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. Download Sociology By Cn Shankar Rao Book pdf. Cn Shankar Rao PDF. Cn Shankar Rao PDF. In this book, C.N. Shankar Rao introduces the basic concepts of. The present invention relates to a continuous casting mold for casting metal as a slab from molten metal. In general, a continuous casting method includes introducing a molten metal into a tundish, a ladle provided with a top nozzle for pouring the molten metal into a mold. This method is divided into a two-stage method, which adds a reducing agent to the molten metal in the ladle to reduce the molten metal to a metal above its melting point, and a one-stage method, which does not add a reducing agent. In the two-stage method, the molten metal is cooled first to a level of about 50.degree. C. below the melting point thereof, then the molten metal is shot into the mold at high speed while adding a reducing agent. In the one-stage method, the molten metal is shot into the mold to thereby form the slab at an ordinary temperature. In the two-stage method, the molten metal is shot at high speed from the ladle to the mold.

Therefore, upon its solidification at the mold, the metal develops strong shearing stresses as well as a strong tendency to split. Thus, the molten metal solidifies unevenly as the casting proceeds, thereby forming asperities in the surface thereof. As a result, the surface of the slab exhibits a rough surface with longitudinal ridges, resulting in the formation of ripples therein. Therefore, with the two-stage casting method it has been impossible to obtain a cast slab of a smooth surface without wrinkles or ripples, and this has been disadvantageous in view of the appearance of the finished product, or so-called "first-grade product". Further, the molten metal which is shot from the top nozzle to the mold is cooled rapidly in the

transition zone from the top nozzle to the mold. This results in an uneven temperature distribution inside the mold and thus makes the surface thereof uneven. The temperature distribution inside the mold is more uneven in the case of a mold having a relatively long heating zone. In such a case, the surface of the slab exhibits a rough surface with large irregularities, thus leading to the formation of gaps between the casting and the mold. As a result, the cast slab is not satisfactorily released from the mold. This problem becomes more serious in the case of a thin

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