

ASYMMETRICAL STEEL SHEET PILE AND
METHOD FOR MANUFACTURING THE SAME

Abstract

5 An asymmetric steel sheet pile and a process for its
production as well as a corner sheet pile for this sheet
pile and a process for its production are disclosed. The
joints of the sheet pile wall are placed on the same plane
as that of flat arm portions, and the joints do not protrude
from the plane. Asymmetric sheet piles having well-shaped
10 bilateral joints can be produced with no instability of
rolling position and imperfect bending of the joints.

 The bilateral asymmetric joints, i.e., an inward joint
and outward joint, are subjected to finish bending one by
one using different grooved rolls for each joint. While one
15 joint is subjected to finish bending, the other joint is
restrained and is not subjected to bending or is only
subjected to intermediate bending.

 The corner sheet pile can be produced by changing the
fixing position of either the outward joint or the inward
20 joint of the asymmetric sheet pile to an oppositely facing
position. Alternatively, the corner sheet pile can be
produced by bending inwardly with respect to the sheet pile
either the inward joint or the outward joint.

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