Title (en)

METHOD AND APPARATUS FOR THE OSCILLATION OF A CONTINUOUS-CASTING MOULD

Publication

EP 0325931 B1 19920422 (DE)

Application

EP 89100324 A 19890110

Priority

CH 30588 A 19880128

Abstract (en)

[origin: JPH01224155A] PURPOSE:To improve the quality of a strand surface in continuous casting for steel by arranging mechanism for adjusting stroke corresponding to strand drawing speed. CONSTITUTION:During substantially the whole descending movement, in sawtooth oscillation, which mold speed excesses the strand drawing speed, and the first range of the low strand drawing speed to about 0.8-1.2m/min, number of the oscillation is increased at first from about 60-120cpm to 120-200cpm and on the other hand, negative strip time (tn) 1a held to about 0.1sec. Further, at the time of increasing the strand drawing speed excessing 0.8-1.2m/min, number of the oscillation is held to the constant in a second range and during increasing the oscillation stroke corresponding to the strand drawing speed, the negative strip time (tr) is held to about 0.1sec. Therefore, by a reason on the production, for example, related to the prescribed production cycle time, the strand drawing speed has to be changed. By this adjustment, the improved strand surface can be obtd. during the continuous casting.

IPC 1-7

B22D 11/04

IPC 8 full level

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CPC (source: EP KR US)

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Cited by

AT517006B1; FR2704788A1; US5823245A; EP0570935A1; US5350005A; EP0564316A1; FR2689045A1; DE19823361A1; GB2313798A; GB2313798B; CN1072046C; WO0030783A1; WO9425201A1; WO9959749A1; WO9627466A1

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