

CONTENT

List of symbols and abbreviations	11
List of quantities and units	13
Introduction	15
1. Brief description of CCM parts	17
1.1. Ladle	18
1.2. Ladle shroud	19
1.3. Tundish	20
1.4. Submerged entry nozzle	21
1.5. Mold	24
2. Justification of the topicality and need for simulations of the steel casting process	25
2.1. Problems in the process of continuous steel casting	28
3. Basic principles of physical modelling of steel flow	30
4. Physical models of CCM parts (TUKE, IMTECH)	34
4.1. Physical model of USS CCM – Laboratory of Simulation of Flow Processes	34
4.2. Physical model of ŽP, a.s. tundish – SimConT Laboratory	37
4.2.1. Device control	39
4.2.1.1. Automatic functions	41
4.2.1.2. Manual mode	41
4.2.1.3. Control program output	42
4.2.2. Technical parameters	43
4.2.3. Methodology of measurement on physical models of CCM	43
5. Visualisation of the flow in the tundish	46
5.1. Residence time	48
6. Flow in the volume of the tundish	52
6.1. Plug volume	55
6.2. Dead zones	55
6.3. Non-isothermal conditions in the tundish	56

7. Use of impact pad in the tundish	60
8. Tundish as a refining reactor	65
8.1. Gas diffuser	69
9. Tundish slag	70
9.1. The role of slag in the tundish	70
9.2. Chemical composition	71
9.3. Degradation of tundish slag	72
10. Verification of physical model data against the actual CCM	74
10.1. Verification of three-strand T-shaped tundish water model data against the actual CCM – case study	74
10.2. Supplied data measured on the actual CCM	75
10.3. Change in tracer content in the well blocks of the actual CCM	77
11. Measurement of the transition region on the SimConT physical model	79
11.1. Verification of the F-curve – conclusion	83
12. Physical modelling of the tundish for casting of qualitatively demanding grades – case study	85
12.1. Description of tested configurations	92
12.2. Measured results	96
13. Effect of ladle shroud deflection	104
13.1. Deflection of the ladle shroud in the symmetrical two-strand tundish (boat type) – case study	104
13.2. Effect of ladle shroud deflection on the flow in the three-strand T-shaped tundish – case study	112
13.2.1. Summary of factors influencing the accuracy of the ladle shroud position in the tundish and proposals for measures	118
13.2.2. Discussion on the effect of the ladle shroud deflection on the flow of steel in the tundish	119
13.3. Partial conclusion on the effect of the ladle shroud deflection on the residence time	119

14. Effect of the ladle shroud length on the residence time of the tundish – case study	121
15. Effect of baffle design on the flow in the two-strand tundish (boat type) – case study	123
15.1. Partial conclusion on influencing the flow by baffle application	125
16. Optimising the internal design of the tundish	127
16.1. Deflection of holes in the baffle	128
16.2. Partial conclusion/discussion	131
17. Comparison of the flow in the tundish equipped with the Turbostop and the experimental swirling chamber – case study	132
17.1. Comparison of a swirling chamber with the Turbostop at two casting speeds	134
17.2. Partial conclusion on the comparison of the swirling chamber with the Turbostop	139
18. Analysis of transition zone formation – case study	140
18.1. Successive casting of grades with identical threshold chemical composition	140
18.2. Successive casting of grades with overlapping content of the transition element	142
18.3. Successive casting of grades with different content of the transition element	144
18.4. Experimental sequential casting of transition heats in operations with the holding time of 5 minutes per 35 tonnes in the tundish	146
18.5. Simulation of transition zone with different holding times at reduced steel level in the tundish – case study	148
18.5.1. .80/20 evaluation criterion	149
18.5.2. 90/10 evaluation criterion	153
18.6. Partial conclusion of the analysis of the formation of transition zones	157
19. Comparison of the flow when using a standard ladle shroud and a bell shroud (bell type)	158
19.1. Results	159

19.2. Partial conclusion	162
20. Modification of the inner shape of the tundish to reduce the weight of the ladle skull after the end of the sequence	163
20.1. Discussion on the measured results	170
20.2. Economic aspects	171
20.3. Partial conclusion	172
21. Comparison of steel flow when using spherical and standard impact pad	173
21.1. Results and their analysis	176
21.2. Partial conclusion	180
22. Special modification of the Spheric K4 spherical impact pad – case study	181
22.1. Partial conclusion	185
23. Overview of physical models in neighbouring countries	186
24. Conclusion	191
References	199