

Title (en)  
METHOD FOR PRODUCING STEEL SLABS

Title (de)  
VERFAHREN ZUM ERZEUGEN VON BRAMMEN AUS STAHL

Title (fr)  
PROCEDE DE FABRICATION DE BRAMES D'ACIER

Publication  
**EP 1307309 B1 20040526 (DE)**

Application  
**EP 01955369 A 20010725**

Priority  
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• EP 0108577 W 20010725

Abstract (en)  
[origin: WO0211925A1] The invention relates to a method for producing steel slabs, whereby the strand leaves an ingot mold with melt enclosed by a strand shell and, in a strand guide located downstream, the opening width of guide rolls mounted in segments with upper and lower frames can be set in a continuous manner with successive steps by adjusting elements that join said guide rolls. An oscillation around a center line of the opening width serves to modify the opening width in order to render the dynamic influences on the guide rolls negligibly small. The amplitude of the opening width oscillation is set to a quantity, which does not provoke any plastic deformation of the strand shell. The actual opening width of the guide rolls is detected and the actuating force of the adjusting elements as well as the amplitude of the actuating force are determined at the same time. In the case of an increasing amplitude of the actuating force, the opening width is set to a predeterminable measure and/or guided in a pressure controlled manner via at least one adjusting element. A force/path diagram of the opening width setting is then determined from a multitude of force/path measurements along the strand. Said diagram is composed, in a chain-like manner, of a multitude of small force/path curves, which are each provided in the form of a hysteresis and which can be individually determined using an oscillation with a comparatively small amplitude.

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