



热连轧产品介绍

INSTRUCTION OF TISCO HOT ROLLED PRODUCTS

冷轧用料
Hot Rolled Coils for Cold Rolling



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Taiyuan Iron and Steel (Group) Co.,Ltd.

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企业使命

为全球消费者提供最精美的不锈钢产品

ENTERPRISE MISSION

Providing the excellent stainless steel products to consumers

战略目标

建设全球最具竞争力的不锈钢企业

STRATEGIC TARGET

To build TISCO the most competitive stainless steel producer over the world

核心价值观

以人为本 用户至上 质量兴企 全面开放 不断创新

CORE VALUES

Personal-focusing, customer-prioritized, quality-driven, fully opening and innovation-led.

营销理念

为用户提供更全、更好、更快的解决方案
在长期合作中实现共赢

MANAGEMENT CONCEPT

Win-win is sought through long-term cooperation with and availability of better and quicker solution package to customers





太原钢铁(集团)有限公司(简称太钢)是中国特大型钢铁联合企业和全球产销量最大、工艺技术装备水平最高、品种规格最全的不锈钢企业。经过70余年发展,已具备1000万吨以上钢、铁、材的生产能力,其中不锈钢产能达300万吨。2009年生产不锈钢248万吨,产量世界第一!

太钢是中国第一炉不锈钢、第一炉硅钢、第一张硅钢片的诞生地。拥有铁矿石等钢铁冶炼原料的采掘与加工、钢铁冶炼、钢铁材料压力加工、冶金设备及备品备件制造等方面先进技术和装备。主要产品有不锈钢、冷轧硅钢片(卷)、热连轧卷板、车轴钢、合金模具钢、军工钢等。产品广泛应用于石油化工、交通运输、建筑装饰、家用电器、医疗食品等行业及神舟系列飞船、嫦娥一号、“东风”系列火箭及核电站等高端领域,进入三峡水利、西气东输、奥运场馆及世博场馆等国家重点工程。2009年在国家认定的575所企业技术中心中,太钢技术中心排名第二,位钢铁行业首位。太钢拥有以不锈钢为核心的745项具有自主知识产权的核心技术,其中100多项达到国际先进水平。

太钢的发展战略是,加快建设全球最具竞争力的不锈钢企业,实现以不锈钢为主的品种、质量、成本、研发、节能、环保、效率、服务等各项指标达到国际一流水平,进而建设具有国际竞争力的大企业集团。

Taiyuan Iron and Steel (Group) Co. Ltd. (TISCO) is one of the steel giants in China and, the largest stainless producer in the world in term of output and sales equipped with the most advanced facilities covering pretty wide product range. After over 70 years development TISCO has the capacity of 10 million tons of steel, which includes 3 million tons of stainless. The year of 2009 saw TISCO become No.1 stainless producer in the world with production of 2.48 million tons of stainless.

In TISCO came out the first heat of stainless steel and first heat of silicon steel as well as the first sheet of silicon in the history of China steel industry. TISCO is well equipped for mining and iron ore refining, iron and steel making, rolling and forging, metallurgical equipment and spare parts manufacturing. TISCO's products cover stainless steel of cold and hot rolling, cold rolled silicon, hot rolled coil, axle steel, die steel and steel for military purpose etc. TISCO's products are widely used in petrochemical industry, transportation, construction decoration, home appliance, medical and food industry. TISCO's products can be also found in the national key projects such as Shenzhou spaceship, Chang'e-1 Moon Detector, Dongfeng rocket series and nuclear power, Three Gorges, West-East natural gas transmission, and Olympic game facility as well as Shanghai world expos. In 2009 TISCO technology centre ranked No.2 among the 575 state acknowledged enterprise technology institutions, and No.1 among the steel industry. TISCO owns 745 core patents in the field of stainless and over 100 patents are taken as the world class.

TISCO is aiming to become the most competitive stainless producer in the world, and achieve the first class stainless product in terms of product range, quality, cost, R&D, energy saving, environment protection, efficiency and service. For this goal TISCO is trying the first world class level and build itself into the world competitive large group company.



太钢热连轧厂于1994年8月8日投产,现拥有1549mm和2250mm两条热连轧生产线,具备800万吨以上年生产能力。主要生产品种有:碳结钢、优碳钢、低合金钢、不锈钢、硅钢等五大类产品。

1549mm热连轧是华北地区第一条热轧生产线,1994年8月8日全线过钢成功,2002年9月进行了全面技术改造。

2250mm热连轧项目是大钢新建150万吨不锈钢系统工程的关键项目与效益工程,工程建设周期21个月,于2006年6月29日一次过钢成功,轧制出第一卷钢。该项目包括一条热连轧生产线、一条平整生产线和一条横切生产线。主轧线及电器设备、平整线、横切线均从国外先进制造企业引进。

2250 mm主轧线由四座步进式加热炉、一台可逆式粗轧机和带边部绝热装置的热卷箱、七架精轧机、层流冷却(预留快速冷却装置)、三台卷取机组组成,年设计能力400万吨,其中碳钢200万吨,不锈钢200万吨。成品规格:厚度1.2~25.4 mm,宽度900~2130 mm;最大卷重40吨。横切线成品厚度5.0~25.4 mm,宽度1000~2130 mm,长度2000~16000 mm。

2250mm产品品种与规格进一步拓宽,可生产高强度用钢、冷成型用钢、结构钢、低合金钢、石油天然气输送用钢、造船用钢、汽车用钢板、压力容器用钢、集装箱用钢板等品种。为进一步发挥装备的优势,2250可生产X80管线钢、双相钢、TRIP钢、超细晶粒钢、高层建筑用耐火耐候钢、高性能工程机械用钢、桥梁钢等宽、厚、新、特品种,可充分满足各行业用户的更高要求。

2250mm热轧装备和控制系统代表了当今世界热连轧机组的最高技术水平。板形控制系统采用了最新的CVC技术,装备有带边部绝热装置的热卷箱和预留有快速冷却装置,确保薄规格产品的良好板形和带钢性能的均匀性,同时满足多相、TRIP等特殊钢种的生产 and 开发需要。生产工艺上采用不锈钢和碳钢的混和轧制技术。2250 mm热连轧生产线已成为世界上产量最大、技术装备最先进的热轧生产线。

The Hot Strip Mill of TISCO was put into operation in Aug. 8, 1994. There are two hot rolling production lines--1549mm HSM and 2250mm HSM-- with total capacity of 8 million tons / per year. The main products are carbon structure steel, quality carbon steel, low alloy steel, stainless steel and silicon steel.

1549mm HSM is the first HSM in North China. It was put into operation in Aug. 8, 1994 and revamped in Sept. 2002.

2250 mm HSM is the key project in the 1.5 million tons new stainless steel production line project in TISCO. The first coil was successfully produced at June, 29, 2006. The main equipment of 2250 mm HSM includes one hot rolling production line, one skin pass mill and one cutting line.

The designed annual capacity is 4 million tons, among it, 2 million tons of stainless steel and 2 million tons of carbon steel. The specification of the products are: thickness range 2.0~20.0 mm and width range 1000~2100 mm for stainless steel; thickness range 1.2~25.4 mm and width range 1000~2130 mm for carbon steel, the maximum coil weight 40 tons. The product specification of the cutting line is thickness range 5.0~25.4mm, width range 1000~2130mm, length 2000~16000mm.

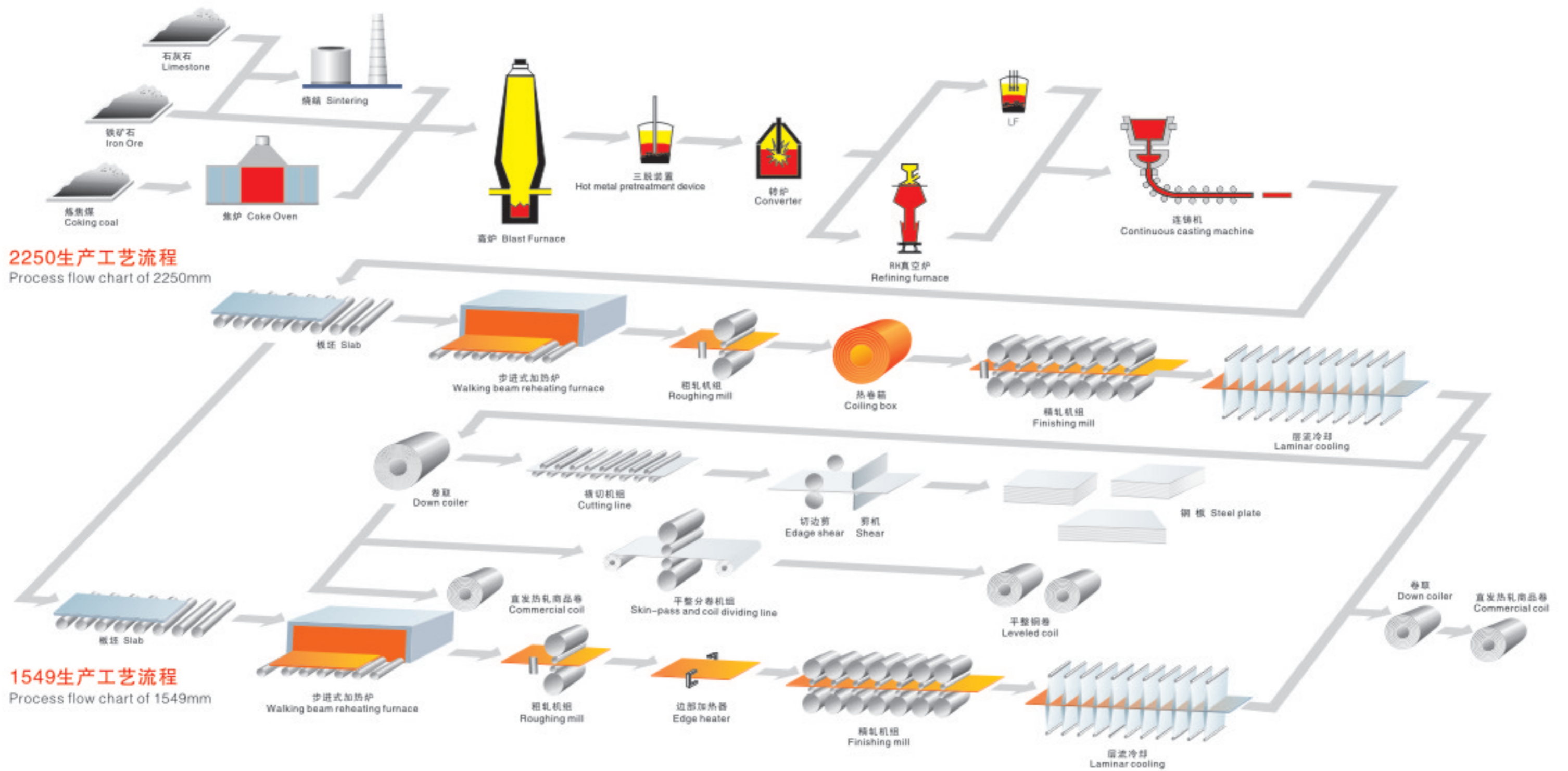
The product mix and specification of 2250mm HSM are widened, it can produce wide range of steel grades such as high strength steel, cold forming steel, structure steel, low alloy steel, steel for transportation of oil and gas, shipbuilding steel, automobile steel, pressurized vessel steel, container steel. In order to further exploit its advantages, the wide, thick, new and special hot rolled products such as X80 pipeline steel, duplex steel, TRIP steel, ultra fine grained structural steel, weather proof steel for high buildings, and steel for

construction machinery and equipment will be produced by the 2250mm HSM to fully meet the requirements of the customers. The equipment and control system of 2250mm HSM represents the most advanced world technological levels. The shape control system adopts the CVC technology. It equips with coil box with edge heater, the location for quick cooling device is reserved, which can ensure good strip shape properties and uniform strip properties and meet the requirements for production and development of duplex steel and TRIP steel. The production process adopts mixed rolling of carbon steel and stainless steel. The 2250mm hot rolling production line becomes the most advanced technology and equipment in the world.



P 1549mm与2250mm热连轧碳钢生产工艺流程图

PROCESS FLOW CHART OF 1549MM AND 2250MM HSM PRODUCTION



M 主要装备介绍 MAIN EQUIPMENT INTRODUCTION

180吨顶底复吹转炉

- 采用顶底复吹方式，脱碳效率高；
- 钢质纯净，残余元素低，夹杂物含量少；
- 成分控制精确。

180t K-OBM converter

- Combined top and bottom blowing is adopted. The efficiency of decarbonization is high.
- The steel is cleaner, the residual element and inclusion in the steel is lower.
- The analysis of steel is accurate.

立式板坯连铸机

- 采用立式板坯连铸机，可实现夹杂物充分上浮，钢质纯净；
- 铸坯不经弯曲矫直，内部缺陷少；
- 结晶器配有非正弦液压振动和电磁涡流式液面控制装置及二冷采用自动配水等技术，铸坯组织均一、致密。

Vertical Continuous Casting Machine

- The slab is produced by vertical continuous casting machine which benefits the floatation of the inclusion and makes the steel cleaner.
- The strand does not pass through bending zone, which eliminates the internal defects.
- The mold is equipped with non-sinusoidal hydraulic vibrator, electromagnetic eddy current mold level control device and secondary cooling with automatic water control. The structure of the slab is uniform and dense.

加热炉

- 分段式步进梁；
- 汽化冷却；
- 最佳化燃烧控制模型。

Reheating Furnace

- Walking beam type reheating furnace
- Gasification cooling
- Optimized combustion control model.



4350高炉 4350 blast furnace



180吨顶底复吹转炉
180 ton top and bottom combined blown converter



RH精炼炉 RH



一机双流连铸机 Two-strand CCM



步进式加热炉
Walking beam reheating furnace



粗轧机 Roughing mill



精轧机 Finishing mill



热卷箱 Recoiling box



层流冷却 Accelerate cooling



卷取机 Down coiler

1549mm热连轧机机组

- 采用先进AWC、AGC控制系统，可获得高的尺寸精度；
- 采用先进液压弯辊、窜辊技术，配备有边部加热装置。

1549mm Hot Strip Mill

- Advanced AWC and AGC control system is adopted. High accuracy of product sizes has been achieved.
- Advanced hydraulic roll bending and roll shifting is adopted. Edge heater is equipped with.

2250mm热连轧机组

- 2250mm生产线装备和控制系统水平代表了当今世界传统热连轧机组的最高水平；
- 板形控制系统采用了最新的CVC⁺技术，压下系统采用液压AGC控制技术；
- 中间坯保温采用带边部绝热装置的热卷箱；
- 高效冷却装置。

2250mm Hot Strip Mill

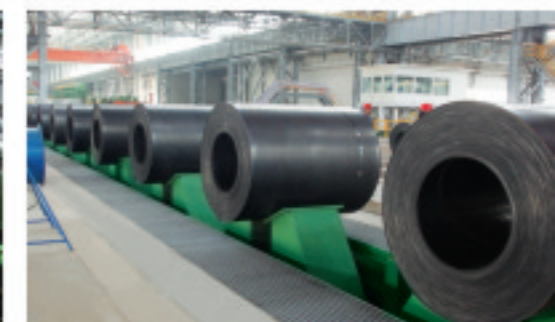
- The equipment and control system of 2250 mm HSM represents the most advanced international technical level of the hot strip mill.
- The shape control system adopts the newest CVC⁺ technology, screw down system adopts the hydraulic AGC system.
- The heat retention of the transfer bar adopts the coil box with edge heat shield.
- High efficiency cooling device.



平整机组 Skin-pass mill



横切机组 Crosscut equipment



成品 Finished products

R 研发能力 R&D CAPACITY



太钢技术中心 TISCO Technology Centre

在国家认定的438家企业技术中心中，太钢技术中心排名第4位。
TISCO Technology Centre ranks the 4th place out of 438 enterprise-based technology centres accredited nationwide.

冷轧用料产品介绍 INTRODUCTION OF HOT ROLLED COILS FOR COLD ROLLING

太钢2250热卷，宽度最宽为2130mm，特别适用于有特殊宽度要求的冷轧板，可根据实际要求纵剪成两倍、三倍、等倍尺或不同宽度使用。

The widest hot rolled coils of TISCO is 2130mm, it is just suit to the special requirement of width. The customers can slit the coil into double, triplication or different width according to the requirement of width.

热卷可根据不同使用用途分为热轧酸洗、冷硬卷、冷轧退火卷、热浸镀锌、电镀锌、电镀铬、镀铝、热浸镀铝锌硅、彩涂等。

The hot rolled coils can be used for pickled coils, cold-rolled coils, annealed cold rolled coils, hot zinc (Al, Si) galvanized; electrical Sn Cr Zn galvanized and colored coating according to the usage.

质量检测 QUALITY INSPECTION



透射电镜
Transmission Electronic Microscope



电子拉伸试验机
Electronic Tensile Tester



电液伺服疲劳试验机
Electrohydraulic Servo Fatigue Testing Machine



热模拟试验机
Thermal Simulator

质量保证体系 QUALITY SYSTEM



尺寸精度 Dimensional accuracy (mm)

厚度精度	Thickness accuracy	± 30 μ
宽度精度	Width accuracy	0~6.5mm
平直度	Flatness	25IU
凸度精度	Profile accuracy	± 20 μ

产品规格 Product specification

规格 Specification	热轧卷 Hot rolled coil	平整/分卷钢卷 Coil leveled/coil divided	横切钢板 Cutting-to-length sheet/plate
厚度 mm Thickness	1.2-25.4	平整 1.2-6.5 分卷 1.2-12.7 Coil leveled coil divided	5.0-25.4
宽度 mm Width	900-2130	1000-2130	1000-2130
卷重 t Coil weight	40(max)	40(max)	单包重 10(max) Packaged sheets
卷内径 mm Inside diameter	762	762	长度 2000-12000 Length
卷外径 mm Outside diameter	2150 (max)	2150 (max)	
生产能力 Capacity	1549mm年产量330万吨; 2250mm年产量450万吨 Annual output 3.3 million ton by 1549mm annual output 4 million ton by 2250mm	100.7万吨 1.007 million ton	62万吨 (含不锈钢30万吨) 0.62 million ton (including 0.3 million ton)

太钢所产冷轧用料牌号及化学成分

The steel grade and chemical composition of Tisco's hot rolled coils for cold rolling

牌号 Grade	化学成份 (%) Chemical composition %											
	C	Si	Mn	P	S	Al	N	Cr	Ni	Cu	Nb	Ti
Q195L	≤0.08	0.10-0.20	0.25-0.50	≤0.045	≤0.050							
Q195LD	≤0.08	≤0.12	0.25-0.50	≤0.045	≤0.050							
SPHC	≤0.15	≤0.05	≤0.06	≤0.035	≤0.035	≥0.01						
SPHD	≤0.06	≤0.03	≤0.04	≤0.030	≤0.020	0.015-0.07						
SPHE	≤0.03	≤0.03	0.10-0.30	≤0.030	≤0.020	0.015-0.07						
SAE1006	≤0.06	≤0.03	≤0.40	≤0.030	≤0.020	0.02-0.07						
SAE1008	≤0.10	≤0.04	≤0.50	≤0.025	≤0.025	0.02-0.07						
MR-1	0.05-0.08	≤0.03	0.30-0.50	≤0.020	≤0.015	0.03-0.07	≤0.06					
MR-2	0.07-0.10	≤0.03	0.35-0.45	≤0.020	≤0.015	0.03-0.07	≤0.06					
MR-3	0.08-0.11	≤0.03	0.45-0.55	≤0.020	≤0.015	0.03-0.07	≤0.06					
MR-4	0.045-0.065	≤0.03	0.25-0.35	≤0.020	≤0.015	0.03-0.07	≤0.06					
TIF-1	≤0.005	≤0.03	0.10-0.20	≤0.015	≤0.015	0.02-0.06	≤0.04	≤0.015	≤0.015	≤0.010		0.045-0.070
TIF-2	≤0.005	≤0.03	0.10-0.20	≤0.015	≤0.015	0.02-0.06	≤0.04	≤0.015	≤0.015	≤0.010	≤0.020	0.045-0.070

产品规格矩形图mm Product specification table

厚度 Thickness	宽度 Width	900-1200	1200-1380	1380-1500	1500-1800	1800-2100
1.2-1.5					*****	*****
1.5-2.0						*****
2.0-2.5						
2.5-3.0						
3.0-5.0						
5.0-8.0						
8.0-12.0						
12.0-16.0						
16.0-20.0		*****				
20.0-25.4						

太钢冷轧用料标准和机械性能
The specification and mechanical property of TISCO hot rolled coils for cold rolling

牌号 Grade	机械性能 Mechanical property				标准号 NO. Specification	规格范围 Size range
	Rel,MPa	Rm, Mpa	A, %	180° 横向冷弯试验 Cold bend test		
Q195L	≥195	315-430	≥33	d=0.5a 完好	Q/TB3066-2007	1.8-16×870-2130
Q195LD	≥195	315-430	≥33	d=0.5a 完好	Q/TB3066-2007	1.8-16×870-2130
SPHC		≥270	≥31	d=0.5a 完好	Q/TB3802-2007	2.0-12.7×870-1800
SPHD	≥180	≥270	≥30	d=0.5a 完好	Q/太新009-2008	1.5-6×870-2130
SPHE	≥160	≥250	≥32	d=0a 完好	Q/太新009-2008	1.5-6×870-2130
SAE1006	≥180	≥270	≥30	d=0a 完好	Q/TX3219-2006	1.5-6×870-2130
SAE1008	≥180	≥270	≥30	d=0.5a 完好	Q/太新079-2008	1.6-6×1000-2100
MR-1					Q/太新061-2009	2-5×870-2130
MR-2					Q/太新061-2009	2-5×870-2130
MR-3					Q/太新061-2009	2-5×870-2130
MR-4					Q/太新061-2009	2-5×870-2130
TIF-1	≤310	≤400	≤40	d=0a 完好	Q/TX3293-2007	3-5×870-2130
TIF-2	≤310	≤400	≤40	d=0a 完好	Q/TX3293-2007	3-5×870-2130

T 服务承诺 The service promise

- 为客户提供个性化成份、性能、包装、卷重、质保书的设计。
 - 交货准确及时；交货期不超过30天。
 - 技术服务：为用户在合理选材及其加工、焊接工艺和使用环境等个性化需求方面提供技术支持。
 - 对客户投诉，在24小时内答复，一周内结案。
 - 服务热线：800-806-1998
- Provide for consumers with the individual designs for composition, properties, package and the quality certificate.
 - Delivery in time : delivery periods will never exceed 30 days.
 - Technical service: offering users' special requirement for selecting materials, processing, welding technology and application environment etc.
 - Answering consumer' s complains within 24hrs. and ending a case within a week.
 - Service line; 800-806-1998

P 产品应用 PRODUCT APPLICATION

1、食品、饮料、喷雾罐、高档化工罐、医疗、包装、纺织和电子元件

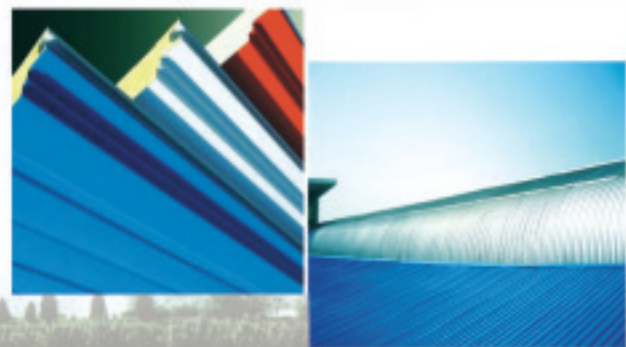
Tin of food, softdrink, sprayer, top grade chemical, medical, package, weave and electronic elements.



2、家用电器的冰箱、洗衣机、空调、电脑等 Appliance, refrigerator, washer, aircondition, computer



3、建筑、交通、家具、家电、电子行业的箱体结构和内外装饰、现代工业厂房、门窗等 Architecture, transportation, furniture, electronic industry, adornment, modern workshop, windows and doors



4、汽车制造、冲压成型件 Automotive manufacture, cold stamping parts



P 产品标识与包装 PRODUCT MARK AND PACKAGE

钢卷标识

Coil mark



山西太钢不锈钢股份有限公司 SHANG TAIANG STAINLESS STEEL CO., LTD.			
品名	规格	重量	备注
牌号	厚度	长度	其他
钢厂	产地	日期	其他
联系人	电话	地址	其他

1549mm碳钢热轧卷
1549mm hot rolling carbon steel






2250mm热轧卷
2250mm hot rolled coil

- ▶ 每卷钢带应粘贴二张产品标签，内圈一张，外圈一张。
Adhering two marks per coil, one inside and one outside.
- ▶ 在钢卷眼内喷印钢号、规格、重量，在钢卷端部喷印卷号。
Marking the steel grade, size and weight in the eye of coil and the number at the end

1549钢卷包装 1549mm coil packing

钢带卷类型 Types of strip	捆扎道次		捆扎示意图 Strapping times For example
	径向 Radial direction	周向 Circumference direction	
一般产品 >2.50 mm Normal product >2.50mm		≥3	<p>周向捆扎3条网式包装带，周向带间隔300mm，纵向包装带间隔600mm。 3 network pattern packing straps around circumference 300mm distance between each strap around circumference 600mm distance between each strap on the transverse direction.</p> <p>纵向包装带 Strap around circumference 焊接纵向包装带 Welded transverse strap 包装带接口钢卡 Steel clamp for strap corrections</p>
集装箱板 及薄规格产品 ≤2.50 mm Container plate and thin plate specification	≥2	≥3	<p>周向捆扎3条网式包装带；径向捆扎2条穿芯包装带；打径向包装带时在钢卷角部加护角。 3 network pattern packing straps around circumference 2 eye packing straps on radial direction when strapping on radial direction fill up protection angle.</p> <p>护角 Protective angle 穿芯带 Eye straps 接口钢卡 Steel fastener 焊接纵向包装带 Welded transverse strap 纵向包装带 Strap around circumference</p>
品种钢 Special steel	≥6	≥3	<p>周向捆扎3条网式包装带；径向捆扎6条穿芯包装带；固定内外圈加衬的镀锌铁皮防护卡圈。 3 network pattern packing straps around circumference 6 eye packing straps on radial direction; fixing lining galvanization locking ring inside and outside.</p>

2250直发卷、平整卷和卷切板包装
2250common coil, coil leveled and cutting plate packing

方案号 Number	类型 Type	说明 Explanation	图示 For example
1	碳钢商品材直发卷 Commercial coil	1、三条周向捆带均匀分布，捆带间距400mm。 2、卷重≤10吨时打一条穿心带，带间加护角。卷重>10吨时不打穿心带。 3、X65以上加装其它包装夹具。 1. 3 straps of even distribution around the circumference distance of straps is 400mm. 2. Weight of coil ≤ 10 tons, one eye strapping without protection angle weight of coil > 10 ton without eye strapping. 3. Adding other packing clamp for X65-X80	
2	平整卷 重卷卷 Coil leveled Coil recoiled	1、宽度(B)≤1600mm时，三条捆带；B>1600mm时四条捆带。 2、卷重≤10吨时打一条穿心带，不加护角。卷重>10吨时不打穿心带。 1. Width ≤ 1600mm, 3 straps B > 1600mm, 4 straps. 2. Weight of coil ≤ 10 tons, one eye strapping without protection angle weight of coil > 10 ton without eye strapping.	
3	碳钢卷切板，长度<6000mm Cutting plate of carbon steel length < 6000mm.	两组捆带分别捆扎两端，两边捆带距两头300mm，捆带间距200mm。 Strapping separately on double end with two groups of strap distance between straps and head of plate is 300mm distance of straps is 200mm.	
4	碳钢卷切板，长度≥6000mm Cutting plate of carbon steel length ≥ 6000mm.	每1m~1.5m一条捆带，均匀分布。 Even strap distribution at intervals of 1m~1.5m.	
5	平行四边形、梯形卷切板 Parallelogram and echelon plate cut	用两组捆带分别捆扎两端，两边捆带距最近端点300mm，组内捆带间距200mm。 Strapping separately on double end with two groups of strap distance between straps on both sides and nearest end is 300mm distance of straps of group is 200mm.	

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