

METHOD OF PRODUCING STEEL SHEET PILE, AND ROLLING
EQUIPMENT LINE FOR PRODUCING STEEL SHEET PILE

ABSTRACT

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The present invention provides a method of producing a high-height large steel sheet pile. Using a rolling equipment line in which a heating device, a roughing rolling mill, an intermediate rolling mill, and a
10 finishing rolling mill are disposed in this order, a material is heated and a plurality of caliber rolling passes are performed to obtain a steel sheet pile of a predetermined shape. In this event, in the intermediate rolling, rolling is performed using an engraved caliber
15 so that the shape of a flange portion after the intermediate rolling takes a first shape that is curved or bent outward. This makes it possible to reduce the depth of a caliber to engrave, suppress a reduction in the transverse rupture strength of a roll, and increase
20 the range of use of the roll. Then, in the finish rolling following the intermediate rolling, the bending forming is performed so that the flange portion of the first shape takes a rectilinear shape or a second shape that is curved or bent inward.

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(Fig. 7A)