

Wire Rod Mill with Bar in Coil Line



Design
Supply
Service



Wire Rod Mill with Bar in Coil Line

Technical data

- Starting stock
 - Billets 120 x 120 x 12,000 mm
 - up to 150 x 150 x 12,000 mm
- Finished product
 - Wire rod \varnothing 5.5 - 16 mm
 - Rebars in coil nos. 3, 4 and 5 (as per ASTM)
 - Bars in coil \varnothing 16 - 42 mm
- Furnace capacity
 - 70 t/h
- Capacity
 - 300,000 t/y
- Finishing speeds
 - Wire rod line 100 (120) m/s
 - Bar in coil line 13.5 m/s
- Material grades
 - Cold-heading steels, reinforcing steels, steels with a carbon content from low to medium, piano-wire, PC-wire, free-cutting steel

Furnace group

- Charging grate, weighscale, descaler, heat-holding tunnel

Mill train

- Single strand, H/V- arrangement, associated shears
- Roughing train: 4 x Model 600, 2 x Model 440
- Intermediate train #1: 3 x Model 440, 3 x Model 340
- Intermediate train #2: 2 x Model 340, 4 x Model 280
- 10-stand wire rod block: 5 x 215 / 5 x 170

Rod finishing equipment

- Water cooling and equalising sections, pinch roll unit, laying head
- Ring conveyor for retarded and accelerated cooling, reforming tub
- Power & Free coil handling system including trimming station, compacting & tying units (2x), weighscale, unloading station

Continuous finishing shop

- Water cooling line, pinch roll units, bar reels (2x), coil transfer, chain conveyor with retarded and accelerated cooling facilities, transfer unit to Power & Free coil handling system

