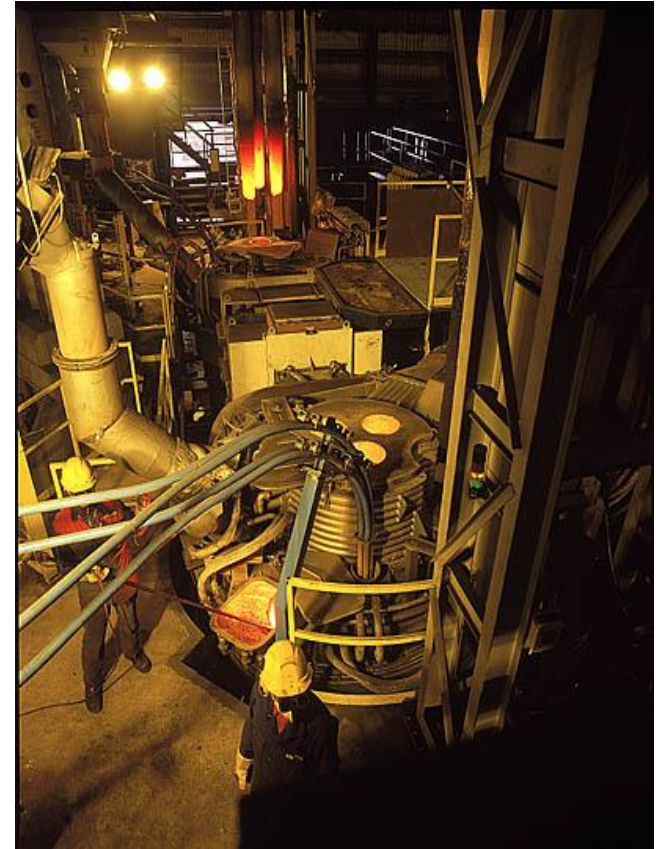
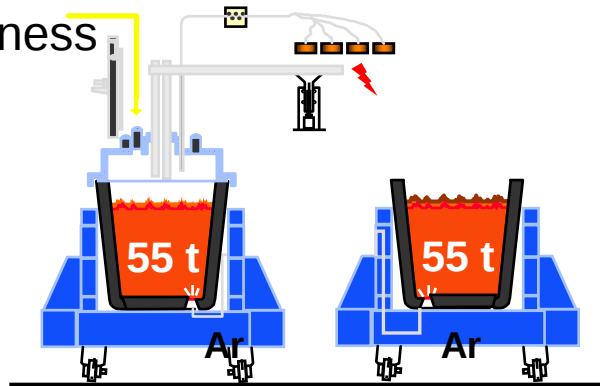


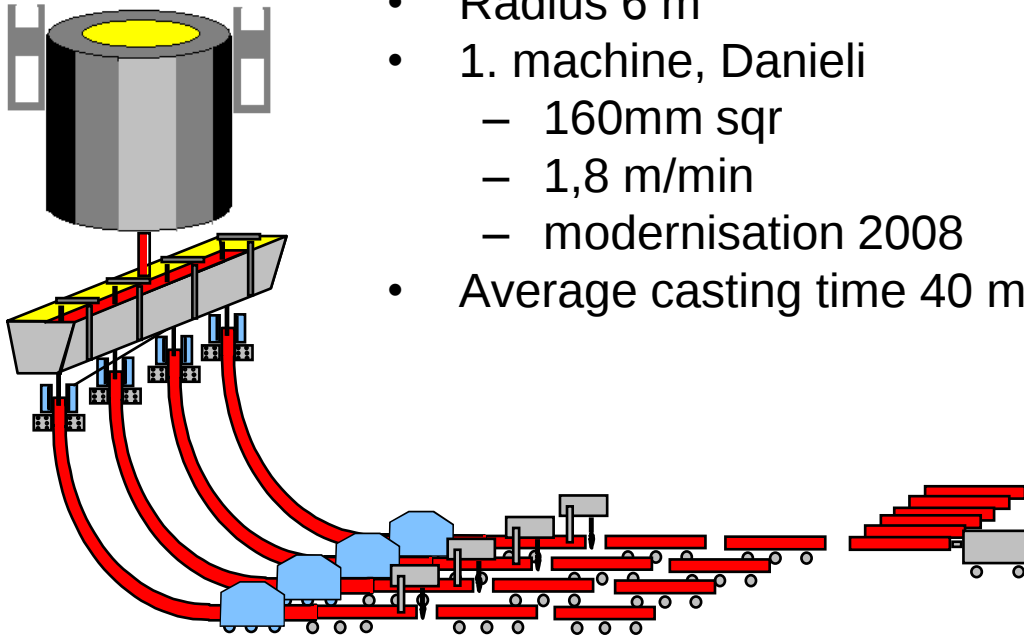
Ladle furnace

- The ladle furnace was built 2001
- Two stations with shared electrodes
- Technical information:
 - Charge: 55 t
 - Max effect 15 MW
 - Heating effect + 5.5 °C/min
 - Electrode wear 7 g/kWh
- Alloys: wire and silo feed
- Benefits of ladle furnace:
 - Better alloying hit rate
 - Better temperature control
 - Better steel cleanliness



Continuous casting machines

- There are two casting machines and they have been revamped and renewed several times during the years.
- Both have 4 strands
- Tundish size: 12,5 t
- Radius 6 m
- 1. machine, Danieli
 - 160mm sqr
 - 1,8 m/min
 - modernisation 2008
- 2. machine, Danieli
 - 160/145/130 sqr
 - 2,8 m/min
 - renewed 2007
- Average casting time 40 min/ladle.



Cooling beds

- After casting the steel is cut to billets
 - 1. machine: 7,2 m (max. 10.6 m)
 - 2. machine: 11,3 m (max. 12.6 m)
 - Propane started oxygen cutting
- 2. machine equipped with deburring.
- The billets are marked on the cooling bead with mechanical stamping.
- On the cooling beds the billets are cooled down, and to keep the billets straight, they are turned 90° at every step.



Billet handling and stock

- **Billet handling**
 - bundling (Alblasserdam billets)
 - Visual surface inspection
 - Grinding of possible surface defects
 - Removal of cutting burr
 - Placing of billets in stock
- **Billet yard**
 - Maximum stock 60kt
 - Trucks and billet carriers
 - Loading of trucks for Dalsbruk (outsourced) and transport to harbour (Alblasserdam)



Produced steel grades 2008

