

Rolling Mill for High-Grade Steels



Design
Supply
Service

MWE
MILL SOLUTIONS

Rolling Mill for High-Grade Steels

Technical data

- Starting stock
 - Billets 50 x 100 x 10,000 mm
125 x 125 x 11,400 mm
- Finished product
 - Rod \varnothing 5,5 - 13,5 mm
 - Bars \varnothing 11 - 57 mm
 - 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
 - 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 8, 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, descalers (2x), heat-holding 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 stationary, 1 x movable
- Various associated equipment, e.g. stoppers, chain transfers, roller tables, etc.

Rod finishing equipment

- Water cooling and equalising 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 equalising sections, pinch roll units, bar reels (2x), transfer equipment to pallet-type coil handling system

