

Title (en)
Method for commencing a casting process

Title (de)
Verfahren zum Starten eines Giessvorganges

Title (fr)
Procede pour debuter un procedure de coulee

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Abstract (en)
[origin: WO2004028725A1] The invention relates to a method for improving the conditions at the commencement of a casting process in a twin-roll casting device, which does not use a dummy bar, said method comprising the following steps: an operating casting thickness is set and the casting rolls are rotated at a casting-roll peripheral speed, which corresponds to a reduced commencing casting speed in relation to the casting speed for stationary operation; molten metal is fed into one of the rotating casting rolls and into the molten metal chamber that is configured from lateral plates lying against the rolls and a cast metal bar with an essentially constant, predetermined cross-sectional size is formed, whilst the casting speed is simultaneously increased to a strip forming casting speed; the casting speed is subsequently increased to a strip separating speed, which is significantly higher than the speed sufficient to cause solidification and the metal strip that has been cast up to this point is separated; the stationary operation casting speed is set; the following cast metal strip is deviated onto a strip transport unit and the stationary casting operation commences. The invention also relates to a twin-roll casting device for carrying out said method.

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