüchen 1 bis 9,
 - Kaltwalzen des heißgewalzten Streifens oder dünnen Blocks mit einem Kaltwalzverhältnis zwischen 30% und 75%, um so ein kaltgewalztes Stahlblech zu erhalten,
 - Wärmebehandeln des Stahlblechs, das einem Aufheizen bei einer Heizgeschwindigkeit $H_{\text{geschwindigkeit}}$ mindestens gleich 1°C/s bis zu einer Glühtemperatur T_{anneal} , die zwischen $T_{\text{min}}=721-36^{\circ}\text{C}-20^{\circ}\text{C}\cdot\text{Mn}+37^{\circ}\text{C}\cdot\text{Al}+2^{\circ}\text{C}\cdot\text{Si}$ (in $^{\circ}\text{C}$) und $T_{\text{max}}=690+145^{\circ}\text{C}-6,7^{\circ}\text{C}\cdot\text{Mn}+46^{\circ}\text{C}\cdot\text{Al}+9^{\circ}\text{C}\cdot\text{Si}$ (in $^{\circ}\text{C}$) liegt, während 30 bis 700 Sekunden, gefolgt von einer Wässerung bei dieser Temperatur, wobei das Aufheizen von 550°C bis zu T_{anneal} und mindestens ein erster Teil des Wässerns in einer oxidierenden Atmosphäre stattfinden, um so eine Eisenoxiddeckschicht mit einer Dicke zwischen 100 und 600 nm zu erzeugen, wobei die Eisenoxidschicht dann vollständig reduziert ist.
18. Verfahren nach Anspruch 17, bei dem eine solche Reduktion während des zweiten Teils des Wässerns bei einer reduzierenden Atmosphäre stattfindet, die zwischen 2% und 35% H_2 enthält und einen Taupunkt unter -10°C aufweist, um so die Eisenoxidschicht vollständig zu reduzieren, wobei das Stahlblech außerdem bei einer Kühlgeschwindigkeit V_{cooling2} über 5°C/s und unter 70°C/s auf Raumtemperatur abgekühlt wird.
19. Verfahren nach Anspruch 18, bei dem der zweite Teil des Wässerns bei einer Atmosphäre stattfindet, deren Taupunkt unter -30°C liegt.
20. Verfahren nach einem der Ansprüche 17 bis 19, bei dem:
 - das Stahlblech bei V_{cooling2} auf eine Temperatur T_{OA} zwischen 350°C und 550°C abgekühlt wird und bei T_{OA} für eine Zeit zwischen 10 und 300 Sekunden gehalten wird, und dann
 - das Stahlblech weiter bei einer Kühlgeschwindigkeit V_{cooling3} von 5°C/s auf 70°C/s auf Raumtemperatur abgekühlt wird.
21. Verfahren nach den Ansprüchen 17 oder 20, bei dem eine solche Reduktion nach dem Abkühlen des Stahlblechs bei einer Kühlgeschwindigkeit V_{cooling2} über 5°C/s und unter 70°C/s auf Raumtemperatur abgekühlt wird und durch chemisches Beizen ausgeführt wird.
22. Verfahren zum Herstellen eines metallisch beschichteten Stahlblechs nach einem der Ansprüche 17 bis 21, die Schritte des Beschichtens umfassend, das mit einem Verfahren ausgeführt wird, ausgewählt aus Feuerbeschichten, Galvanisieren und Vakuumbeschichten, möglicherweise gefolgt von einer Wärmebehandlung.
23. Verfahren nach Anspruch 22, wobei ein solches metallisch beschichtetes Stahlblech einer Verzinkungswärmebehandlung unterzogen wird.
24. Verfahren nach einem der Ansprüche 17 bis 23, bei dem der heißgewalzte Streifen durch ein Verfahren mit den folgenden Schritten erhalten wird:

- Gießen von Stahl, dessen Zusammensetzung entsprechend den Ansprüchen ist, um so einen Block zu erhalten,
- Wiederaufheizen des Blocks bei einer Temperatur T_{reheat} zwischen 1100°C und 1300°C,
- Heißwalzen des wiederaufgeheizten Blocks bei einer Temperatur zwischen 800°C und 1250°C, um einen heißgewalzten Stahlstreifen zu erhalten,
- Abkühlen des heißgewalzten Strahlstreifens bei einer Kühlgeschwindigkeit V_{cooling1} von mindestens 10°C/s bis zu der Wickeltemperatur T_{coiling} kleiner oder gleich 700°C,
- Wickeln des heißgewalzten, auf T_{coiling} gekühlten Streifens.

25. Verfahren nach Anspruch 24, bei dem der heißgewalzte Stahlstreifen außerdem mittels eines Verfahrens gegläht wird, das ausgewählt ist aus Haubenglühen zwischen 400°C und 600°C zwischen 1 und 24 Stunden und kontinuierlichem Glühen zwischen 650°C und 750°C zwischen 60 und 180 s.

26. Fahrzeug, ein Strukturteil aus einem Stahlblech entsprechend einem der Ansprüche 1 bis 16 umfassend.

Revendications

1. Tôle en acier laminée à froid comprenant, en pourcentage en poids :

- $0,1 \leq C \leq 0,5\%$
- $3,5 \leq Mn \leq 10,0\%$
- $Al \leq 9,0\%$
- $Si \leq 5,0\%$
- $0,5 \leq Si + Al \leq 9,0 \%$
- $Ti \leq 0,2 \%$
- $V \leq 0,2\%$
- $Nb \leq 0,2\%$
- $B \leq 0,0035$
- $Cr \leq 1\%$
- $S \leq 0,004\%$
- $P \leq 0,025 \%$

le reste de la composition étant du fer et des impuretés inévitables résultant de la fusion, et la microstructure contient de 10 % à 50 % d'austénite, de 25 % à 90 % de ferrite, moins de 5 % de précipités Kappa et moins de 25 % de martensite, ladite tôle présentant à partir de la surface supérieure les couches successives suivantes :

- une couche supérieure de fer métallique pur dont l'épaisseur est située dans la plage de 50 à 300 nm et
- une première sous-couche fabriquée à partir de fer métallique qui contient également un ou plusieurs précipités d'oxydes choisis parmi Mn, Si, Al, Cr et B, dont l'épaisseur est située dans la plage de 1 à 8 μm .

2. Tôle en acier laminée à froid selon la revendication 1, comprenant en outre une deuxième sous-couche, située en dessous de ladite première sous-couche, constituée de ferrite pure, dont l'épaisseur est située dans la plage de 10 à 50 μm .

3. Tôle en acier laminée à froid selon la revendication 1 ou 2, la composition d'acier ayant une teneur en manganèse de 5,0 à 9,0 %.

4. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 3, la composition d'acier ayant une teneur en carbone de 0,1 à 0,3 %.

5. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 4, la composition d'acier ayant une teneur en carbone de 0,15 à 0,25 %.

6. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 5, la composition d'acier ayant une teneur en aluminium de 1,5 à 9 %.

7. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 6, la composition d'acier ayant une teneur en aluminium de 5 à 8 %.

8. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 7, la composition d'acier ayant une teneur en silicium inférieure ou égale à 1,5 %.
- 5 9. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 8, la composition d'acier ayant une teneur en silicium inférieure ou égale à 0,3 %.
10. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 9, la microstructure en acier contenant entre 25 et 40 % d'austénite.
- 10 11. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 10, la microstructure en acier contenant entre 50 et 85 % de ferrite.
12. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 11, la microstructure en acier contenant moins de 15 % de martensite.
- 15 13. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 12, la microstructure en acier ne contenant pas de précipités Kappa.
14. Tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 13, présentant une résistance à la traction TS supérieure ou égale à $1000 - 50 \times \% \text{ d'Al}$ en MPa, un allongement uniforme UEI supérieur ou égal à 15 % et un essai K.W.I supérieur ou égal à 20 %.
- 20 15. Tôle en acier à revêtement métallique obtenue par revêtement d'une tôle en acier laminée à froid selon l'une quelconque des revendications 1 à 14, un tel revêtement étant effectué par un procédé choisi parmi le dépôt en bain fondu, le dépôt électrolytique et le revêtement sous vide, éventuellement suivi d'un traitement thermique.
- 25 16. Tôle en acier à revêtement métallique selon l'une quelconque des revendications 1 à 15, dans laquelle ladite tôle est recuite après galvanisation.
- 30 17. Procédé de fabrication d'une tôle en acier laminée à froid selon les revendications, comprenant les étapes suivantes :
 - apport et décalaminage d'une bande laminée à chaud ou d'une brame mince dont la composition est selon les revendications 1 à 9,
 - laminage à froid de la bande laminée à chaud ou de la brame mince avec un rapport de laminage à froid situé
 - 35 entre 30 % et 75 % de manière à obtenir une tôle en acier laminée à froid,
 - traitement thermique de la tôle en acier qui subit un chauffage, à une vitesse de chauffage C_{vitesse} au moins égale à 1 °C/s, jusqu'à la température de recuit T_{recuit} située entre $T_{\text{min}} = 721 - 36^{\circ}\text{C} - 20^{\circ}\text{C} \cdot \text{Mn} + 37^{\circ}\text{C} \cdot \text{Al} + 2^{\circ}\text{C} \cdot \text{Si}$ (en °C) et $T_{\text{max}} = 690 + 145^{\circ}\text{C} - 6,7^{\circ}\text{C} \cdot \text{Mn} + 46^{\circ}\text{C} \cdot \text{Al} + 9^{\circ}\text{C} \cdot \text{Si}$ (en °C) pendant 30 et 700 secondes suivi d'un trempage à ladite température, le chauffage de 550 °C jusqu'à T_{recuit} et au moins la première partie du trempage ayant
 - 40 lieu dans une atmosphère oxydante afin de produire une couche supérieure d'oxyde de fer ayant une épaisseur située entre 100 et 600 nm, ladite couche d'oxyde de fer étant alors complètement réduite.
18. Procédé selon la revendication 17 dans lequel une telle réduction a lieu pendant la deuxième partie du trempage, dans une atmosphère réductrice contenant entre 2 % et 35 % de H₂ et ayant un point de rosée en dessous de - 10 °C, de manière à complètement réduire ladite couche d'oxyde de fer, la tôle en acier étant en outre refroidie à une
- 45 vitesse de refroidissement $V_{\text{refroidissement2}}$ supérieure à 5 °C/s et inférieure à 70 °C/s jusqu'à la température ambiante.
19. Procédé selon la revendication 18, dans lequel la deuxième partie du trempage a lieu dans une atmosphère dont le point de rosée est inférieur à -30 °C.
- 50 20. Procédé selon l'une quelconque des revendications 17 à 19, dans lequel :
 - la tôle en acier est refroidie à $V_{\text{refroidissement2}}$ jusqu'à une température T_{OA} située entre 350 °C et 550 °C et maintenue à T_{OA} pendant une durée située entre 10 et 300 secondes puis
 - 55 - la tôle en acier est en outre refroidie à une vitesse de refroidissement $V_{\text{refroidissement3}}$ de 5 °C/s à 70 °C/s jusqu'à la température ambiante.
21. Procédé selon les revendications 17 ou 20 dans lequel une telle réduction a lieu après refroidissement de ladite

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tôle en acier à une vitesse de refroidissement $V_{\text{refroidissement}2}$ supérieure à 5 °C/s et inférieure à 70 °C/s jusqu'à la température ambiante et est effectuée par décapage chimique.

5 **22.** Procédé de fabrication d'une tôle en acier à revêtement métallique selon l'une quelconque des revendications 17 à 21, comprenant les étapes de revêtement effectuées par un procédé choisi parmi le dépôt en bain fondu, le dépôt électrolytique et le revêtement sous vide, éventuellement suivi d'un traitement thermique.

10 **23.** Procédé selon la revendication 22, dans lequel une telle tôle en acier à revêtement métallique subit un traitement thermique de recuit après galvanisation.

24. Procédé selon l'une quelconque des revendications 17 à 23, dans lequel ladite bande laminée à chaud est obtenue par un procédé comprenant les étapes suivantes :

- 15
- coulage d'un acier dont la composition est selon les revendications de manière à obtenir une brame,
 - réchauffage de la brame à une température $T_{\text{réchauffage}}$ située entre 1 100 °C et 1 300 °C,
 - laminage à chaud de la brame réchauffée à une température située entre 800 °C et 1 250 °C pour obtenir une bande d'acier laminée à chaud,
 - refroidissement de la bande d'acier laminée à chaud à une vitesse de refroidissement $V_{\text{refroidissement}1}$ d'au moins 10 °C/s jusqu'à une température de bobinage T_{bobinage} inférieure ou égale à 700 °C,
 - 20 - bobinage de la bande laminée à chaud refroidie à T_{bobinage} .

25 **25.** Procédé selon la revendication 24, dans lequel la bande d'acier laminée à chaud est en outre recuite à l'aide d'un procédé choisi parmi le recuit en bobine entre 400 °C et 600 °C, entre 1 et 24 heures, et le recuit continu entre 650 °C et 750 °C, entre 60 et 180 s.

30 **26.** Véhicule comprenant une pièce structurale fabriquée à partir d'une tôle en acier selon l'une quelconque des revendications 1 à 16.

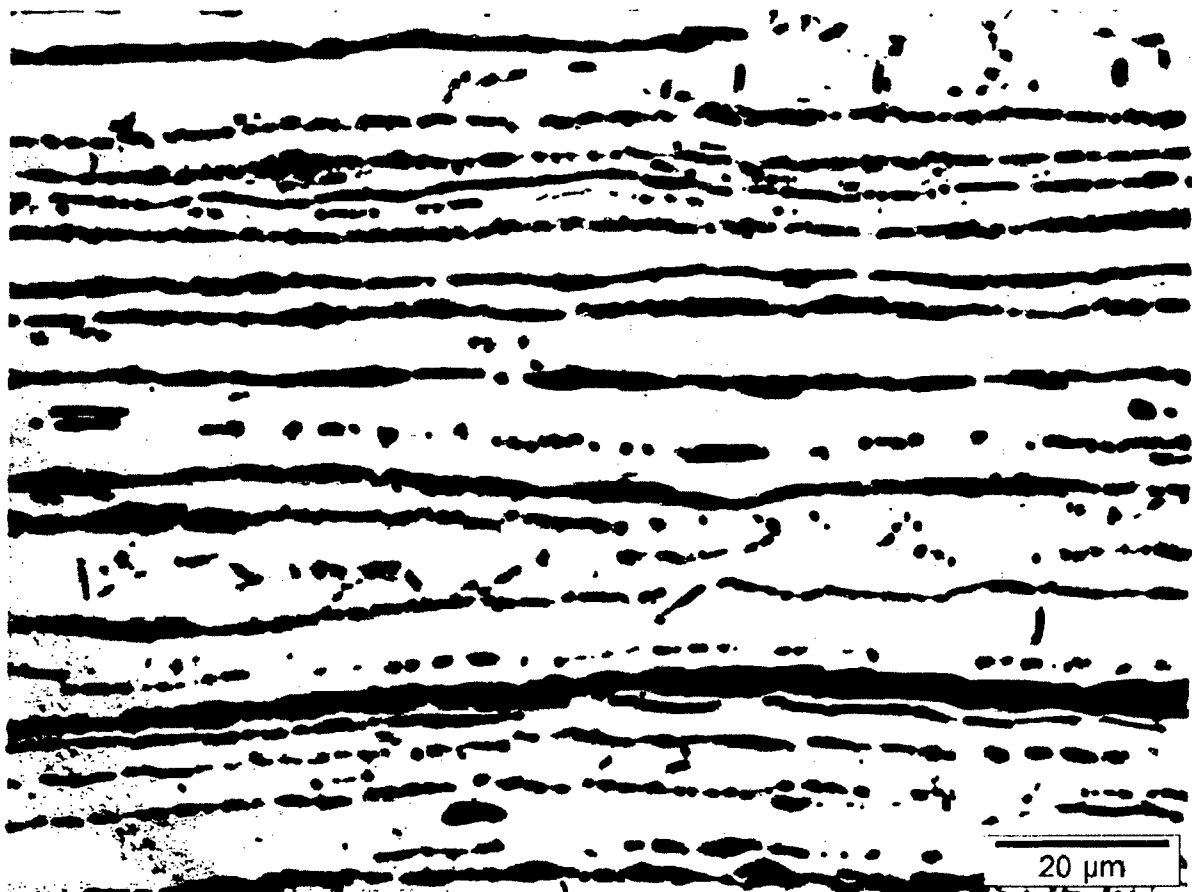


Figure 1

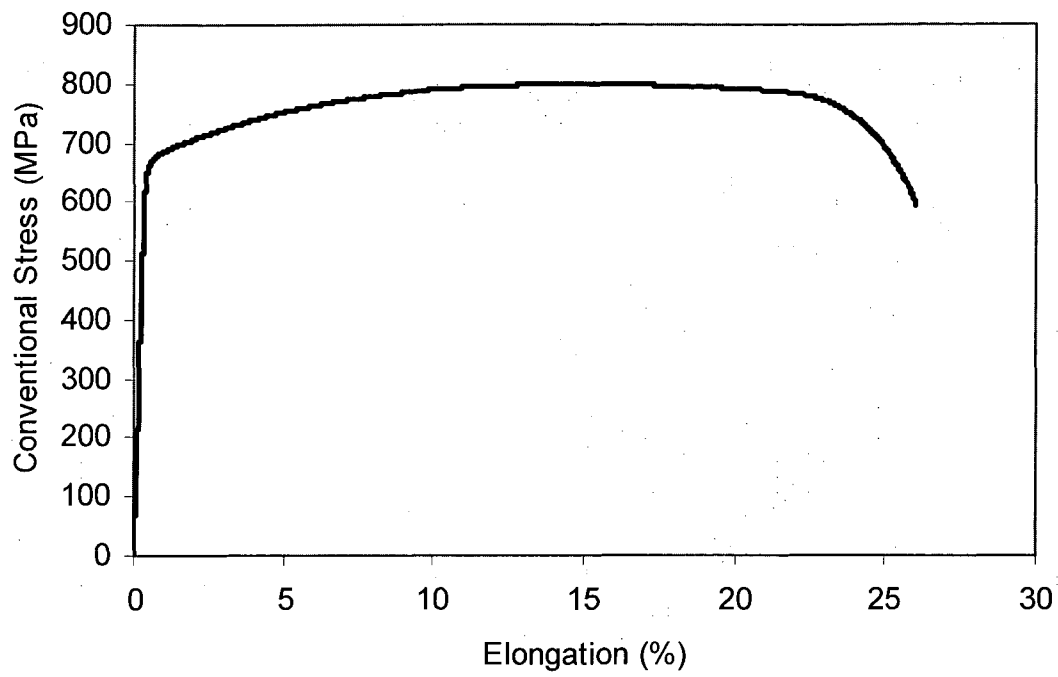


Figure 2

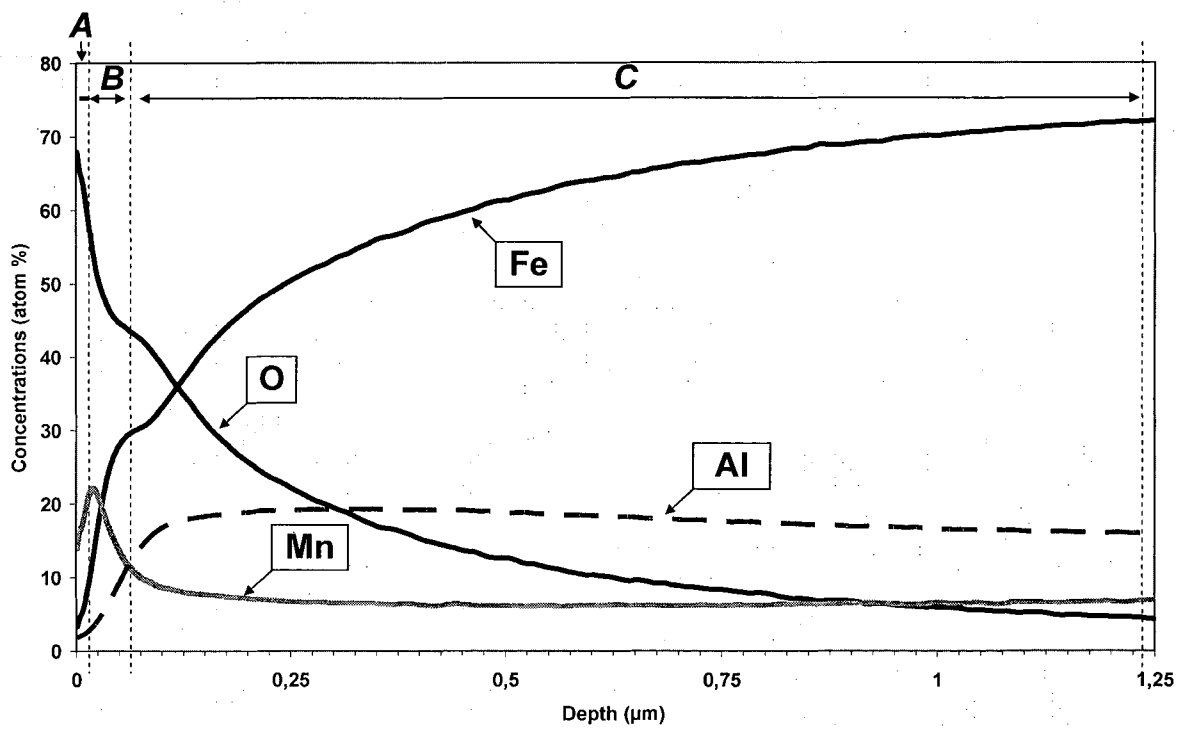


Figure 3

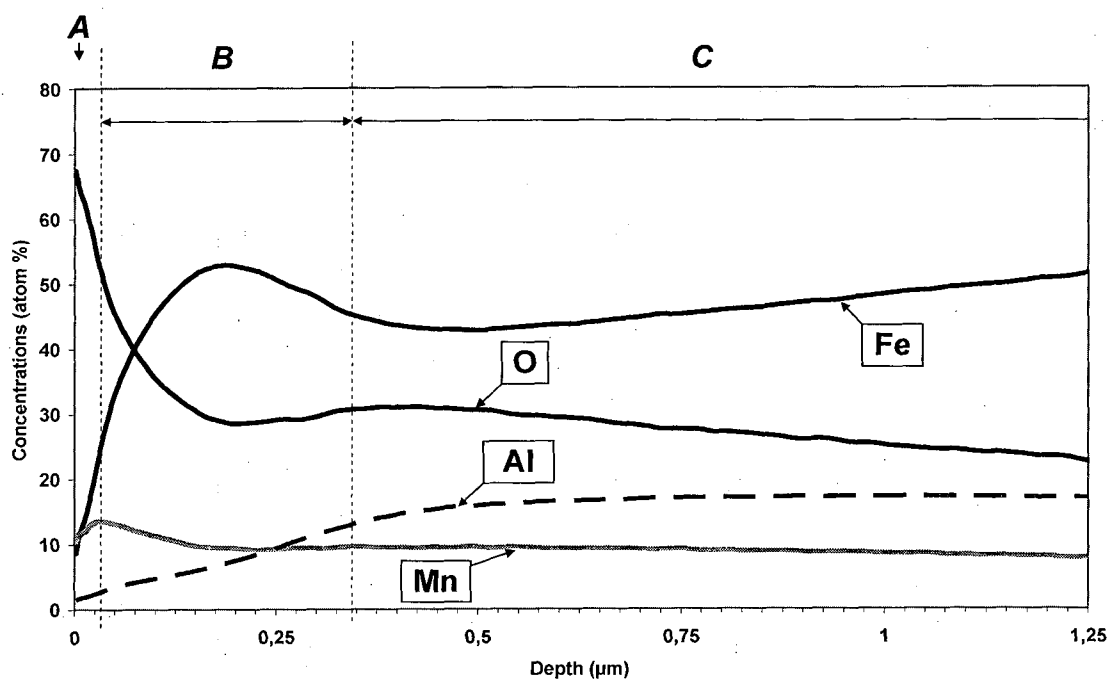


Figure 4

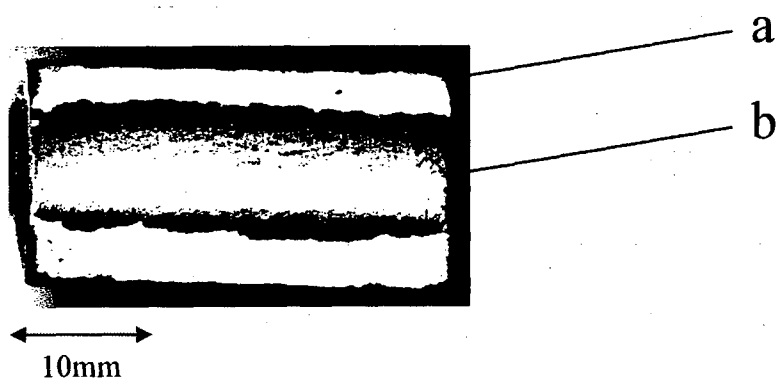


Figure 5

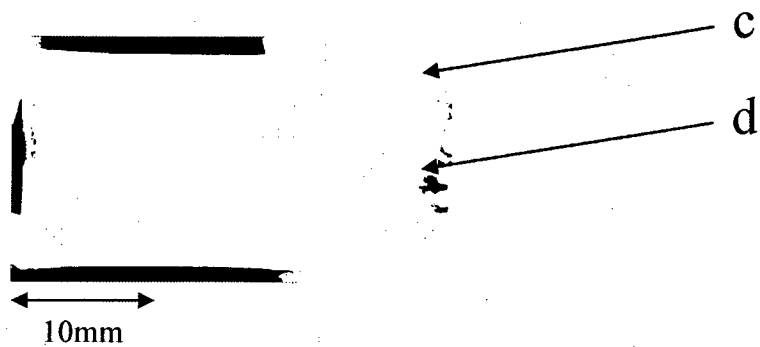


Figure 6

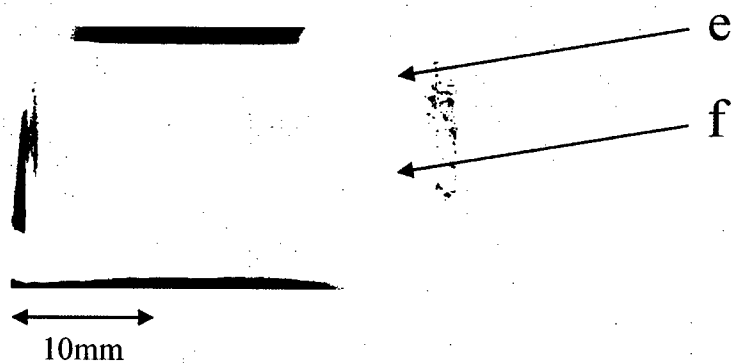


Figure 7

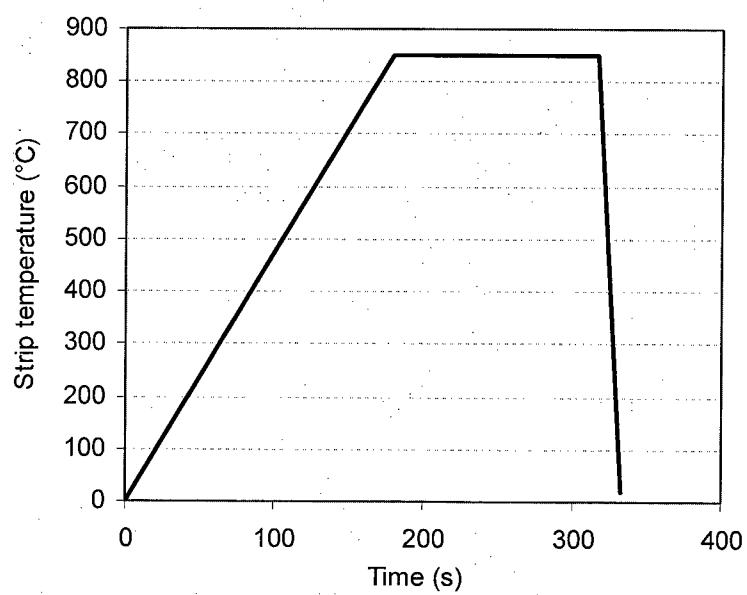


Figure 8

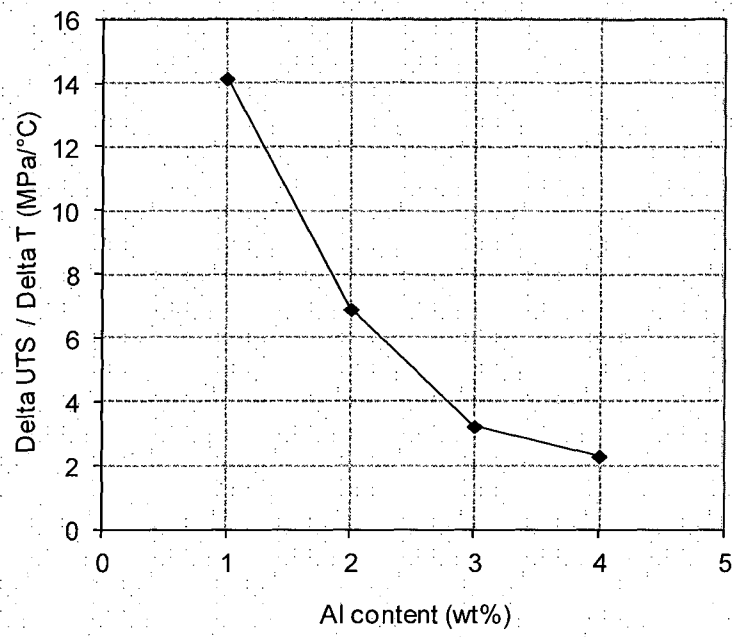


Figure 9

REFERENCES CITED IN THE DESCRIPTION

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- WO 2009142362 A [0009]
- WO 2012147898 A [0010]
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SZABADALMI IGÉNYPONTOK



1. Hidegen hengerelt acéllemez, amely tömegszázalékban a következőket tartalmazza:

$$0,1 \leq C \leq 0,5\%$$

$$3,5 \leq Mn \leq 10,0\%$$

$$Al \leq 9,0\%$$

$$Si \leq 5,0\%$$

$$0,5 \leq Si+Al \leq 9,0\%$$

$$Ti \leq 0,2\%$$

$$V \leq 0,2\%$$

$$Nb \leq 0,2\%$$

$$B \leq 0,0035$$

$$Cr \leq 1\%$$

$$S \leq 0,004\%$$

$$P \leq 0,025 \%$$

az összetétel maradéka vas, és az olvasztásból származó elkerülhetetlen szennyeződések, továbbá a mikroszerkezet 10% és 50% közötti mennyiségű ausztenit, 25% és 90% közötti mennyiségű ferritet, kevesebb mint 5% kappá kiválásokat, és kevesebb mint 25% martenzitet tartalmaz, és az említett lemez a felületétől számítva sorban a következő rétegekből áll:

- tiszta fémvas legfelső réteg, amelynek vastagsága 50 és 300 nm között van, és
- fémvas első alsó réteg, amely egy vagy több oxid kiválást tartalmaz, amely a mangánt, szilíciumot, alumíniumot, krómot és bór tartalmazó oxidcsoportból van kiválasztva, és amelynek vastagsága 1 és 8 μ m között van.

2. Az 1. igénypont szerinti hidegen hengerelt acéllemez, amely továbbá tartalmaz egy második alsó réteget, amely az első alsó réteg alatt helyezkedik el, és tiszta ferritből áll, és amelynek vastagsága 10 és 50 μ m között van.
3. Az 1 vagy 2. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél összetételében a mangántartalom 5,0 és 9,0 % között van.
4. Az 1-3. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél összetételében a karbontartalom 0,1 és 0,3 % között van.
5. Az 1-4. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél összetételében a karbontartalom

0,15 és 0,25 % között van.

6. Az 1-5. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél összetételében az alumíniumtartalom 1,5 és 9 % között van.
7. Az 1-6. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél összetételében az alumíniumtartalom 5 és 8 % között van.
8. Az 1-7. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél összetételében a szilíciumtartalom egyenlő vagy kisebb, mint 1,5 %.
9. Az 1-8. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél összetételében a szilíciumtartalom legfeljebb 0,3 %.
10. 1-9. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél mikroszerkezete 25 és 40 % közötti mennyiségű ausztenitet tartalmaz.
11. Az 1-10. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél mikroszerkezete 50 és 85 % közötti mennyiségű ferritet tartalmaz.
12. Az 1-11. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél mikroszerkezete kevesebb mint 15 % martenzitet tartalmaz.
13. Az 1-12. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, ahol az acél mikroszerkezete nem tartalmaz kappa kiválásokat.
14. Az 1-13. igénypontok bármelyike szerinti hidegen hengerelt acéllemez, amelynek szakítószilárdsága TS egyenlő vagy nagyobb, mint $1000 + 50 \times AL\%$, MPa-ban kifejezve, továbbá egyenletes nyúlása UEI egyenlő vagy nagyobb, mint 15%, és öblösödése HE egyenlő vagy nagyobb, mint 20 %.
15. 1-14. igénypontok bármelyike szerinti hidegen hengerelt acéllemez bevonásával nyert fémbevonatú acéllemez, ahol a bevonat a tűzi bevonatképzést, a galvanizálást és a vákuumpárológatást tartalmazó csoportból kiválasztott előjárással alakítjuk ki, adott esetben ezt követő hőkezelést is alkalmazva.
16. Az 1-15. igénypontok bármelyike szerinti fémbevonatú acéllemez, ahol a lemez galvanizálás során lágyított lemez.
17. Eljárás az igénypontok szerinti hidegen hengerelt acéllemez gyártására, amelynek során a következő lépéseket hajtjuk végre:
 - az 1-9. igénypontok bármelyike szerinti összetételű melegén hengerelt szalagot vagy laposbugát adagolunk és revéltlenítünk,
 - a melegén hengerelt szalagot vagy laposbugát hidegen hengereljük, ahol a hengerelési fogyás 30 és 75 % között van úgy, hogy hidegen hengerelt acéllemezt kapunk,
 - az acéllemezt legalább $1\text{ }^{\circ}\text{C/s}$ H hevítési sebességgel hevítjük T_{legyen} hőmérsékletig, amely a $T_{\text{min}}=721-36^{\circ}\text{C}\cdot 20\cdot\text{Mn}+37^{\circ}\text{C}\cdot\text{Al}+2^{\circ}\text{C}\cdot\text{Si}$ ($^{\circ}\text{C}$ -ban kifejezve) és $T_{\text{max}}=690+145^{\circ}\text{C}\cdot 6,7\cdot\text{Mn}+46^{\circ}\text{C}\cdot\text{Al}+9^{\circ}\text{C}\cdot\text{Si}$ ($^{\circ}\text{C}$ -ban kifejezve) között

tákszik, 30 és 700 másodperc közötti hőntartással, amelyet követően az említett hőmérsékleten hőntartjuk, és a hevítés 550 °C-tól $T_{\text{hőgyűlése}}$ hőmérsékletig tart, és legalább a hőntartás első szakasza oxidáló atmoszférában megy végbe úgy, hogy vasoxid felületi réteget hozunk létre, amelynek vastagsága 100 és 600 nm közötti van, és az említett vas-oxid réteget ezt követően teljesen redukáljuk.

18. A 17. igénypont szerinti eljárás, ahol a redukálás a hőntartás második szakaszában megy végbe, redukáló atmoszférában, amely 2 % és 35 % közötti mennyiségű H_2 hidrogén tartalmaz, és harmatpontja -10 °C alatt van úgy, hogy teljesen redukáljuk a vasoxid réteget, és az acéllemezt ezt követően szobahőmérsékletre hűtjük $V_{\text{hűtés}}$ sebességgel, amely nagyobb mint 5 °C/s és kisebb mint 70 °C/s.
19. A 18. igénypont szerinti eljárás, ahol a hőntartás második szakasza olyan atmoszférában megy végbe, amelynek harmatpontja -30 °C alatt van.
20. A 17-19. igénypontok bármelyike szerinti eljárás, ahol
 - az acéllemezt $V_{\text{hűtés}}$ sebességgel T_{OA} hőmérsékletre hűtjük, amely 350 °C és 550 °C között van, és T_{OA} hőmérsékleten tartjuk 10 és 300 másodperc közötti hőntartási idővel, majd ezt követően
 - az acéllemezt tovább hűtjük szobahőmérsékletre $V_{\text{hűtés}}$ sebességgel, amely 5 °C/s és 70 °C/s között van.
21. A 17. vagy 20. igénypontok szerinti eljárás, ahol a redukációt az acéllemez szobahőmérsékletre hűtését követően hűtjük végre $V_{\text{hűtés}}$ sebességgel amely nagyobb mint 5 °C/s és kisebb mint 70 °C/s, majd ezt követően vegyszerrel pácoljuk.
22. A 17-21. igénypontok bármelyike szerinti fémbevonatú acéllemez gyártására szolgáló eljárás, amelynek során a bevonatot a tűzi bevonatkészítést, a galvanizálást, és a vákuumpárológatást tartalmazó csoportból kiválasztott eljárással alakítjuk ki, adott esetben ezt követő hőkezelést is alkalmazva.
23. A 22. igénypont szerinti eljárás, ahol a fémbevonatú acéllemez galvanizálás során lágított lemez.
24. A 17-23. igénypontok bármelyike szerinti eljárás, ahol a melegen hengerelt szalagot a következő lépésekből álló eljárással állítjuk elő:
 - az igénypontok szerinti összetételű acélbugát öntünk.
 - a bugát 1100 °C és 1300 °C közötti $T_{\text{gyűlése}}$ hőmérsékletre visszahevítiük,
 - a visszahevített bugát 800 °C és 1200 °C közötti hőmérsékleten melegen hengerelt acélzalaggá meleghengereljük,
 - a melegen hengerelt acélzalagot legalább 10 °C/s $V_{\text{hűtés}}$ sebességgel legfeljebb 700 °C $T_{\text{tekeredési}}$ tekereselési hőmérsékletre lehűtjük,
 - a melegen hengerelt, és $T_{\text{hűtés}}$ sebességre lehűlt szalagot tekereseljük.
25. A 24. igénypont szerinti eljárás, ahol a melegen hengerelt acélzalagot tovább lágítjuk a következő eljárások közül kiválasztott eljárással: szakaszos lágítás 400 °C és 600 °C közötti hőmérsékleten, 1 és 24 óra közötti hőntartással, illetve folyamatos lágítás 650 °C és 750 °C közötti hőmérsékleten 60 és 180s közötti hőntartással.
26. Járma, amely az 1-16. igénypontok bármelyike szerinti acéllemezről kialakított szerkezeti elemet tartalmaz.