

Title (en)
Method and apparatus for continuous casting.

Title (de)
Verfahren und Vorrichtung zum Stranggießen.

Title (fr)
Procédé et appareil de coulée continue.

Publication
EP 0218855 A1 19870422 (DE)

Application
EP 86111710 A 19860823

Priority
DE 3533517 A 19850920

Abstract (en)
1. Method for continuous casting in a continuous-casting mould having a mould cap (22) whose inner wall, while forming an overhang (8), protrudes beyond the inner wall of the continuous-casting mould, in which method the inner wall of the continuous-casting mould is cooled and lubricated, a gas under pressure, such as air, nitrogen or inert gas being fed at the overhang (8) of the mould cap (22) together with lubricant into the shaped hollow space into the continuous-casting mould, and a dummy block being used during casting, characterized in that a vacuum is produced in the gap between dummy block and mould running surface (7), and in that the parting compound and/or lubricant and the gas, before entry into the shaped hollow space of the continuous-casting mould (1), is mixed in a volumetric ration of 1-4:1000 while forming a gas/oil mist, and this mixture, starting at the overhang of the mould cap (22), is blown out in the discharge direction parallel to and along the mould running surface (7), a laminar flow being maintained.

Abstract (de)
Die Erfindung betrifft ein Verfahren zum Stranggießen in einer Stranggießkokille (1) mit einem Kokillenaufsatz (22) dessen Innenwandung unter Bildung eines Überhanges (8) über die Innenwandung der Stranggießkokille vorsteht, bei dem die Innenwandung der Stranggießkokille gekühlt und geschmiert wird, wobei ein unter Druck stehendes Gas wie Luft, Stickstoff oder Inertgas am Übergang des Kokillenaufsatzes in den Formhohlraum (15) in die Stranggießkokille eingeleitet wird. Das Trenn- und/oder Schmiermittel und das Gas wird vor dem Eintreten in den Formhohlraum der Stranggießkokille in einem Volumen-Verhältnis von 1 - 4 : 1000 vermischt und diese Mischung wird ausgehend vom Überhang des Kokillenaufsatzes in Abzugsrichtung parallel zur und entlang der Kokillenauflfläche (7) ausgeblasen.

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Citation (search report)
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