







Casting Consortium	Casting Condition	s Simula	ted
	Mold Length (mm)	1200	
	Domain Width (mm) top (mold width) bottom	984 934.04	
	Domain Thickness (mm) top (mold thickness) bottom	132 79.48	
	Domain Length (mm)	2400	
	Nozzle Port Height × Thickness (mm × mm)	$75 \times 32$ (inner bore)	
	Bottom Nozzle Port Diameter (mm)	32	
	SEN Submergence Depth (mm)	127	
	Casting Speed (m/min)	1.524	
	Superheat (° C)	57.	
	Fluid Dynamic Viscosity (m <sup>2</sup> /s)	7.98 × 10-7	
	Fluid Density (kg/m <sup>3</sup> )	7020	
	Particle Density (kg/m <sup>3</sup> )	2700	
	Particle Diameter (µm)	100, 250 and 400	
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