

Rolling Mill for High-Grade Steels

Project Engineering • Supply • Services



Rolling Mill for High-Grade Steels

Starting stock

- Billets 50 x 100 x 10,000 mm
125 x 125 x 11,400 mm

Finished product

- Rod 5.5 - 13.5 mm dia.
- Bars 11 - 57 mm dia.
- Flats 22 - 120 mm, 5 - 12 mm thick

Bundle/stack length

- 3 - 8.5 m

Bundle/stack weight

- 0.5 - 3 (5) t

Furnace capacity

- up to 60 t/h

Material grades

- High-grade structural steels
34 Cr 4, 60 SiMn7, 42 CrMo4
- Antifriction bearing steels
100 Cr 6, 100 Cr 2, 100 CrMo 7 3

Material grades

- Tool steels:
X 210 Cr 12, X 38 CrMoV 5 1, 55 CrNiMoVS 4 2 4
- Acid-resistant and heat-resistant steels:
X 5 CrNiMo 18 11, X 2 CrNiMo 19 13,
X 20 CrNiSi 25 4
- High-speed steels:
X 79 Wco 18 5, X 82 W Mo 6 5 5
- Special alloys:
X 55 CrMnNiN 20, X 45 CrSi 9 3,
X 3 CrNiMoNbN 23 17
- The complete range of steel grades includes
approx. 300 different grades

Furnace group

- Charging grate, cross transfers, weighscale, descaler (2x), heatholding tunnel

Mill train

- Single strand, H/V - arrangement
- Roughing train: PSW and 6 x Model 440
- Intermediate train: 4 x Model 440, 2 x Model 340
- Finishing train: 4 x Model 340
- Kocks-block
- 8-stand wire rod block for high grade steels
3 x 215 / 5 x 170
- Associated shears
- Loopers: 7 x vertical, 1 x horizontal

Cooling bed group

- Water cooling line, pinch roll unit
- Cooling bed shear
- Cooling bed 57 x 5 m
- Continuous finishing shop:
- Abrasive cutting machine
- Piling and stacking facilities (non-magnet type)
- Tying machines: 1 x fixed, 1 x movable
- various associated equipment, e.g. stoppers, chain transfers, roller tables etc.

Rod finishing equipment

- Water cooling and equalizing sections, pinch roll unit, laying head
- Ring conveyor for retarded and accelerated cooling
- reforming tub
- Pallet-type coil handling system, compacting & tying units, weighscale, unloading station

Reel plant

- Water cooling and equalizing sections,
- Pinch roll units,
- Bar reels: 2 x,
- Transfer equipment to pallet-type coil handling system

