

Title (en)  
Method for continuous casting of metals.

Title (de)  
Verfahren zum Stranggiessen von Metallen.

Title (fr)  
Procédé de coulée continue de métal.

Publication  
**EP 0560024 A2 19930915 (DE)**

Application  
**EP 93100834 A 19930121**

Priority  
DE 4203337 A 19920206

Abstract (en)  
In a method for the continuous casting of metals, especially aluminium or aluminium alloys, in a multi-mould casting installation, disturbances in the progress of casting are to be compensated for immediately so that optimum bar quality is obtained. This is achieved, according to the invention, by feeding in a pressurised gas and a lubricant underneath the hot top of each mould via at least one gas line, a regulating valve for setting the volume flow of gas, a downstream pressure sensor and a device for measuring the said volume flow being arranged in each gas line. It is furthermore envisaged, according to the invention, that the volume flow of gas in each gas line be automatically held constant at a predetermined value, irrespective of the respective filling level of the mould, in a first casting phase from the beginning of the filling of the mould with molten metal to a point in time following the entry of the metal strand into the water-cooled zone. During a second casting phase, the volume flow of gas in each gas line is automatically regulated in such a way that the gas pressure in each gas line is held constant at a predetermined value.

Abstract (de)  
Ein Verfahren zum Stranggießen von Metallen, insbesondere von Aluminium oder Aluminiumlegierungen, in einer Mehrfachkokillengießanlage, wobei jede Kokille mit einem Heißkopfaufsatz versehen ist, und in den Kokillenformhohlraum unterhalb des Heißkopfaufsatzes ein unter Druck stehendes Gas und ein Schmiermittel eingeleitet wird.

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