

Wire Rod Mill with Bar in Coil Line

Project Engineering • Supply • Services



Wire Rod Mill with Bar in Coil Line

Starting stock

- Billets 120 x 120 x 12,000 mm up to 150 x 150 x 12,000 mm

Finished product

- Wire rod 5.5 - 16 mm
- Rebars Nos. 3, 4 and 5 (as per ASTM)
- Coils 16 - 42 mm dia.

Furnace capacity

- 70 t/h

Annual 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 equalizing 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

Bar-in-coil line

- 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

