

HOT-ROLLING

01. Preheating furnace

The grinding slab is preheated in a walking-beam furnace, from 1250°C to 1280°C. Once the interior and exterior slab temperatures are equal, the slab is moved along rotating rollers to the roughing mill.

02. Roughing mill

At the end of this process the slab thickness has decreased from 200 mm to 20-30 mm.

03. *Steckel* mill

It is a reversing mill with a coiler on each side. As the strip gets in each roll pass, the final thickness is between 2 and 10 mm.

04. Coiler

After the *Steckel* Mill, the cooled roll strip is cooled, coiled and strapped. The result of the whole process is a black coil.

05. Hot plate shop

The following installations are in operation in this shop:

- Annealing and pickling line: mechanical properties and metallurgical structure are recovered.
- Leveller and squaring section: shear up to 20 mm thickness.
- Plasma cutting: thickness cutting range between 20 to 50 mm.