

Title (en)

Method for baiting liquid metal on rolls in continuous casting and installation for carrying out this method.

Title (de)

Verfahren zum Einleiten von flüssigem Metall auf eine Walze beim Strangguss und Verfahren zu seiner Durchführung.

Title (fr)

Procédé d'amorçage d'une coulée continue de métal liquide sur un cylindre et dispositif pour sa mise en oeuvre.

Publication

**EP 0435800 A1 19910703 (FR)**

Application

**EP 90470071 A 19901206**

Priority

FR 8917194 A 19891226

Abstract (en)

[origin: JPH04127938A] PURPOSE: To provide a method for chilled roll which is small in the roughness of a roll surface and is capable of making operation even when a lead angle is insufficient for starting casting by making the lead angle relatively large at the start of the casting and gradually displacing a caisson so as to diminish this lead angle after the start of the casting. CONSTITUTION: Even if the caisson exists in any relative position to the roll, an important requirement is to maintain the specified angle  $\alpha$  of inclination formed by the surface of the roll 1 and a front end wall 5 in order to surely prevent the leakage at the contact point of the upper end edge 11 of the caisson 4 and the roll 1. For this purpose, the assembly of the caisson and the roll is prevented from being displaced when the assembly rotates about an arbitrary horizontal axis. This horizontal axis may be aligned to the axis X of the roll itself like an example shown in Fig. In such a case, a bridge 10 for rigid connection of a sleeve 12 which is mounted freely turnably about the axis X on the outer side of the roll and the bottom of the caisson 4 is disposed. The angular position of the caisson is adjusted by a drive cylinder fixed 13 fixed to the floor. The free end 14 of the piston rod of the drive cylinder 13 is joint connected to the outer end on the side of the bottom of the case opposite to the front end wall 5.

Abstract (fr)

L'invention concerne un procédé d'amorçage d'un dispositif de coulée continue de métal liquide, notamment d'acier, sur un cylindre refroidi (1) tournant autour de son axe horizontal. Un caisson adjacent (4) contient le métal à couler et présente une paroi frontale (5) dont le bord supérieur libre (11) est surbaissé pour permettre la sortie du métal à couler, et que vient lécher la surface refroidie du cylindre (1). Selon l'invention, l'amorçage de la coulée s'effectue avec un angle d'attaque (A) relativement élevé et, lorsque la coulée est amorcée, on déplace le caisson par pivotement autour d'un axe horizontal qui peut être l'axe de rotation du cylindre, de manière à diminuer l'angle d'attaque pour parvenir en une position nominale de travail (4') où le caisson est maintenu fixe. Application à la coulée continue d'acier en bandes minces. <IMAGE>

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IPC 8 full level

**B22D 11/06** (2006.01)

CPC (source: EP US)

**B22D 11/064** (2013.01 - EP US)

Citation (search report)

- [Y] DE 3627196 A1 19870219 - NIPPON YAKIN KOGYO CO LTD [JP], et al
- [Y] PATENT ABSTRACTS OF JAPAN vol. 12, no. 126 (M-687)(2973), 19 avril 1988; & JP - A - 62252645 (HITACHI) 04.11.1987
- [A] PATENT ABSTRACTS OF JAPAN vol. 11, no. 356 (M-644)(2803), 20 novembre 1987; & JP - A - 62134147 (KAWASAKI STEEL) 17.06.1987

Designated contracting state (EPC)

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DOCDB simple family (application)

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