

Hot Dip Galvanizing Line

Working Process

Feeding wires-->Hot water washing-->Heat treating with gas furnace-->Air cooling
-->Water cooling-->Electrolysis acid washing-->Water cleaning-->Assist galvanizing
-->Dry-->Hot dip galvanizing-->Take up wires





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Specification	
Number of wires	28
Diameter range	1.6mm - 4.0mm
Weight of Zinc layer	100g/square meter
Speed (DV)	36mm*m/min
Carbon content of the steel wire	≤0.30%
Annual work hours	8100 hours
Capacity	6235T/year
Wire pay off system	28pcs dial type wire pay-off
Wire take up system	28pcs inverted wire take-up
Hot Water Tank (with Circulating Pump)	Length 1.4m
Furnace	fuel: Natural Gas
	Calorific Value of Gas: 8000X4.186 KJ/Nm3
	Capacity: 6230T/year
	Consumption of Gas: ≤60m3/T
	Inner Width of Furnace: 1160mm
	12 burners
Water Cooling Tank(with Circulating Pump)	Length 1.4m
Electrolysis acid Tank(with Resistant Pump)	Length 5.8m
	Material: PP
	Electrolyte: H2SO4
	Temperature of Electrolyte
Water Tank(with 2 Resistant Pump)	Length 1.7m
Assist galvanizing Tank(with Circulating Pump)	Length 2m
Dry Oven	Length 4m
	Drying Mode: Heated Air Circulating
	Temperature : > 120°C
Hot dip galvanizing Tank	Outside Dimension: 4060X2842X1360mm
	Inner Dimension: 3248mmX2030X1036mm
	6 Burners
	Max.Temperature: 440--480°C
	Storage Volume of Zinc: 38T

Electric Galvanizing Line

Process Flowing

1. Raw material Decoiling >>
2. Wire Tensioning >>
3. Electrolytic Acid cleaning >>
4. Cooling Water Cleaning >>
5. Electric Zinc-plating >>
6. Cooling Water Cleaning >>
7. Cooling Water Cleaning >>
8. Hot Water Cleaning >>
9. Drying >>
10. Spooling

Main Technical Parameters

1. No. of Galvanizing Line: 10
2. Total Power: 50kw (frequency)
3. Dia. of Wire: 1.5-4.0mm
4. Max. Speed: 55m/min.
5. Average Capacity: 1000kg/h
6. Length of Production Line: 80M
7. Operator needed for production line: 4 operators + 1 manager

