

Title (en)  
METHOD OF PRODUCING ROUND BILLETS

Title (de)  
VERFAHREN ZUR ERZEUGUNG VON RUNDEN KNÜPPELN

Title (fr)  
PROCEDE DE PRODUCTION DE BILLETES RONDES

Publication  
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Application  
**EP 99964428 A 19991207**

Priority  
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Abstract (en)  
[origin: WO0037200A1] The invention relates to a method and to a device for producing continuously cast billets in a production plant consisting of a vertical-type continuous casting machine for casting round billets which is provided with a horizontal discharge chute, at least one descaling device (3, 7) and a plurality of subsequent roll stands (5, 6). For producing round billets with a diameter ranging between 90 and 300 mm, the surface of the solidifying round billet is descaled once the billet leaves the ingot mold (1) and before it is fed to the subsequent rolling unit (5). The near-surface skin is precooled precisely to the temperature that is the optimum for the respective steel before the round billet is formed in at least three subsequent horizontal passes (5) and then in one vertical pass (6). The surface of the pre-formed billet is again descaled before the last pass (7).

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