

A method of continuous casting steel includes supply of liquid metal into crystallizer, extraction from the crystallizer with formation of scabs in the crystallizing ingot and its cooling. Scabs are formed in the plane of symmetry parallel to the facets, and the supply of metal is carried out asymmetrically to said plane at a distance determined from the relationship

$$d = (2 \div 6) \delta,$$

where d - distance from the place of the supply of metal to the shrinkage cavity of slab;

δ - distance between the apexes of scabs.