

Title (en)
Method for continuous casting

Title (de)
Verfahren zum Stranggiessen

Title (fr)
Procédé de coulée continue

Publication
EP 0564316 B1 19960626 (FR)

Application
EP 93400675 A 19930316

Priority
FR 9203906 A 19920331

Abstract (en)
[origin: EP0564316A1] The invention applies to continuous casting of steel in a mould with cooled walls, which is driven in oscillatory movement with travel h and frequency f , for producing a product leaving the mould at a casting speed V_c , the metal being topped with a lubricant forming liquid slag, the downward speed of the ingot mould being greater than the casting speed V_c during a crust-forming time t_N . According to the invention, without altering the nature of the lubricant, it is possible to adjust the casting speed V_c over a wide range in order to adapt to specified casting conditions, by acting in combination on the travel and on the frequency of the oscillations as a function of the chosen casting speed, so that, whatever the casting speed V_c , the rate Q of consumption of the lubricant and the crust-forming time t_N are each held at a substantially constant optimum value over the entire adjustment range of the speed. <IMAGE>

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