TANGSHAN IRON & STEEL CORP., TANGSHAN, PR CHINA
NEW GALVANIZING LINES #5 & #6
Tangshan Iron and Steel Group Co. Ltd., a Chinese steel producer, has awarded Primetals Technologies an order to supply two continuous galvanizing lines to expand cold rolling mill no. 2 at its Tangshan plant in Hebei Province. This will increase the production capacity for high-strength, coated metal sheets by 650,000 metric tons per annum. The sheets will mainly be used by the automotive industry.

Continuous galvanizing lines nos. 5 and 6 will be constructed in a new hall alongside the existing cold rolling mill. This was also supplied by Primetals Technologies, and has been in production since the beginning of 2015. The two new continuous galvanizing lines are scheduled to come into operation in 2017.

A special aluminum-silicon coating technology package will be installed on one line.

The two new continuous galvanizing lines are scheduled to come into operation in 2017 with production of the first coils in 18.5 months for CGL6 and 21 months for CGL5.

**SCOPE OF SUPPLY**

- Coil charging section equipped with an entry walking beam, a shuttle coil car, and an automatic unstrapping and a weighing station
- Entry section with a double payoff reel and scrap evacuation outside the building
- Welding section equipped with a laser welding machine including entry and exit centering units and a notcher
- A 16-strand entry looper with a capacity of 400 meters and a top movable carriage
- Cleaning section including 1 vertical dip dunk tank with spray, 1 brush scrubber, 1 vertical electrolytic cleaning tank, 1 brush scrubber and 1 HP rinsing tank
- Furnace section equipped with an ART (all-radiant tubes) furnace technology
- Coating section including a wiping system, a zinc pot and associated equipment
- Cooling section comprising an APC tower and quenching system
- A 16-strand intermediate looper with a capacity of 400 meters and a top movable carriage
- TM-TL section equipped with a 4-high temper mill, a shapemeter, a roughness gauge (CGL no.6 only), and a tension leveler
- A mechanical properties measurement system (CGL no.6 only)
- Post-treatment section including 2 vertical roll coaters
- Exit looper with a capacity of 290 meters and a top movable carriage
- Side-trimming section equipped with a side trimmer and a scrap chopper (CGL no.6 only)
- Inspection section including a vertical and horizontal inspection station
- Exit section with an electrostatic oiling machine, a double tension reel, and scrap evacuation outside the building
- Coil discharging section equipped with an exit walking beam, a shuttle coil car, an automatic strapping machine, and a weighing station
- Electrical and automation equipment
- Know-How package

**PLANT DATA CGL#5**

- **Material to be processed**: Cold rolled steel
- **Production capacity**: 250,000 t/y
- **Product grade**: CQ, DQ, IF, HSS, BH, DP
- **Strip thickness**: 0.18 to 1.50 mm
- **Strip width**: 850 to 1,300 mm
- **Line speed**: max. 250 m/min
- **Process section**: max. 180 m/min
- **Coating type**: GI

**PLANT DATA CGL#6**

- **Material to be processed**: Cold rolled steel
- **Production capacity**: 400,000 t/y
- **Product grade**: CQ, DQ, IF, HSS, BH, DP
- **Strip thickness**: 0.50 to 3.00 mm
- **Strip width**: 850 to 1,600 mm
- **Line speed**: max. 250 m/min
- **Process section**: max. 180 m/min
- **Coating type**: GI, AlSi
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