

SECOND HAND MACHINES

1 MTPY STEEL MELTSHOP

DEFORMED BARS AND WIRE ROD 1 MTPY ROLLING MILL





1 MTPY STEEL MELTSHOP

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GENERAL DATA

PLANT CAPACITY:

1.000.000 tpy (*)

STARTING MATERIAL:

Steel Scrap

STEEL GRADES:

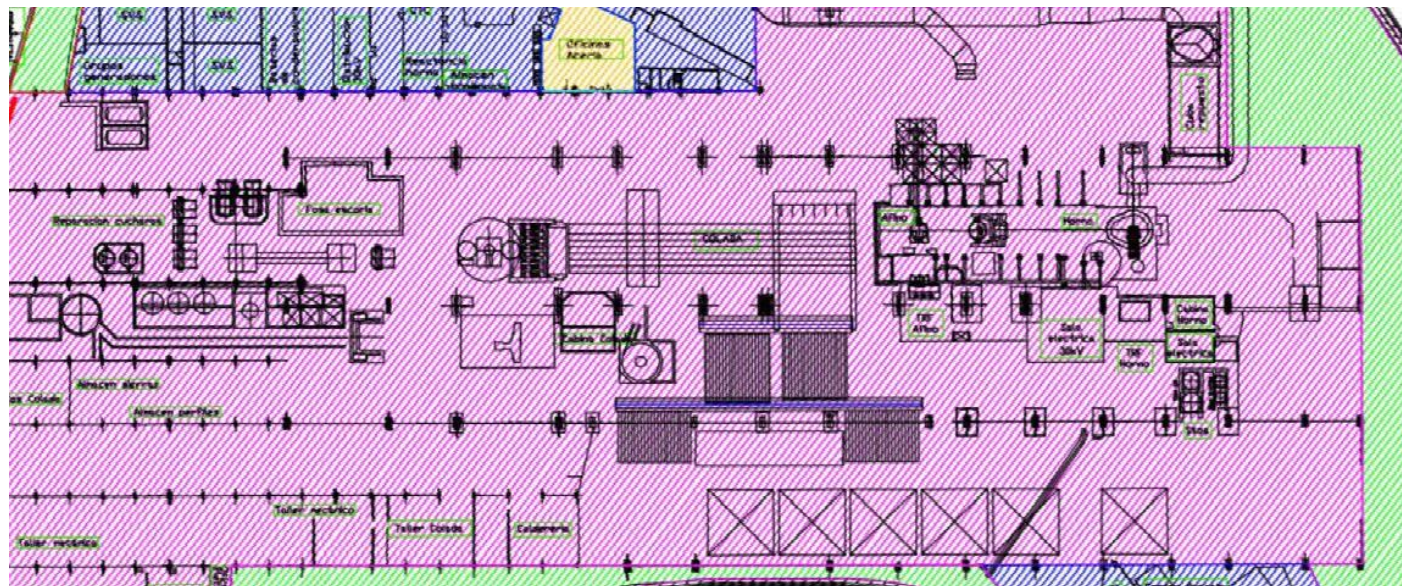
Low and Medium Carbon Steel

FINISHED PRODUCT:

Billet 130x130 and 140x140 x 12.000 mm

PRODUCT TOLERANCES:

According to EN standard



(*) Yearly capacity based on a 3 daily shifts working schedule.

1 MTPY STEEL MELTSHOP

EAF

Manufactured 1996 revamped 2010

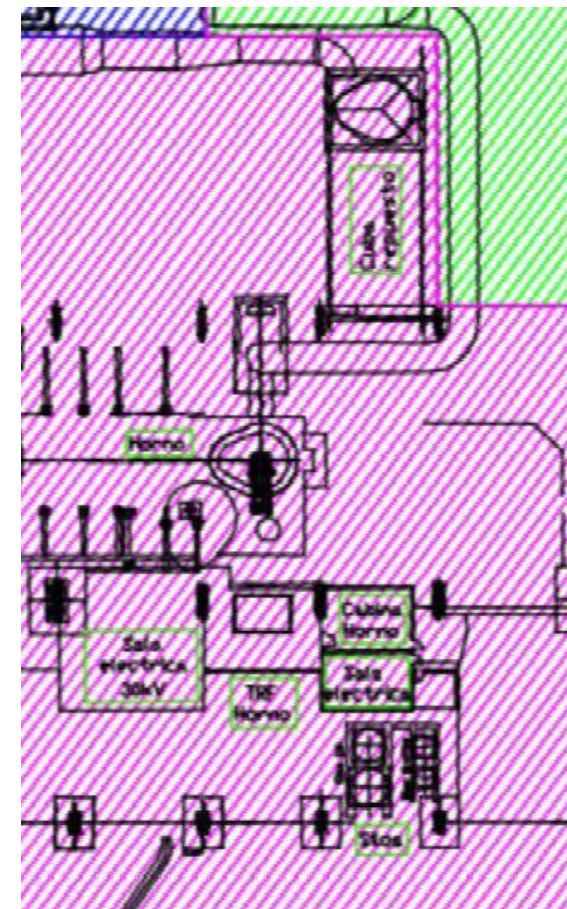
AC type EBT

Nominal capacity 135 Ton/heat

110 MVA transformer

600 electrode diameter

Shell diameter 5.600 mm



1 MTPY STEEL MELTSHOP

LF

Manufactured 1983

Nominal capacity 135 Ton/heat

Heating rate $> 2^{\text{a}}$ C/min

26 MVA transformer

Water cooled roof design

Heating station served by ladle car



1 MTPY STEEL MELTSHOP

CCM

Manufactured 2002 by Danieli revamped in 2010

Machine radius: 7 m

Number of strands: 6

Castable sections: Billets 130 x 130 and 140 x 140

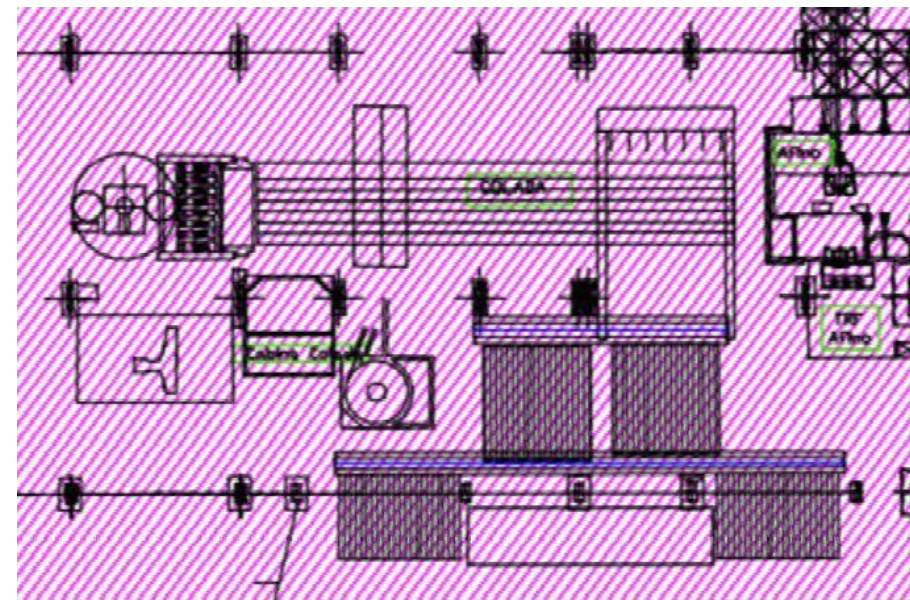
Casting mode: open stream

Mould: 1.000 mm length

Oscillating bench: Mechanical

Secondary cooling: three zones with four independent regulation loops

Billet discharging: liftable side transfer, walking beam cooling bed



The background of the image shows a large industrial facility, likely a steel mill, with complex machinery, pipes, and structural elements. The scene is dimly lit, with a purple and blue color cast. The text is overlaid in the center in a bold, white, sans-serif font.

DEFORMED BARS AND WIRE ROD 1 MTPY ROLLING MILL

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GENERAL DATA

PLANT CAPACITY:

1.000.000 tpy (*)

STEEL GRADES:

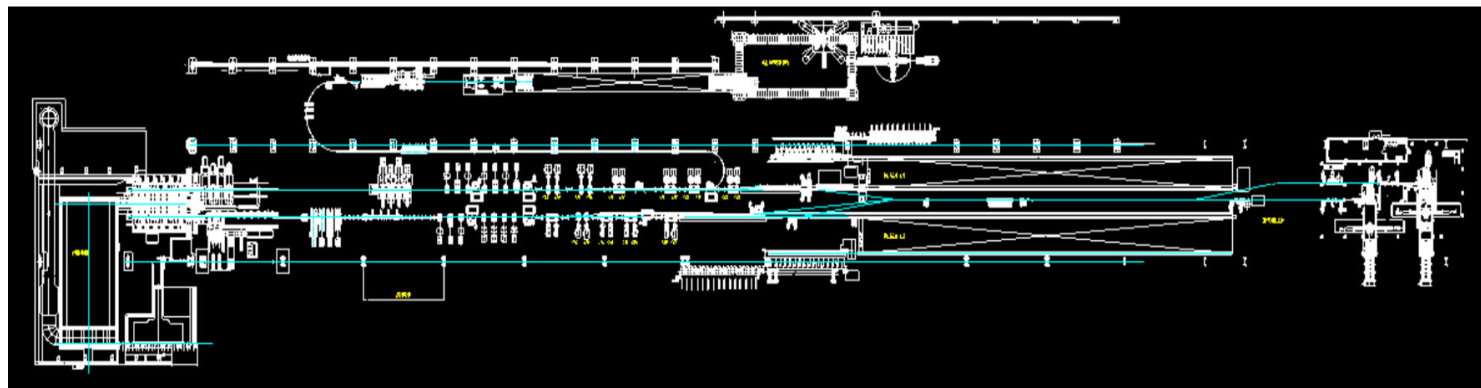
Low and Medium Carbon Steel

STARTING MATERIAL:

Billet 130x130 and 140x140 x 12.000 mm

PRODUCT TOLERANCES:

According to EN standard



FINISHED PRODUCT:

- Deformed Bars (DB) from 8 to 40 mm dia
- Spooled Bar-in-coil from 8 to 32 mm dia
- Wire rod from 5,5 to 14 mm dia

FINISHED PRODUCT SUPPLY:

- **Bundles Length:** 6.000 to 12.000 mm
Weight: 1.000 to 2.000 Kg
- **Spooled Coil Weight:** 1.800 kg for 8 to 10 dia
3.000 kg for 12 to 32 dia

(*) Yearly capacity based on a 3 daily shifts working schedule.

DEFORMED BARS AND WIRE ROD 1 MTPY ROLLING MILL

REHEATING FURNACE

Manufacturer Fives Stein in 2002

Walking Hearth type furnace

Nominal capacity 180 Ton/h

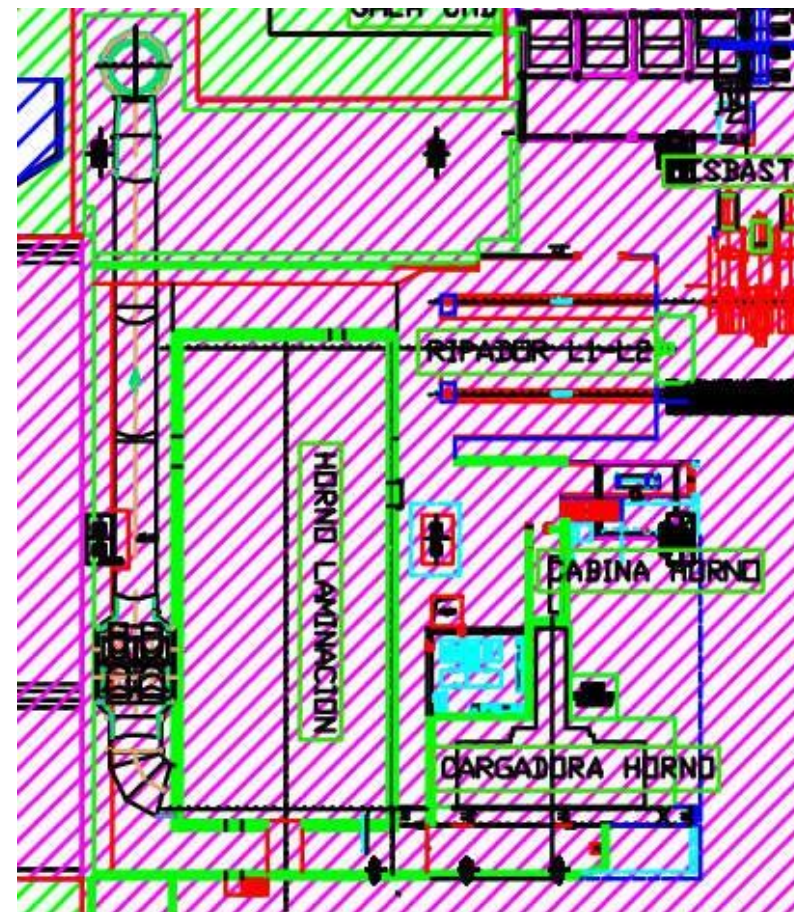
Maximum billet section 140 x 140

Useful maximum internal width 12,5 m

Number of burning zones 4

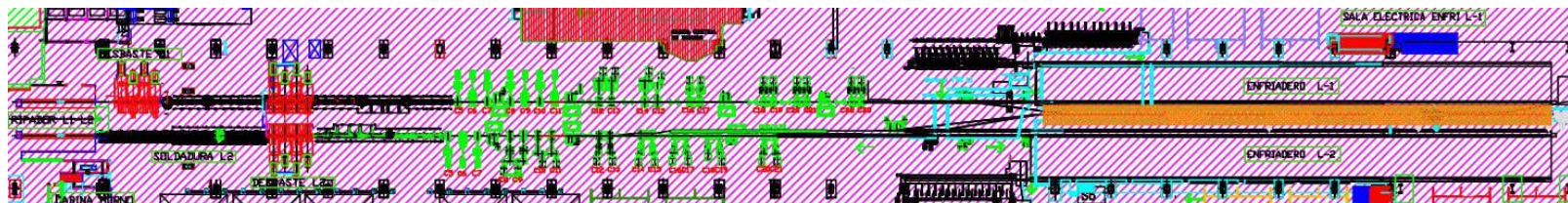
Number of burners 63

Fuel Natural Gas



DEFORMED BARS AND WIRE ROD 1 MTPY ROLLING MILL

ROLLING MILL LINE I



Product – Deformed Bars 8 – 10 mm

23 Stands in H – V configuration – DC Motors

Stands 1 to 4 - Roll Dia. 580/500 mm – Barrel 1.000 mm

Stands 5 to 11 - Roll Dia. 510/470 mm – Barrel 1.000 mm

Stands 12 to 15 - Roll Dia. 415/365 mm – Barrel 1.000 mm

Stands 16 to 23 – Roll Dia. 320/280 mm – Barrel 710 mm

6 Motorized flying shears

6 Loopers

2 Tempcore Water Boxes 13.800 mm length for thermomechanical rolling

Cooling bed

90 meter length

4.500 mm width

Bundling station

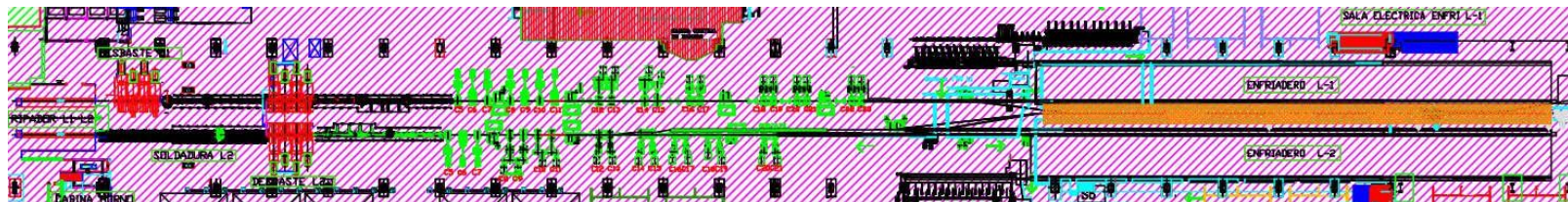
1.300 mm shear with stopper

Max bundle length 15.000 mm

Two tying machines OMV

DEFORMED BARS AND WIRE ROD 1 MTPY ROLLING MILL

ROLLING MILL LINE II



Product – Deformed Bars 12 - 32 mm

21 Stands in H – V configuration – DC Motors

Stands 1 to 4 - Roll Dia. 580/500 mm – Barrel 1.000 mm

Stands 5 to 7 - Roll Dia. 510/470 mm – Barrel 1.000 mm

Stands 8 to 11 - Roll Dia. 415/365 mm – Barrel 800 mm

Stands 12 to 21 – Roll Dia. 320/280 mm – Barrel 710 mm

5 Motorized flying shears

5 Loopers

2 Tempcore Water Boxes 18,000 mm length for thermomechanical rolling

Cooling bed

93 meter length

5.000 mm width

Bundling station

Bundling station 1.300 mm shear with stopper

Max bundle length 15.000 mm

Two tying machines OMV

DEFORMED BARS AND WIRE ROD 1 MTPY ROLLING MILL

SPOOLER LINE

Two Spooler coilers for deformed bars from 8 to 32 mm

Spooled coils

1.100 to 1.250 mm external diameter

850 mm inner diameter

800 mm coil height

Coil weight

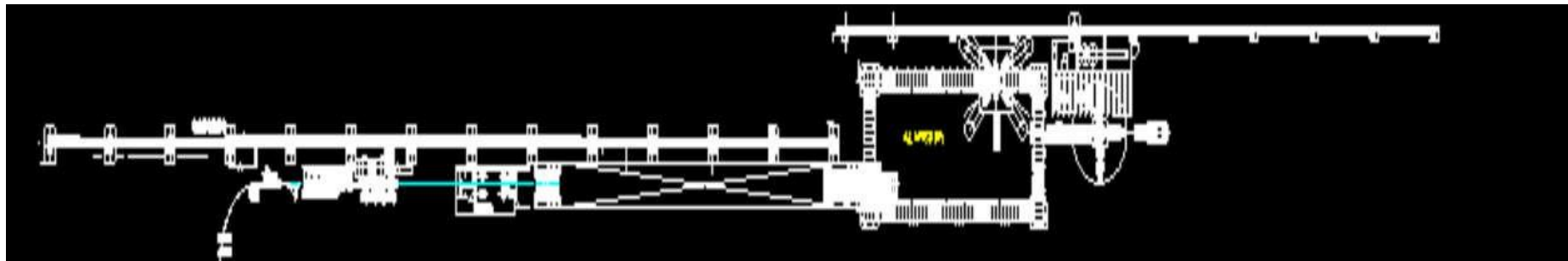
1.800 kg for Dia. 8 to 10 mm

3.000 kg for Dia. 12 to 32 mm



DEFORMED BARS AND WIRE ROD 1 MTPY ROLLING MILL

WIRE ROD LINE



Wire Rod Dia. 5,5 to 14 mm

8 Pass Monoblock

Lying head, conveyors, compacting machine and tying machine

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