

Title (en)

METHOD AND DEVICE FOR CASTING METAL CLOSE TO FINAL DIMENSIONS

Title (de)

VERFAHREN UND VORRICHTUNG ZUM ENDABMESSUNGSNAHEN GIESSEN VON METALL

Title (fr)

DISPOSITIF ET PROCEDE DE COULEE DE METAL, PROCHE DES COTES FINALES

Publication

**EP 1077782 B1 20011128 (DE)**

Application

**EP 99919121 A 19990319**

Priority

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- DE 19823440 A 19980519

Abstract (en)

[origin: US6363997B1] A method and a device for the casting of rectangular billets from metal, in particular from steel, close to final dimensions, and for the subsequent inline rolling out of the billet, with a material supply vessel, via the outlet nozzle of which the liquid metal is deposited onto the upper strand of a conveyor belt, on which it solidifies and is transferred to a roll stand for forming, characterized by the following steps:a) before the start of castingaa) the point at which the liquid metal is deposited onto the conveyor belt is predetermined approximately,ab) the conveying speed of the conveyor belt is set as a function of the desired rolling thickness and rolling speed of the roll stand,b) during castingba) the position of thorough solidification of the metal billet located on the conveyor belt is detected,bb) the temperature of the rolling stock is detected in the region of the roll stand, andbc) the position of thorough solidification and the temperature of the rolling stock are used as control variables for the current position of the point at which the liquid metal leaving the material supply vessel is deposited onto the conveyor belt.

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**B22D 11/06**

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CPC (source: EP KR US)

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