In April 2013, Tangshan Iron & Steel Corp., a key enterprise of Hebei Iron & Steel Group based in the eastern area of Hebei province, awarded Primetals Technologies an order for the supply of a complete new cold rolling plant, including a coupled pickling line and tandem cold mill (PLTCM), a continuous annealing line (CAL) and a continuous galvanizing line (CGL), to produce high-strength automotive plate and advanced steel grades for household appliances. The complex has been designed for a capacity of 1.6 million tons per year.

The two processing lines were manufactured by a consortium of Primetals Technologies for the supply of the key equipment, and its associated partners: Siemens Ltd China for the electrical and automation equipment and individual mechanical parts, and Andritz Selas for the furnace. The entire local part was supplied by Primetals Technologies.

A remarkable aspect of this project was the extremely short execution period of only 21 months from the contract signing to the first coil.

**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, and a tension leveler
- A mechanical properties measurement system
- Post-treatment section including 2 manual 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
- Inspection section including a vertical and horizontal inspection station, a mechanical properties measuring device, and automated surface inspection system (SIAS®)
- Exit section with an electrostatic oiling machine, a double tension reel, and scrap evacuation outside the building
- TM-TL section equipped with a 4-high temper mill, a shapemeter, a roughness gauge, and a tension leveler
- A mechanical properties measurement system
- Post-treatment section including 2 manual 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
- Inspection section including a vertical and horizontal inspection station, a mechanical properties measuring device, and automated surface inspection system (SIAS®)
- Exit section with an electrostatic oiling machine, a double tension reel, and scrap evacuation outside the building
- TM-TL section equipped with a 4-high temper mill, a shapemeter, a roughness gauge, and a tension leveler
- A mechanical properties measurement system
- Coating range 60 to 450 g/m² (both sides)
- Exit section
- TM-TL section
- Tension leveler force max. 1000 t
- Tension leveler capacity max. 25 t
- Post-treatment Anti-fingerprint and passivation solutions

**BENEFITS**
- State-of-the-art continuous galvanizing line able to produce the latest generation of advanced high-strength steels (AHSS) for automotive export market
- One single partner with overall responsibility, Primetals Technologies is the leader of the consortium for the PLTCM, CAL, and CGL
- Through the seamless integration of the production equipment and automation, Primetals Technologies has full control over productivity, quality, and availability performance, which are key factors for profitability

**PRODUCT DATA**
- Product grade CQ, DQ, DDQ, EDDQ, SEDDQ, BH, HSS, DP, TRIP
- Strip thickness 0.20 to 2.50 mm
- Strip width 700 to 1,600 mm
- Coil weight 26 t
The information (including, e.g., figures and numbers) provided in this document contains merely general descriptions or characteristics of performance based on estimates and assumptions which have not been verified. It is no representation, does not constitute and/or evidence a contract or an offer to enter into a contract to any extent and is not binding upon the parties. Any obligation to provide and/or demonstrate respective characteristics shall only exist if expressly agreed in the terms of the contract. These estimates and assumptions have to be analyzed on a case-to-case basis and might change as a result of further product development. Primetals Technologies excludes any liability whatsoever under or in connection with any provided information, estimates and assumptions. The provided information, estimates and assumptions shall be without prejudice to any possible future offer and/or contract. Any use of information provided by Primetals Technologies to the recipient shall be subject to applicable confidentiality obligations and for the own convenience of and of the sole risk of the recipient. Primetals is a trademark of Primetals Technologies Ltd.