

Title (en)

METHOD AND VERTICAL CONTINUOUS CASTING SYSTEM FOR PRODUCING THICK SLABS FROM A METALLIC MELT

Title (de)

VERFAHREN UND VERTIKALSTRANGGIESSANLAGE ZUM HERSTELLEN VON DICKEN BRAMMEN AUS EINER METALLISCHEN SCHMELZE

Title (fr)

PROCÉDÉ ET INSTALLATION DE COULÉE CONTINUE VERTICALE PERMETTANT DE PRODUIRE DES BRAMES ÉPAISSES À PARTIR D'UNE MASSE DE MÉTAL FONDU

Publication

EP 2697010 B1 20150610 (DE)

Application

EP 12714654 A 20120405

Priority

- DE 102011016879 A 20110413
- EP 2012056285 W 20120405

Abstract (en)

[origin: WO2012139968A1] The invention relates to a method and to a vertical continuous casting system (1) for producing thick slabs from a metallic melt, wherein a steel strand having a core that is still liquid is cast in a vertical mold (2), is transported further in a subsequent strand guidance unit comprising a plurality of strand guidance segments (n1bis) having at least some strand guidance rollers (5; 5a, 5b) driven and/or applied therein, and is divided after complete solidification by a severing device (10) into slab lengths (11a), which are then discharged. In order to produce steel strands (11) having a thickness greater than 300 mm, in particular between 400 and 800 mm, and having format widths of 900 to 3200 mm, the deviation of the steel strand from the vertical is recorded, without supporting and guiding the completely solidified steel strand (11), in a system section (7) that follows the strand guidance unit, and the steel strand is bent back to the vertical by increasing or reducing the application forces and/or changing the positions of strand guide rollers (5a; 5b) upstream or downstream of the unsupported system section (7) before the steel strand (11) has reached the severing device (10).

IPC 8 full level

B22D 11/14 (2006.01); **B22D 11/128** (2006.01)

CPC (source: EP)

B22D 11/1281 (2013.01); **B22D 11/141** (2013.01)

Designated contracting state (EPC)

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

DOCDB simple family (publication)

WO 2012139968 A1 20121018; CN 103648687 A 20140319; CN 103648687 B 20161116; EP 2697010 A1 20140219; EP 2697010 B1 20150610; RU 2013150511 A 20150520; RU 2563388 C2 20150920; TW 201244849 A 20121116; TW I496633 B 20150821

DOCDB simple family (application)

EP 2012056285 W 20120405; CN 201280018142 A 20120405; EP 12714654 A 20120405; RU 2013150511 A 20120405; TW 101111768 A 20120403