

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

Publication  
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Application  
**EP 98936178 A 19980615**

Priority  
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• DE 19728957 A 19970630

Abstract (en)  
[origin: DE19728957A1] The invention relates to a method for producing thin slabs, and to a continuous casting device for use in the inventive method. Said continuous casting device has a mould with adjustable sides, a submerged nozzle projecting into said mould. Said mould has a evenly rounded cross-section which is small in the centre area at the exit end of the casting and a larger rounded cross-section opposite, at the pouring end. Support and guide roll pairs are located downstream from the mould and have a groove corresponding to the exiting rounded casting. The submerged nozzle (11) has a spade-shaped mouth (13) with a maximum thickness (d) corresponding to  $d = 0.3 \text{ to } 0.5 \times DE$ , DE being the spacing of the mould broad sides (21) in the pouring area. The mould broad side parts (21) have centre parts (23) at least in the shroud area of the submerged nozzle (11), said centre parts being arranged parallel to each other in relation to their contours. The broad side panels (21) are configured as even side faces (24, 25), at least in the adjustment area of the narrow side panels (22). Said even side surfaces (24, 25) are arranged so that they approach each other in a cone shape, in the direction of the narrow sides (22). The even-surfaced centre panel (23) is joined to the even-surfaced side faces (24, 25) by bridging parts (26, 27), said bridging parts (26, 27) forming a wedge shape in the casting direction of movement, tapering to a point where they meet, the tip of said wedge shape (28) finishing at a distance (A) measured from the top edge of the mould,  $a = 0.5 \text{ to } 0.8 \times L$ , L being the mould length. The contour of the support and guide rolls (41) corresponds with the even-surfaced centre panel (23) and the even side panels (24, 25) of the mould broad sides (21) in the mouth area of the mould.

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