Basic understanding of tertiary rolled in scale

Good example to explain the importance of temperature

Basic understanding of tertiary rolled in scale generation

Tertiary rolled in scale = f (strip surface temperature, roll surface roughness)

Strip surface temperature here generally means temperature <u>after FSB till F3 or F4</u>

Roll surface roughness means regular roughness, partial banding or small comet-like scoop.

Basic concept of tertiary rolled in scale

Roll surface roughness

F
E
D

Rolled in scale region

C

Good surface region

B
A

Strip surface temperature

A: Fish scale type scale

B: HSS roll type fish scale

C: Scattered sand scale or salt and pepper scale

 D: Band scale

E: Comet scale

F: Roll mark type scab