



博隆冶金技术工程有限公司

BOLONG METALLURGICAL TECHNOLOGY ENGINEERING CO., LIMITED

Professional Solution for Steel Melting Casting and Rolling Mill

BOLONG MACHINERY

WE PROVIDE STATE-TO-ART
TECHONOLOGIES,
MACHINERY, AUTOMATION
SYSTEM, PLANTS, SOLUTION
AND SERVICE TO STEEL AND
MEALUGGIRCAL INDUSTRY

R6m 2-machine 2-strand Hot Charging Square Billet Continuous Casting Machine Technical Proposal (Reserved to 3 Strands) For Contract No.: BL2023112534

BOLONG MACHINERY

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Technical Proposal for Arta Sanat Keshavarz Co.

1.连铸机主要技术参数

机型：全弧形连铸机

基本半径：R6

流间距：1250mm

流数：二机二流（预留一流）

铸坯断面： $120 \times 120 \text{ mm}^2 \sim 150 \times 150 \text{ mm}^2$
定尺： $\leq 12\text{m}$

代表钢种：

优质炭素结构钢

低合金结构钢

普碳钢

浇注方式：敞开浇铸

冷却方式：全水冷却

拉坯速度：

拉矫速度：0.4~4.0m/min（变频调速）

切割方式：自动火焰切割

引锭杆形式：刚性引锭杆

出坯方式：液压翻钢机+机械移钢机+滑轨冷床

1.CCM's Main tech data

Machine model:	Fully arc continuous casting machine
Basic radius:	R6/11m
Strand spacing:	1250mm
Strand quantity:	2-machine 2strand (Reserved one strand)
Cast billet's cross section:	125×125 mm ² , 150×150 mm ²
Cut-to-length:	≤12m
Steel quality :	Quality carbon structural steel Low alloy structural steel Common carbon steel
Casting method:	Open type casting
Type of cooling:	Full water cooling
Straightening speed:	0.4~4.0 m/min (frequency controls speed)
Cutting method:	Automatic flame cutting machine
Dummy bar method:	Rigid dummy bar
Billet out method:	Hydraulic billet filter+ mechanical billet transfer machine + slide rail cooling bed

2.整机目标保证值：

连铸坯合格率： ≥99.8%

坯形公差： 符合 YB2011—83

切口断面斜度： 5mm
定尺精度： ±10mm
铸坯质量： 符合 YB2011—83
合格坯年产量： 18~20ons/hour (150×150mm²)

2. Target value that can be ensured

Rate of qualified Billet: ≥99.8%
Tolerance on billet's external appearance:
in accordance with YB2011—83
Slope of cut cross section: 5mm
Cut-to-length precision: +/- 10mm
Billet quality: in accordance with YB2011—83
Qualified billet output: 18~20Tons/hour (for billet 150×150mm²)

3.连铸机主要单机设备技术性能及结构要求

3. CCM's main tech features and requirement's on structure

3.1 铸机钢结构设备 (买方自制)

CCM's steel structure equipment (Made by buyer)

3.1.1 钢结构浇铸平台 (买方自制)

Steel structure platform for casting(Made by buyer)

数量： 1 套

形式： 采用 H 型钢及钢板焊接结构。

特点：

*不依附于厂房柱的独立结构，避免厂房内行车运行等振动影响。

*振动及二冷装置的安装及维修方便。

*负载能力： 1.5t/m²

Quantity: 1set

Method: Adopting welded H section steel and steel plate.

Features :

*Independent structure not depending on factory building's column so that the oscillation from the cranes in the workshop will be avoided.

*Oscillation and secondary cooling device's re-assembling and maintenance is easy.

*Loading capacity platform, 1.5t/m²

3.1.2 引锭存放钢结构平台 (买方自制)

Steel structure platform for dummy bar storage (Made by buyer)

数量： 1 套

形式： 采用 H 型钢及钢板焊接结构。

特点:

*不依附于厂房柱的独立结构，避免厂房内行车运行等振动响。

*负载能力：

平台： 1.2t/m²

走道： 0.5t/m²

Quantity : 1 set

Type: adopting welded H section steel and steel plate.

Features:

*Independent structure not depending on factory building's column so that the oscillation from the cranes in the workshop will be avoided.

*Loading capacity:

Platform: 1.2t/m²

Walkway: 0.5t/m²

3.1.3 二冷室钢结构 (买方自制)

Secondary cooling room's steel structure (Made by buyer)

数量 : 1 套

特点 : 二冷室下部后墙及侧墙为钢筋砼结构 (由连铸土建施工) 。上部及前墙为钢板焊接结构

Quantity: 1 set

Features: the back wall and the side wall for the lower part of the secondary cooling room is made of concrete cement. It will be done by civil construction company. The wall for upper part and the front is of welded steel plate.

3.1.4 机旁走道及盖板 (买方自制) **Walkway and cover plate(Made by buyer)** 数量 : 1 套

形式 : 型钢支架、花纹钢盖板

负载能力 : 0.5t/m²

Quantity: 1 set

Features: section steel support, checkered cover plate

Loading capacity: 0.5t/m²

3.2 二冷蒸汽排放风机及管路 **Secondary cooling discharging fan and piping**

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3.2.1 二冷蒸汽排放管路 (买方自制)

Secondary cooling's discharging piping(Made by buyer)

数量：1套

形式:钢板焊接结构。包含管路支架，管路，冷凝水排放装置及防溅百叶窗。

Quantity: 1 set

Type: of welded steel plate structure. Including piping's support frame, piping, condensed water discharging device and splashing-proof blinds.

3.2.2 二冷蒸汽排放风机 Secondary cooling's discharging

fan 数量：1台

型式：离心通风机

材质：不锈钢

型号：4-72C，No.8C

电机功率：11KW

Quantity:1 set

Type: Centrifugal ventilation fan

Material: Stainless steel

Model: 4-72C，No.8C

Motor power: 11kw

3.3 浇铸设备 Casting equipment

3.3.1 钢包车 Ladle car

数量：2套

作用：采用移动的方式将满包钢水从接受位移动到浇铸位。

定位： 安装在浇铸平台的轨道上。

结构形式： 高低腿式

主要参数：

承载能力： 40t

轨距： 3000mm

运行速度： 20m/min

电机功率： 5.5kW×2

Quantity: 2 sets

Function: with moving ladle which is full of molten steel from receiving side to the casting side

Location: Installed on the rail of the casting platform

Structure form: high-and-low arm type

Main parameter :

Loading capacity: 40t

Rail distance: 3000mm

Running speed: 20m/min

Motor power: 5.5kW x2

3.3.2 中间罐 Tundish

数量： 2 只

结构形式： T 形；

主要参数：

容量： 13~15t（正常工作）。

钢水液面高度： ~750mm（正常工作）。

~850mm（溢流）。

中间罐钢水停留时间：10~12min。

结构及特点描述：

罐体为钢板焊接和机加工结构件。

中间罐由罐体、包盖组成。

确保获得合理的流场和温度。

包盖的设计能保证高效的烘烤和方便的钢水测温

Quantity: 2 pieces

Type: T-type

Main parameters:

Capacity : 13~15t (under normal work conditions)

Molten steel liquid level height: normally about 750mm.

Overflow: about 850mm

Molten steel retention time: 10~12min

Structure and features:

Tundish body is of welded steel plate and machined structural workpieces Tundish is composed of body and cover.

Make sure obtaining reasonable flow field and temperature.

The cover design can make sure high efficient baking and convenient molten steel temperature measurement.

结构说明：罐体为钢板焊接和机加工结构件。

Notes to the structure: the tundish body is of welded steel plate and

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machined structural work pieces.

3.3.3 摆罐) **Swinging trough**

数量：4 只

形式：钢板焊接结构

Quantity: 4 pieces

Type: Welded steel plate structure

3.3.4 事故罐 (**Emergency trough**

数量：1 个

形式：钢板焊接结构

Quantity: 1 pieces

Type: Welded steel plate structure

