

Title (en)

AUTOMATIC START METHOD AND DEVICE FOR CONTINUOUS CASTING SYSTEMS

Title (de)

VERFAHREN UND VORRICHTUNG ZUM AUTOMATISCHEN START VON STRANGGIESSANLAGEN

Title (fr)

PROCEDE ET DISPOSITIF POUR DEMARRER AUTOMATIQUEMENT DES INSTALLATIONS DE COULEE CONTINUE

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Application

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Abstract (en)

[origin: WO0172451A1] The invention relates to an automatic start method for continuous casting systems, preferably for strand thicknesses of 10 -150 mm and widths of up to 3.500 mm by regulating the casting level and by means of a closure system consisting of a slider system or a stopper system. In order to automatically start the continuous casting system, the following process data is detected: the temperature of the steel at the end of the treatment thereof in the secondary metallurgic range, T.LF (11); the heating-up time of the distributor before casting begins, t.T<0,5> (5.1); the inner distributor temperature after the distributor has been pre-heated, W.T (14), T.T (4); the weight of the steel in the distributor at the moment when the distributor is opened for casting to begin; the time required to fill the permanent mold, the time between the moment the permanent mold is opened and the strand (15) is removed; formation of a functional context for the product of T.LF (11), t.T<0,5> (5.1), W.T (14), for example; formation of the functional relationship between filling time (15) and the product from ((11) (5.1) (14)); establishment of the desired filling time (15) for all successive castings and determination of the weight of the steel in the distributor equivalent to the desired filling time when the temperature of the steel T.LF (11) is set in an uncontrolled manner; pre-heating time of the distributor t.T (5) and distributor temperature T.T (4) directly before the kettle is opened in order to fill the distributor.

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