

Title (en)  
Improvements in and relating to casting

Title (de)  
Verbesserungen beim Giessen

Title (fr)  
Améliorations concernant la coulée

Publication  
**EP 0903192 A1 19990324 (EN)**

Application  
**EP 98307619 A 19980918**

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Abstract (en)  
The method involves a moulding stage for forming a partially solidified strand with a molten core, the partially solidified strand passing to a roller stage on leaving the moulding stage, the method comprising, at least during a portion of a casting cycle :- providing a first portion of the rolling stage with a reducing separation between rollers, thereby defining a volume occupied by the strand in that portion; changing the volume of the strand between the rollers in that portion by changing the position of one or more rollers; and providing a further portion of the rolling stage with a reducing separation between rollers. By varying the volume of the strand between the rollers in that portion the volume of the strand can be increased therein, for instance to move the zone of soft reduction away from the moulding stage, or alternatively to lower the level of the meniscus within the solidifying strand. Alternatively, the volume of the strand between the rollers in that portion can be decreased, for instance to move the zone of soft reduction towards the moulding stage, or alternatively to increase the level of the meniscus within the moulding stage. More accurate soft reduction and less wastage material during close down of a casting run result from the application of the invention. <IMAGE>

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**B22D 11/12**

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CPC (source: EP)  
**B22D 11/1206** (2013.01)

Citation (search report)  
• [X] DE 4436328 A1 19950420 - VOEST ALPINE IND ANLAGEN [AT]  
• [A] EP 0730924 A1 19960911 - SUMITOMO METAL IND [JP]  
• [A] EP 0611610 A1 19940824 - VOEST ALPINE IND ANLAGEN [AT]  
• [A] WO 9714522 A1 19970424 - SUMITOMO METAL IND [JP], et al  
• [A] PATENT ABSTRACTS OF JAPAN vol. 013, no. 441 (M - 876) 4 October 1989 (1989-10-04)

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