COPPER MOULD TUBE

HOTION

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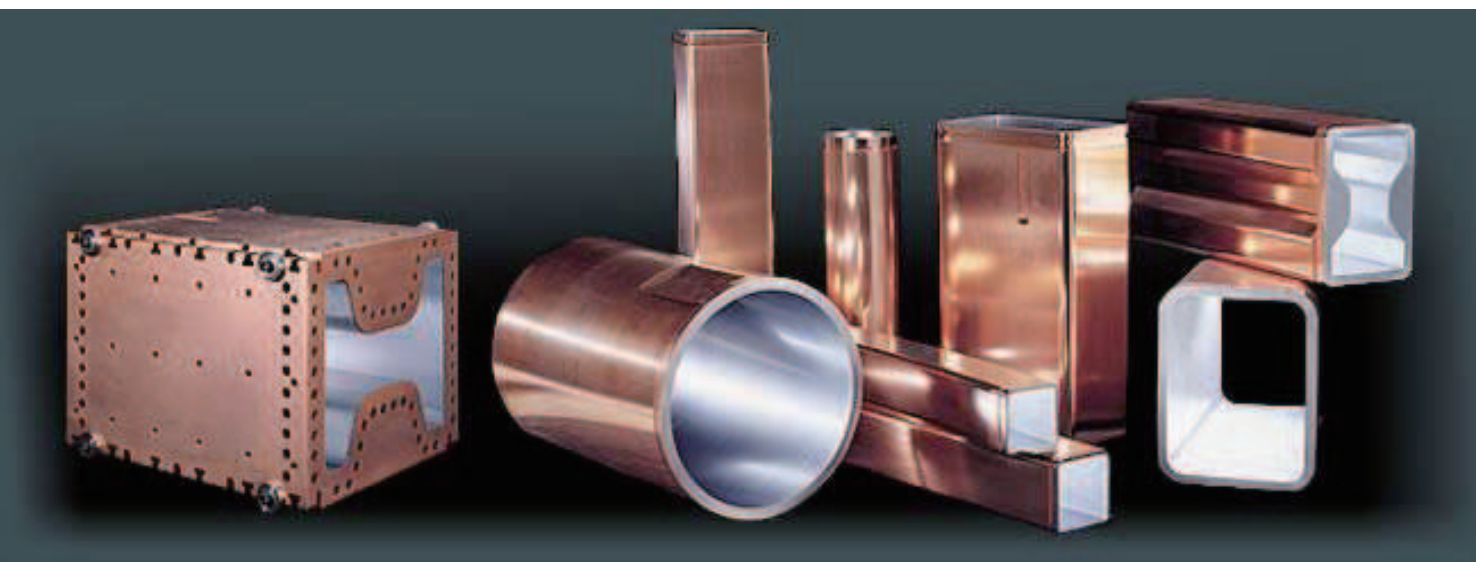

Copper mould tubes are the most consumables for the continuous casting lines. Our main products includes square, rectangular, round and beam blank copper mould tubes. With dedicated research of new technologies, we continuously develop various sizes, materials and special shapes, large and super large size mould tubes. We also developed various types of high efficiency copper mould tube for continuous casting machine.

All the products meet the standard of ISO 9001:2000 and environmental management certificate ISO 14001. Also we builds the internal internet management.

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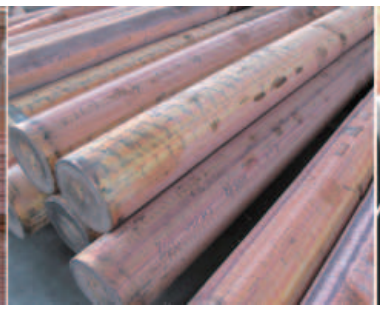
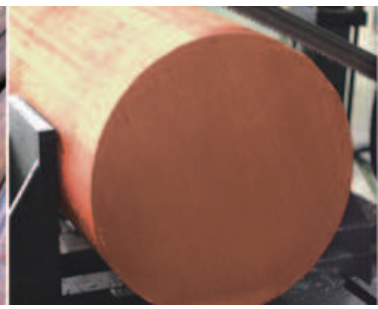
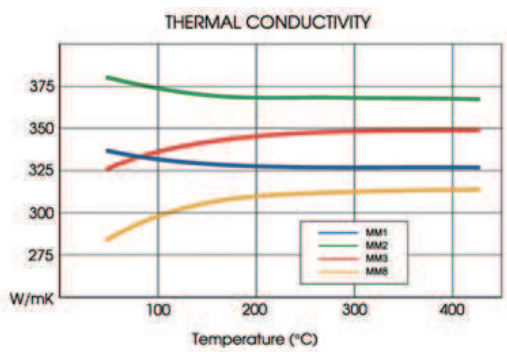
Material

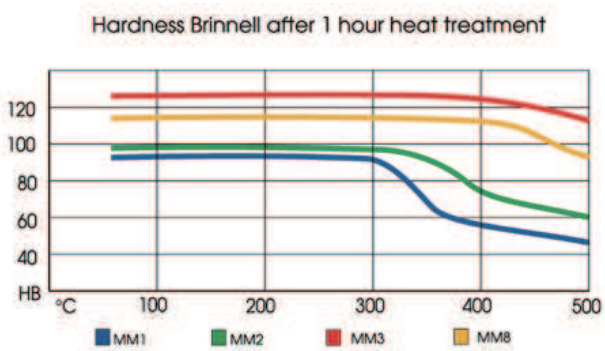



TP2 is a kind of material is selected by most of the steel plants.It shows excellent heat-proof and antifatigue property under high temperature and it has good processing property.

CuAg0.1 is adding 0.08%-0.12% silver during copper
ingots melting will increase the recrystallization temperature of copper by 100C, which will increase the heat stress and anti-abrasive property of copper mould tube interior surface, showing better heatresistant property than TP2.

Cu-Cr-Zr is a kind of copper allys which can be normalized by time.It has excellent mechanical property under both room temperature and hight temperature. It has hight heat conductivity, melting point, antifatigue and anti heat stress properties. Their outstanding features make it different from the previous copper alloys. It combines all good properties together. But compared with other copper alloys, Cu-CrZr is difficult to be formed with higher products costs.





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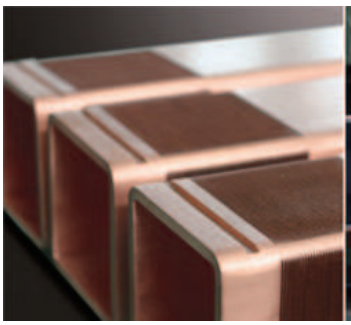
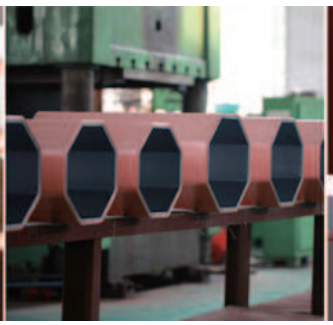
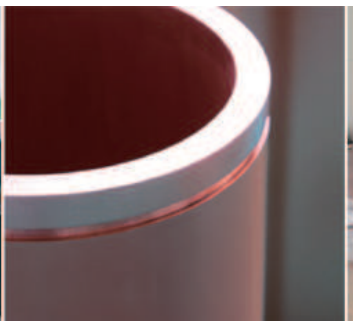
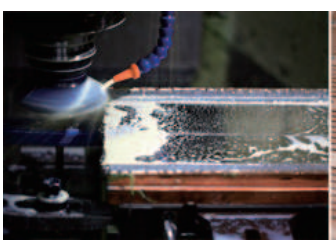
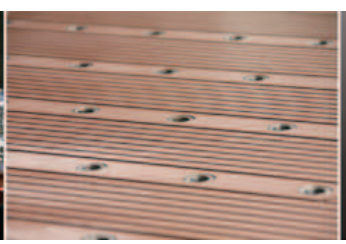
Mould Tubes

NAME	SIZE	CAMBER RADIUS	THICKNESS	LENGTH	REMARKS
Square & Rectangle Copper tubes	Square 50x50-650x650 Rectangle (100-500)x650	3000-17000 Also straight	6-50	602-1100	With slot single taper, double taper, triple taper, quadruplicate taper, parabolic taper and various kinds of continuous taper high effciency copper mould tubes
Round copper tubes	Φ110-Φ1500	5000-17000 Also straight	10-50	602-900	With slot double taper, quadruplicate taper, parabolic taper and various kinds of continuous taper high effciency copper mould tubes
Non-standard copper mould tubes Beam Blank copper mould tubes	535-150x120-70	6000-14000	12-50	700-1016	With slot single taper, double taper, triple taper, quadruplicate taper, parabolic taper

Mould Plates

COPPER PLATE SIZE	SPECIFICATION			MATERIAL	COATING
	LENGTH	WIDTH	THICKNESS		
Slab	350-3800	700-1000	30-75	Cr-Zr-Cu, CuAg	Ni-Co, Cr, Ni-Fe
Beam Blank	350-900	300-1000	35-300	Cr-Zr-Cu, CuAg	Ni-Co, Cr, Ni-Fe
Rectangle	700-900	200-3000	30-70	Cr-Zr-Cu, CuAg	Ni-Co, Cr, Ni-Fe
Thin Slab	1200-2000	1100-1200		Cr-Zr-Cu, CuAg	Ni-Co, Cr
Ultra-thin Slab	1530	1100		Cr-Zr-Cu, CuAg	Ni-Co, Cr

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Mould & Plate Coatings

Copper has lower hardness which leads to lower anti-abrasive property. Therefore, the area at the lower part of the moulds, where the stress increases drastically due to shells, will be more severely worn. To increase the life time of copper moulds, CCM provides uniform mould interior surface plating with suitable hardness. Most of the copper mould tubes for small size billet casting are not used in any casting system where there are rigid casting stream support, therefore they are very sensitive to wearing. We use hard chrome plating which provides life of mould tubes. The llating thickness recommended by CCM will be controllde in the best range. As for the coating of copper mould plates, based on our years of experiece, we are able to provide Chrome coating, Ni-Cr coating, Ni-Fe coating and Ni-Cr coating to meet the demand of various customers both at home and abrod.

Assembly

Mould assemblies are key equipment for continuous casting. We produce round,square,rectangular and beam blank mould assemblies of different sizes in material of stainless steel and carbon steel. We have vertical and curved types in structure, The precision of mould assemblies are guaranteed as the forged stainless water jackets are produced by extrusion while assembled water jackets are machined by high precisionn CNC machines.

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