

ESR plant

Technical-technological description

Type FB 1650/84 W II (double plant)

This plant is an ESR double plant with ingot retractor and electrode changing device for producing extremely pure forging blanks.

The ESR plant consists of four mobile portals to house the electrode feed system and the systems required for the electrode change, which are assigned to the two melting stations.

Peripheral equipment

- Electrode bar welding plant
- Band saws for the preparation of the electrodes
- Electrode testing stand
- Dedusting plant

Ingot dimensions, production volumes

Ingot diameter [mm]	Ingot lengths [mm]	maximum ingot weights [kg]
500	2,500 – 6,000	8,500
800	2,500 – 6,000	22,500
1,000	2,500 – 6,000	35,000
1,250	2,500 – 6,000	55,000
1,500	2,500 – 6,000	79,000
1,650	2,500 – 5,000	84,000

This results in ingot weights of 3.8 to 84 tons.

Blanks

- Consumable electrodes with diameters of 316; 492; 583; 670; 795, 905 mm
- Maximum electrode length: 2,750 mm
- Maximum electrode mass: 11,000 kg