

Title (en)
METHOD AND DEVICE FOR PRODUCING THIN SLABS

Title (de)
VERFAHREN UND VORRICHTUNG ZUM ERZEUGEN VON DÜNNBRAMMEN

Title (fr)
PROCEDE ET DISPOSITIF POUR LA PRODUCTION DE BRAMES MINCES

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Application
EP 98936178 A 19980615

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• DE 9801633 W 19980615
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Abstract (en)
[origin: US2003150589A1] The invention relates to a process for producing thin slabs and to a continuous casting installation for this purpose, having a laterally adjustable mold into which an immersion nozzle protrudes, and in which there is opposite a larger crowned cross section on the charging side a cross section on the strand outlet side which is small and identically crowned in the central region, and having pairs of supporting and guiding rollers which follow the mold and have a caliber adapted to the emerging crowned strand. In this case, a) the immersion nozzle (11) has a spade-shaped mouth (13) with a maximum thickness (d) corresponding to $d=0.3$ to $0.5 \times DE$, where DE is the distance between the mold broad faces (21) in the charging region, b) the broad-face parts (21) have at least in the shadow region of the immersion nozzle (11) central parts (23) which are arranged parallel to one another according to their contour lines, c) the broad-face plates (21) are designed at least in the adjusting region of the narrow-face plates (22) as planar side surfaces (24, 25), d) the planar side surfaces (24, 25) are arranged such that they move conically toward each other in the direction of the narrow faces (22), e) the planar-surface central plate (23) is connected to the planar-surface side surfaces (24, 25) by transitional parts (26, 27), f) the transitional parts (26, 27) taper toward each other in the form of a wedge and the wedge tip (28) ends at a distance (a), measured from the upper edge of the mold, with $a=0.5$ to $0.8 \times L$, where L=the length of the mold, and g) the supporting and guiding rollers (41) have a contour which corresponds to the planar-surface central plate (23) and the planar side plates (24, 25) of the mold broad faces (21) in the region of the mouth of the mold.

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Cited by
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US 2003150589 A1 20030814; **US 6810943 B2 20041102**; AR 012755 A1 20001108; AT E249299 T1 20030915; AU 8531998 A 19990125; BR 9811275 A 20000718; DE 19728957 A1 19990107; DE 59809580 D1 20031016; EP 0996514 A1 20000503; EP 0996514 B1 20030910; KR 100573751 B1 20060424; KR 20010014325 A 20010226; TR 199903303 T2 20000721; TW 372204 B 19991021; WO 9901244 A1 19990114

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