

Title (en)
Mold for continuous casting of metal

Title (de)
Kokille zum Stranggiessen von Metall

Title (fr)
Coquille pour la coulée continue de métaux

Publication
EP 1792675 B1 20101117 (DE)

Application
EP 06019527 A 20060919

Priority
DE 102005057580 A 20051130

Abstract (en)
[origin: EP1792675A2] A permanent chill mold (1) for the continuous casting of metal comprises a mold cavity (2) having a pouring slot (3), an exit opening (4) and a casting cone (6). At least one concave bulging (7) is provided that extends in the casting direction (G), which begins at a distance (A) below a predetermined casting bath level position (5) and extends up to the exit opening. The beginning of the concave bulging is in an initial region that extends 30-70 (preferably 50)% of the mold cavity length (L), measured from the pouring slot. The distance between the predetermined casting bath level position and the concave bulging is greater than 10 (preferably greater than 20)% of the length (L) of the mold cavity. Conicity at the deepest part of the concave bulging decreases down to at most 0% per meter. Conicity at edges of the bulgings decreases to 0.6-1.5% per meter. Adjacent bulgings form an undulating profile, and an imaginary center line of the undulating profile forms a determining optimum line for design of the permanent chill mold with regard to conicity. The concave bulging is produced at least partially by a depositing method. A contour of the concave bulging is produced at least partially by material removal.

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B22D 11/04 (2006.01)

CPC (source: EP KR US)
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