● Series rolled from CC-blooms
○ Series rolled from CC-beam blank

Profile before pass rolling

Fig. 4 New rolling method of B.B. from slabs

Table 1 Summary of the application of new B. B. rolling method from slabs for large H-shapes

3.2.2 Application of partial web method

As a result of practical use of the partial web

width actively. At this time the blank is not constrained by the side walls of the pass, but is guided only by the belly.

(3) Belly groove crossing rolling

Since the non-reduced portion constrains elongation in the rolling direction at this time, deformation due to reduction is centered on width spread-

of H-shapes. As a result of this investigation it was possible to obtain deformation characteristics which will be useful background information in determining

(4) Flange spreading rolling

5.1.2 Deformation characteristics of stationary

(2) Difference between roll with belly and flat roll

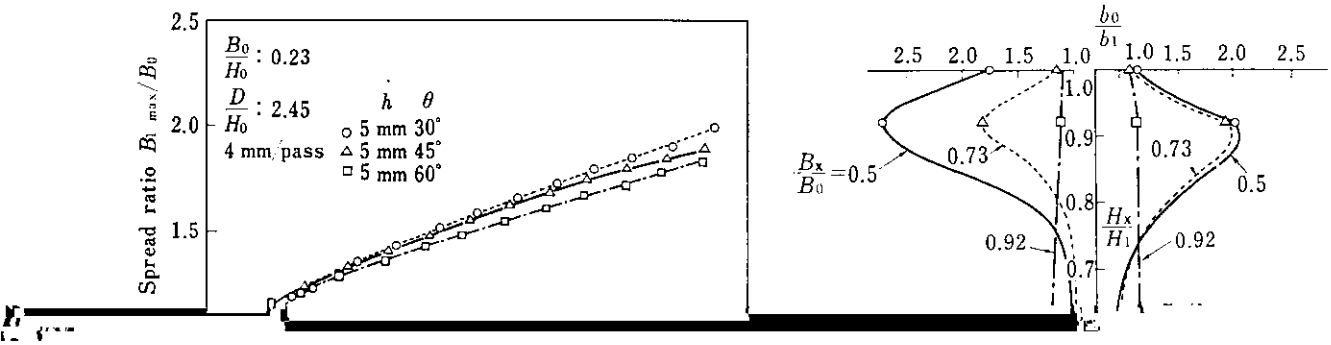

Fig. 14 Influence of θ on spread ratio after rolling

B_x : Distance from surface along the through-width direction before rolling

during the experiment, the following was observed:

Table 2 Pass schedule of partial web rolling

web rolling

0	T_0	180	931	Edging rolling (E.R.)

affect changes in shapes during partial web rolling

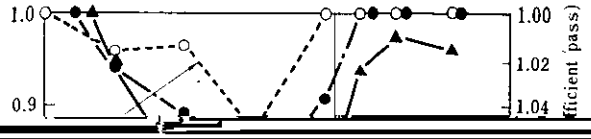

Table 3 An example of elongation coefficient (λ_T) at each rolling

	Partial web rolling		Finish

(3) Enhancement of prime product obtainable ratio

slab method has made such a machine

As a result of improvement on accuracy of materials weight and reduction in defective products

sary.

caused by defective materials, the achieving ratio of the plan for proper matching of products with

7 Conclusion

With the development of the slab method based