

Title (en)

METHOD OF OPERATING A CONTINUOUS CASTING PLANT AND A BILLET-OXYGEN CUTTING MACHINE FOR CARRYING OUT THE SAME

Publication

**EP 0213389 B1 19891227 (DE)**

Application

**EP 86110343 A 19860726**

Priority

DE 3531041 A 19850830

Abstract (en)

[origin: EP0213389A2] 1. Method for operating a continuous casting plant with a flame-cutting machine for separating cast pieces, in which measurement data, such as billet width, billet thickness and cross-sectional billet shape, are acquired at the flame-cutting machine, while taking account of the pouring temperature, pouring speed, homogeneity over the moving billet length, billet surface defects and relative material density, and evaluated in a computing and control device, the values for an optimizing control of the continuous casting plant, on the one hand for immediate operation and on the other for long-term optimization, are made available and the values obtained are fed into the actual flame-cutting machine, for cutting off a workpiece of a desired length corresponding exactly or almost exactly to a certain workpiece weight, characterised in that, in order to divide the billet without wastage, a first billet piece, which is determined with conventional safety allowances, is measured and separated by the flame-cutting machine as a calibration workpiece and that the temperature, homogeneity and shape deviations, which are known from the latter, from a weight/length ratio which takes account of the ideal case, are fed into the flame-cutting machine as a calibration value for programming a new piece length for the purpose of separating a second billet piece.

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