

# Heat Treatment Meets Metallurgy

Steel Treatment in Perfection





# TENOVA LOI THERMPROCESS

Tenova LOI Thermprocess with headquarters in Duisburg, Germany, is one of the leading companies in supplying industrial furnace systems for the heat treatment of metals. Worldwide clients from the steel, aluminium and automotive industries rely on the technical solution competence and thousands of references. With a history of over 100 years Tenova LOI Thermprocess represents the entire know-how in the field of material properties and secondary metallurgy. Tenova LOI Thermprocess is a global partner represented in all major markets throughout the world.

Being a driver in the transformation of the metals industry towards decarbonization and sustainability, we implement proven thermoprocess solutions and focus on the development and implementation of fossil-free annealing technologies, especially Hydrogen, as well as electrical heating capabilities in new plants and revamps.

The wide portfolio of technologies meets the most demanding market requirements including batch and continuous heat treatment lines for steel strip, heavy plates, pipes & tubes and forgings. Tenova LOI Thermprocess technologies for production of grain-oriented (GO) and non-grain-oriented (NGO) electrical steel pave the way for e-mobility with state-of-the-art heat treatment equipment. Sustainable solutions such as melting and recycling furnaces for aluminium support reduction of waste and energy consumption.



# Heat Treatment meets Metallurgy – Steel Treatment in Perfection

Tenova LOI Thermprocess offers the full range of solutions for the whole life-cycle of the equipment from a single source: Comprehensive process know how, design (mechanical, electrical and automation), project management and installation as well as modernization, maintenance and service.

Digitalization is one of the key drivers in our business. All our processes are enhanced by our smart digital solutions.

Tenova LOI Thermprocess offers reliable and green solutions that minimize the environmental impact and guarantee quality, production efficiency and safety. Tenova LOI Thermprocess is a trademark of Tenova.



**ALLINO**

**BBC**  
BROWN BOVERI



**KOPPERS-WISTRA**  
Koppers-Wistra-Ofenbau G.m.b.H. Düsseldorf/Heerd



**Dr.SCHMITZ+APELT**

*Indugas*



**WISTRA GMBH**  
Thermoprozesstechnik



**LOI ESSEN**



**LOI Italimpianti**  
TENOVA

**LOI-SAAR**  
INDUSTRIEOFENANLAGEN GMBH



**LOI**  
THERMPROCESS



**LOI WIEN**  
Industriefenanlagen

**LUDWIG**

**LUDWIG-OFAG-INDUGAS**



**LVE**  
Verfahrenselektronik



**möhl**  
GEGR. 1856



**NASSHEUER**



**NASSHEUER LOI**  
Industriefenanlagen



**SCHMITZ+APELT LOI**  
Industriefenanlagen

**TECHNOMETAL**

# REHEATING OF LONG OR FLAT PRODUCTS AND FORGINGS

As supplier, main contractor or in cooperation with other companies, we deliver the mechanical and electrical design of industrial furnaces and complete plants or lines together with Tenova Italmimpianti.

Key competences include highly advanced burner technologies as well as production automation and optimization. We manufacture and source locally and globally.

We offer reheating furnaces for hot formed materials, furnaces in casting and rolling lines for thin slabs and heat treatment plants for heavy plates and forged products.

- ▼ Tenova Italmimpianti Walking Beam Furnaces are suitable for heavy plates and heavy loads, especially if quenching is required.







### CHAMBER/BOGIE HEARTH FURNACES

*Reheating of large and heavy blocks or ingots*

### WALKING HEARTH FURNACES

*Reheating of billets, blooms, beam blanks*

### ROLLER HEARTH FURNACES

*Heating and holding of slabs*

### PUSHER TYPE FURNACES

*Reheating of blooms, slabs, billets, intermediate products/pre-shaped blanks*

### WALKING BEAM FURNACES

*Reheating for hot forming of long and flat products made from C steel, stainless steel, copper, grain oriented steel, titanium, special alloys*

### ROTARY HEARTH FURNACES

*Reheating for hot rolling and forging of blooms and billets of C steel and stainless steel*

Tenova Italmimpianti is the world's leading supplier of Rotary Hearth Furnaces for a variety of process applications and product types (up to 67 m in diameter), with over 300 references in its portfolio.

▲ In the forging industry, Tenova LOI Thermprocess Bogie Hearth Furnaces represent well-known technology as well as solutions that have been tried and tested in industry.

▼ Tenova LOI Thermprocess Rotary Hearth Furnace for long products with zone separation



## ROLLER HEARTH FURNACES FOR THIN SLABS

*Intermediate heating and holding for thin slab casting and rolling with slab lengths of 30–50 m and a thickness between 40 to 90 mm, endless rolling of bar lengths up to 300 m.*

Tenova Italmimpianti has supplied

- the longest furnace,
- the furnace with the highest temperature (up to 1,250 °C),
- the first operating furnace with three lines.



# HEAT TREATMENT PROCESSES

## DETERMINE THE MICRO-STRUCTURE OF METALS

Tenova LOI Thermprocess heat treatment furnaces feature advanced process technology which

- precisely meets the requirements for the microstructure,
- achieves a homogenous temperature distribution inside the parts,
- prevents shape distortion of the material and
- avoids high internal stresses.

## DETERMINE THE SURFACE QUALITY

Tenova LOI Thermprocess heat treatment technology offers tailor-made surface quality.

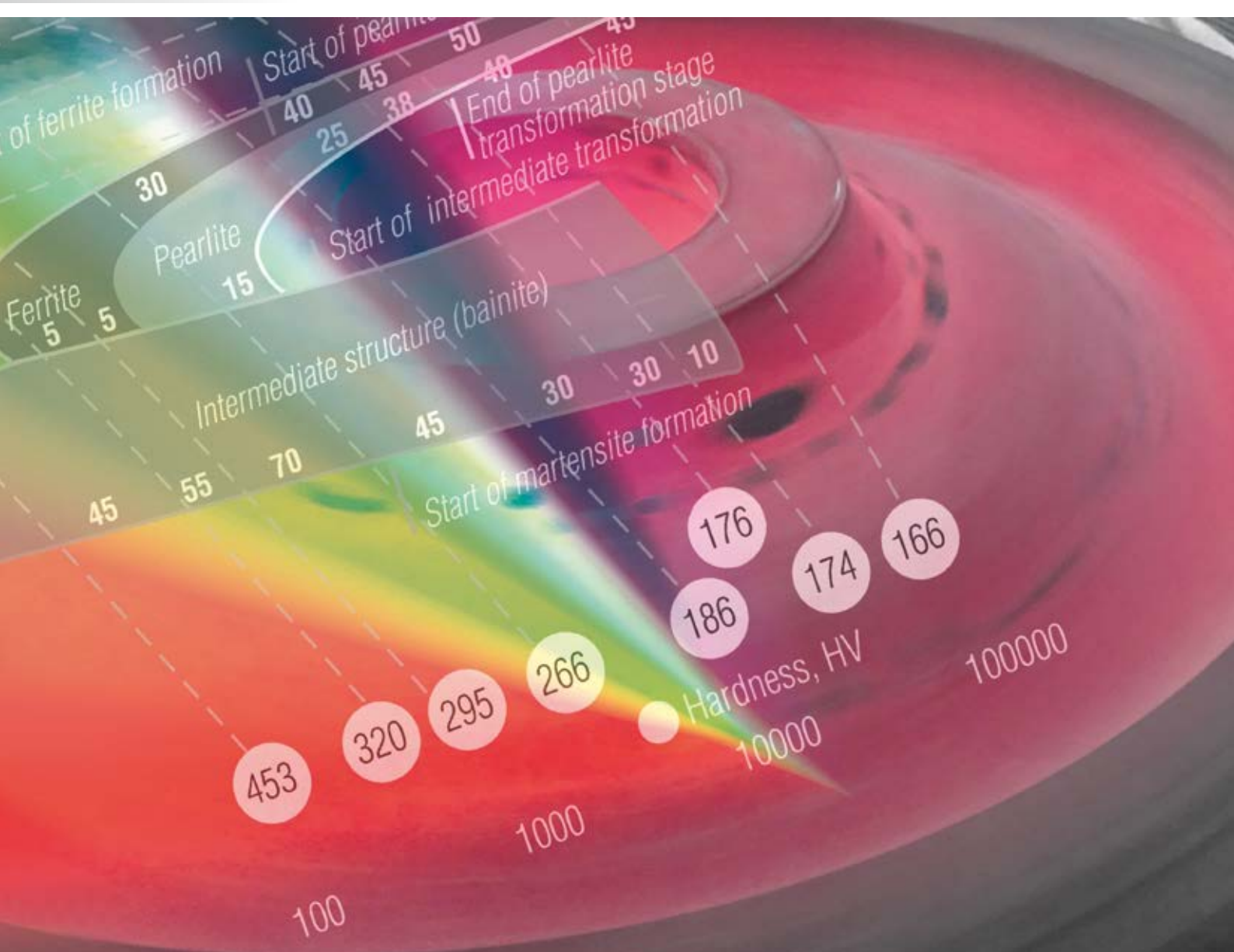
## MODIFY THE SURFACE BY METALLIC AND NONMETALLIC COATINGS

Tenova LOI Thermprocess heat treatment furnaces galvanize, aluminize or coat.

## MODIFY THE SURFACE LAYERS BY CHEMICAL PROCESSES

Several hundred Tenova LOI Thermprocess heat treatment furnaces for case hardening or austenitizing have been installed for the automotive industry.

▼ The key to the definition of the microstructure of metals is the cooling of the material. The behavior is described in TTT diagrams like the one shown below.





# Tenova LOI Thermprocess Portfolio

## *Hot Formed Materials*

- Reheating furnaces
- Furnaces in casting and rolling lines for thin slabs
- Heavy plate heat treatment lines
- Heat treatment lines for forged components



## *Rod, Wire and Tube*

- Heat treatment plants for tubes and bars
- Heat treatment plants for rods and wire



## *Strip*

- H<sub>2</sub> Bell-type Annealing Furnaces HPH\*
- Processing lines for electrical steel strip
- Continuous strip galvanizing lines



## *Components*

- Atmosphere furnaces
- Protective gas furnaces
- Galvanizing plants



## *Aluminium*

- Melting and casting furnaces
- Twin-Chamber Melting Furnaces TCF\*
- Heat treatment plants for Al components
- Heat treatment plants for strip coils and foils



## *Customer Service*

- Modernization
- Retrofit
- Relocation
- Technological service
- Spare parts
- Service



# Q&T Quenching and Tempering Lines for Heavy Plates

*C steel, stainless steel*



▲ Tenova LOI Thermprocess heat treatment lines (austenitizing, quenching, tempering) for heavy plates



▲ With the iQuench® tailored quenching technology Tenova LOI Thermprocess offers a wide variety of quenching modes and the full range of heat transfer combined with a powerful and unique mathematical material model and overall automation.

Tenova LOI Thermprocess Q&T Lines for Hardening, Normalizing and Tempering are ideal for mass

producers as well as niche producers with small lots. The key equipment is the water quench. Our quenching technology is precisely tailored to customers' growing requirements for process security, quality and flexibility. Tenova LOI Thermprocess has been the leading company in this field since the 1990s with more than 30 quench installations and more than 50 furnace installations through-

out the world. Tensile strengths of more than 1.500 MPa can be achieved by our Q&T technology. Reaching material hardness higher than 500 HBW, a Q&T Line is also the right tool for producing abrasion-resistant steel. Plates can be produced with widths up to 5 m, thicknesses from 3 mm up to more than 150 mm and lengths up to 30 m.



▼ Tenova LOI Thermprocess NF Roller Hearth Furnace for normalizing of heavy plates



# Heat Treatment Lines for Forged Products

*Forgings, high-performance railway wheels*



▲ Tenova LOI Thermprocess continuous heat treatment line for high-speed railway wheels

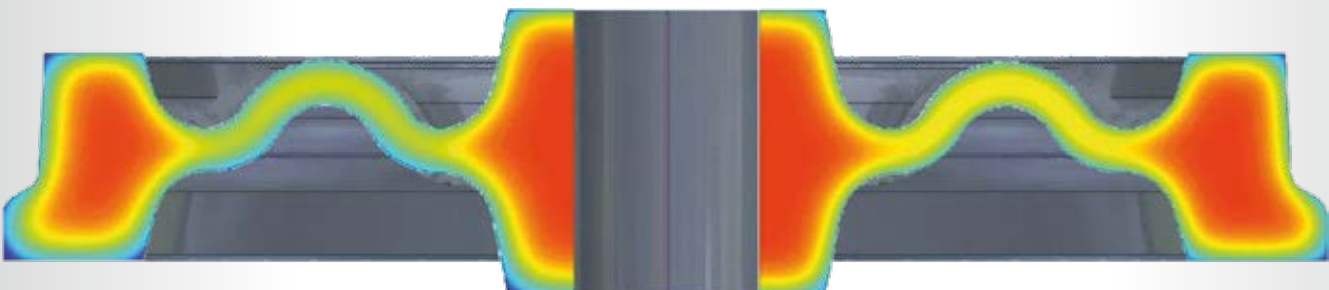
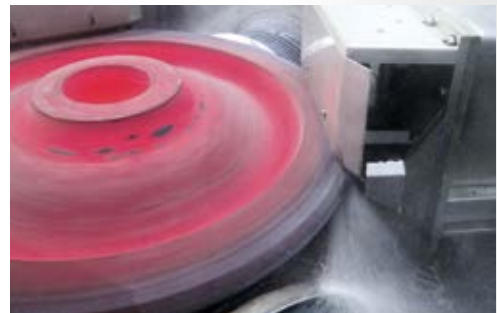
The example above shows one furnace for austenitizing and two furnaces for tempering (with an overall length of approx. 100 m) combined with 8 Hardening Tables.

The whole system is combined with auxiliary transportation and quality assurance systems and highly automated. It operates practically in line with a forging press, which means that a typical output of 70 wheels

per hour can be reached. Different furnace dimensions and numbers of Hardening Tables are possible, depending on the customer's needs.

## QUENCHING OF HIGH-PERFORMANCE RAILWAY WHEELS

In order to reach a long service life, railway wheels must have a fine perlitic structure over a certain depth under the contact surface with the rails. A highly complex quenching process is necessary with a dedicated system of nozzles spraying water onto the wheel with different flows depending on the position of the wheel and time. A mathematical model adapts the quenching process to each individual type of wheel.



# Heat Treatment Plants for Tubes and Bars

*Carbon steel, stainless steel, non-ferrous metals for long products and coils*



## ROLLER HEARTH FURNACES

Tenova LOI Thermprocess offers continuous and semi-continuous Roller Hearth Furnaces with protective and reactive gas atmospheres as well as heat treatment processes to meet the highest requirements regarding chemical composition and mechanical properties.

The controlled atmosphere meets the requirements for bright annealing and prevents unwanted reactions like decarburization. Tenova LOI Thermprocess Roller Hearth Furnaces are also in accordance with the CQI-9 standards for products used in the automotive industry.

## STAINLESS STEEL

- up to 100 % H<sub>2</sub>
- annealing temperatures up to 1,200 °C
- jet cooling gradient up to 5 K/sec between 900 - 400 °C

## CARBON STEEL

- activity controlled carbon atmospheres
- annealing temperatures up to 1,050 °C
- highly efficient heat recovery systems available, if required



▼ Tenova LOI Thermprocess continuous Roller Hearth Furnace for bright annealing of LWCs (level wound copper tubing)

▲ Tenova LOI Thermprocess Roller Hearth Furnace for bright and carbon neutral annealing of precision steel tubes in endogas-nitrogen atmosphere

## WALKING BEAM FURNACES

Tenova LOI Thermprocess provides tempering furnaces, hardening furnaces and innovative quenching systems.





# Heat Treatment Plants for Rod and Wire

*High quality rod and wire coils*



**ROLLER HEARTH FURNACES**  
Carbon, alloyed and stainless steel, copper wire

◀ Tenova LOI Thermprocess Roller Hearth Furnace plant with a protective atmosphere for wire coils



**HPH® BELL-TYPE ANNEALING FURNACES**  
Carbon, alloyed and stainless steel, copper wire

These furnaces are equipped with HPH® (High Performance Hydrogen) technology. High-quality annealing results can be reliably reproduced. Uniform mechanical and metallurgican properties lay an excellent foundation for cold working.

▲ Schematic of Tenova LOI Thermprocess HPH® Bell-type Annealing Furnace



## HIGH PERFORMANCE HYDROGEN BELL-TYPE ANNEALING PLANTS

*Rolled or drawn wire coils of carbon or stainless steel as well as non-ferrous metals*

- Tenova LOI Thermprocess market share over the past 10 years approx. 50 %
- Both multi-stack and single stack plants available
- N<sub>2</sub>, H<sub>Nx</sub> or 100 % H<sub>2</sub> atmosphere
- Plants with recirculation up to material temperature of 900 °C
- High-performance atmosphere gas recirculation system
- Stack height up to 5,600 mm
- Charge weight: up to 90 t
- Patented HPH® Jet Cooling Hood



# Heat Treatment Plants for Steel Strip

## HPH® BELL-TYPE ANNEALING FURNACES BAF FOR STEEL STRIP

Material: Hot and cold rolled, CQ to EDDQ, HSQ, high carbon steel, tinplate T1 – T4, AISI 400, stainless steel

▼ Typical installation of an HPH® Bell-type Annealing Furnace plant for steel strip



Throughout the world, more than 8,500 Tenova LOI Thermprocess annealing bases have been installed. About 5,000 of these bases operate with HNx controlled atmosphere. More than 3,500 bases use HPH® (High Performance Hydrogen) annealing technology with a pure hydrogen annealing atmosphere.

Tenova LOI Thermprocess is therefore also the market leader in the field of high performance Bell-type Annealing Furnaces.

Tenova LOI Thermprocess HPH® technology ensures atmosphere dew points below  $-60\text{ }^{\circ}\text{C}$ . An extremely pure hydrogen annealing atmosphere and precise temperature control bring considerable quality benefits with a wide variety of steel grades. The temperature uniformity inside the total stack at the end of soaking will be within a range of  $\pm 5\text{K}$ .

## HPH® BELL-TYPE ANNEALING FURNACES FOR NON-FERROUS STRIP

The atmosphere used depends on the specific alloys and the annealing process which is required. The gases which are available include pure hydrogen, nitrogen or mixtures of the two.

- Sophisticated plant design and process technology for high productivity and material quality
- References: first reference from 1949
- Both single-stack and multi-stack bases available
- Very high process quality: dew points below  $-60\text{ }^{\circ}\text{C}$
- Useful diameters 800 to 2,400 mm

Tenova LOI Thermprocess HPH® Bell-type Annealing Furnace plant for non-ferrous metals  
Material: non-ferrous metals, mainly copper and copper alloys ►





### MULTI STACK BELL-TYPE ANNEALING FURNACES MBAF FOR SILICON STEEL STRIP

The requirement for reduced losses in the transmission and transformation of electric power has created a huge demand for

electrical steel (silicon steel). Especially the production of grain-oriented GO silicon steel requires various heat treatment routes in different continuous processing lines and high temperature batch-type plants.

Tenova LOI Thermprocess is the only company able to supply all types of heat treatment equipment required for silicon steel production.

- ▼ Tenova LOI Thermprocess Multi-Stack Bell-type Annealing Furnaces MBAF for silicon steel strip GO



### BELL-TYPE ANNEALING FURNACE PLANTS FOR SILICON STEEL STRIP

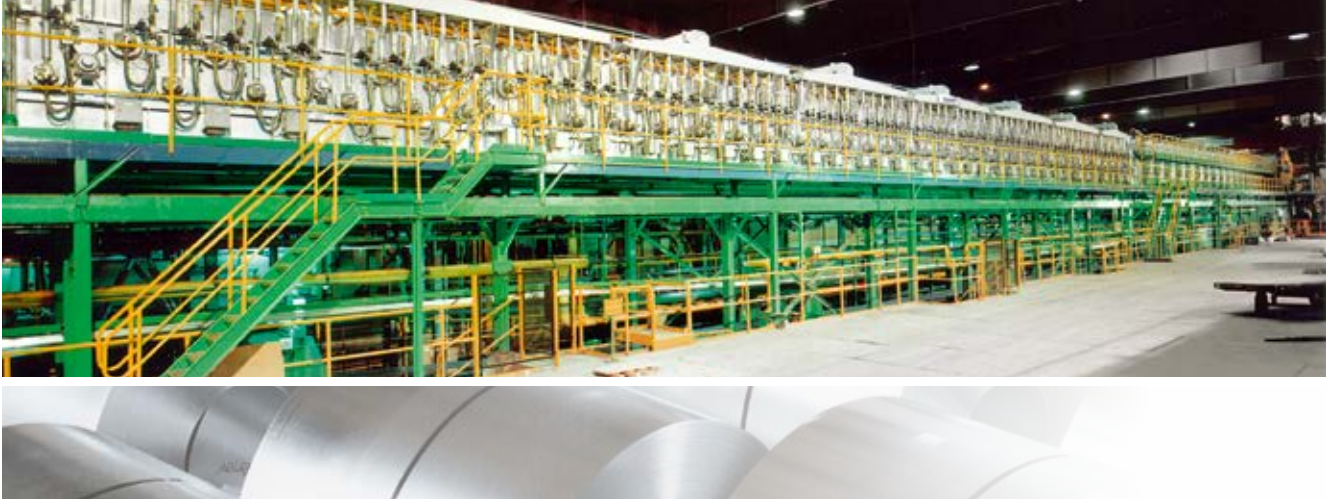
- MBAF Multi-Stack Plants (up to four stacks per heating hood)
- Tenova LOI Thermprocess references: > 400 bases
- Single and double layer design available
- Process temperatures up to 1,250 °C
- Electrically powered and gas fired heating hoods
- Annealing in a nitrogen, hydrogen or mixed atmosphere
- Cooling by cooling systems integrated in heating hood





# Continuous Heat Treatment Lines for Carbon and Silicon Steel Strip

*Carbon and silicon steel*



▲ Tenova LOI Thermprocess Continuous Galvanizing Line CGL for carbon steel strip

▼ Tenova LOI Thermprocess Decarburizing and Coating Line DCL for grain oriented GO silicon steel strip

## CONTINUOUS GALVANIZING LINE CGL

The heat treatment process for the strip includes heating, soaking, slow cooling and rapid cooling before it enters the coating pot containing the liquid zinc.

## ANNEALING AND PICKLING LINE APL

The hot-rolled strips (non grain oriented NGO and GO) are initially annealed in a continuous process line. During annealing, the microstructure is changed in order to reduce brittleness and increase ductility before cold rolling. The annealing process is followed by







▲ Tenova LOI Thermprocess Flattening and Coating Line FCL for GO silicon steel strip

a controlled cooling stage with cooling rates tailored to the steel grade.

### **DECARBURIZING AND COATING LINE DCL**

Cold-rolled GO silicon steel strip is annealed in a continuous process line for primary recrystallization and decarburization. After the steel strip has passed through the DCL furnace, it is coated with magnesium oxide and dried.

### **FLATTENING AND COATING LINE FCL**

For the final heat treatment process the silicon steel strip is coated with insulating varnish in an in-line process, then dried in an indirectly heated furnace and straightened using the integrated hot stretching equipment. This stage is followed by a slow cooling process.

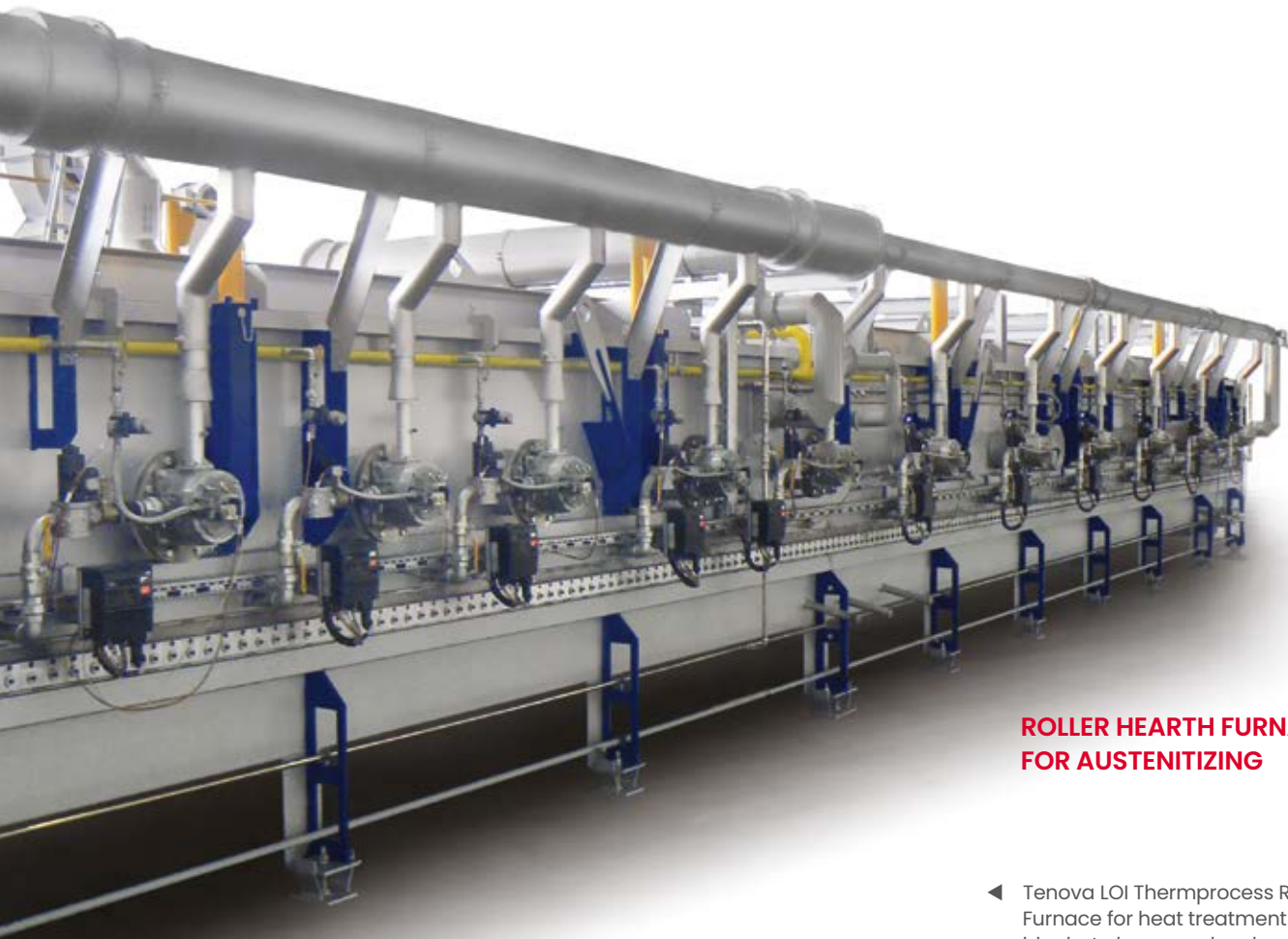
### **ANNEALING AND COATING LINE ACL**

NGO strip is annealed in a radiant tube furnace using a continuous process after cold rolling to ensure recrystallization and controlled grain growth. Top-quality steel requires strip temperatures above 1,100 °C and a very dry atmosphere with a high hydrogen content.





# Heat Treatment Plants for Automotive and Structural Parts



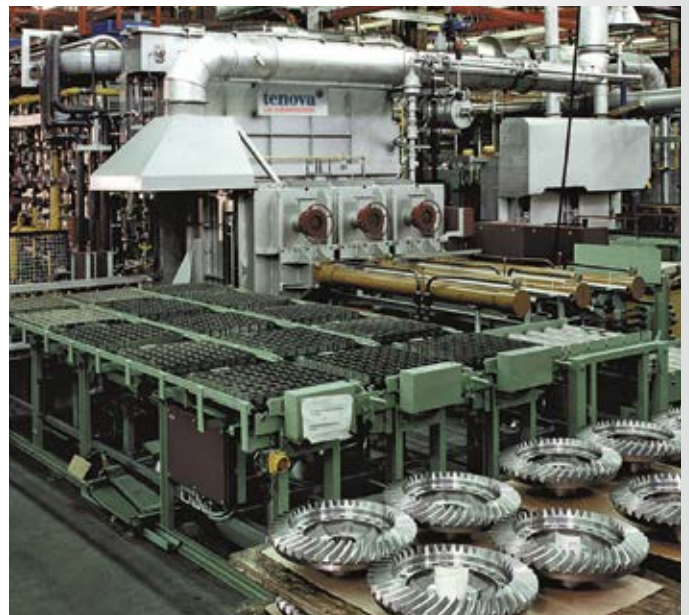
## ROLLER HEARTH FURNACE FOR AUSTENITIZING

- ◀ Tenova LOI Thermprocess Roller Hearth Furnace for heat treatment of metal blanks to be press-hardened

## HEAT TREATMENT OF AUTOMOTIVE AND STRUCTURAL PARTS

Since 1950 Tenova LOI Thermprocess has supplied several hundred case hardening lines for automotive parts with carburizing furnace, quench, washing machine, tempering furnace and fully-automated material handling:

Comprehensive practical knowledge of carburizing, decarburizing, quenching, nitriding and other processes is combined with a wide range of mathematical models developed in-house.







### ROTARY HEARTH FURNACE WITH ZONE SEPARATION FOR CASE HARDENING

Tenova LOI Thermprocess's original heat treatment technology for case hardening as well as for quenching and tempering steels has been continuously improved and developed into the Tenova LOI Thermprocess Rotary Hearth Furnace featuring zone separation, which allows optimum process control.

▲ Tenova LOI Thermprocess Rotary Hearth Furnace with zone separation for gas carburizing of gear parts and Q&T steels

## GALVANIZING PLANTS

### Galvanizing furnace for high temperature

Galvanizing furnaces with ceramic application areas are used for galvanizing small parts.

### Galvanizing furnace with kettle

Galvanizing furnaces with kettle are used for galvanizing large structural steel components.

### Drying furnace

The drying furnace is an integral part of the production line and is adapted to the overall material flow concept of the galvanizing workshop.

### Zinc bath housing

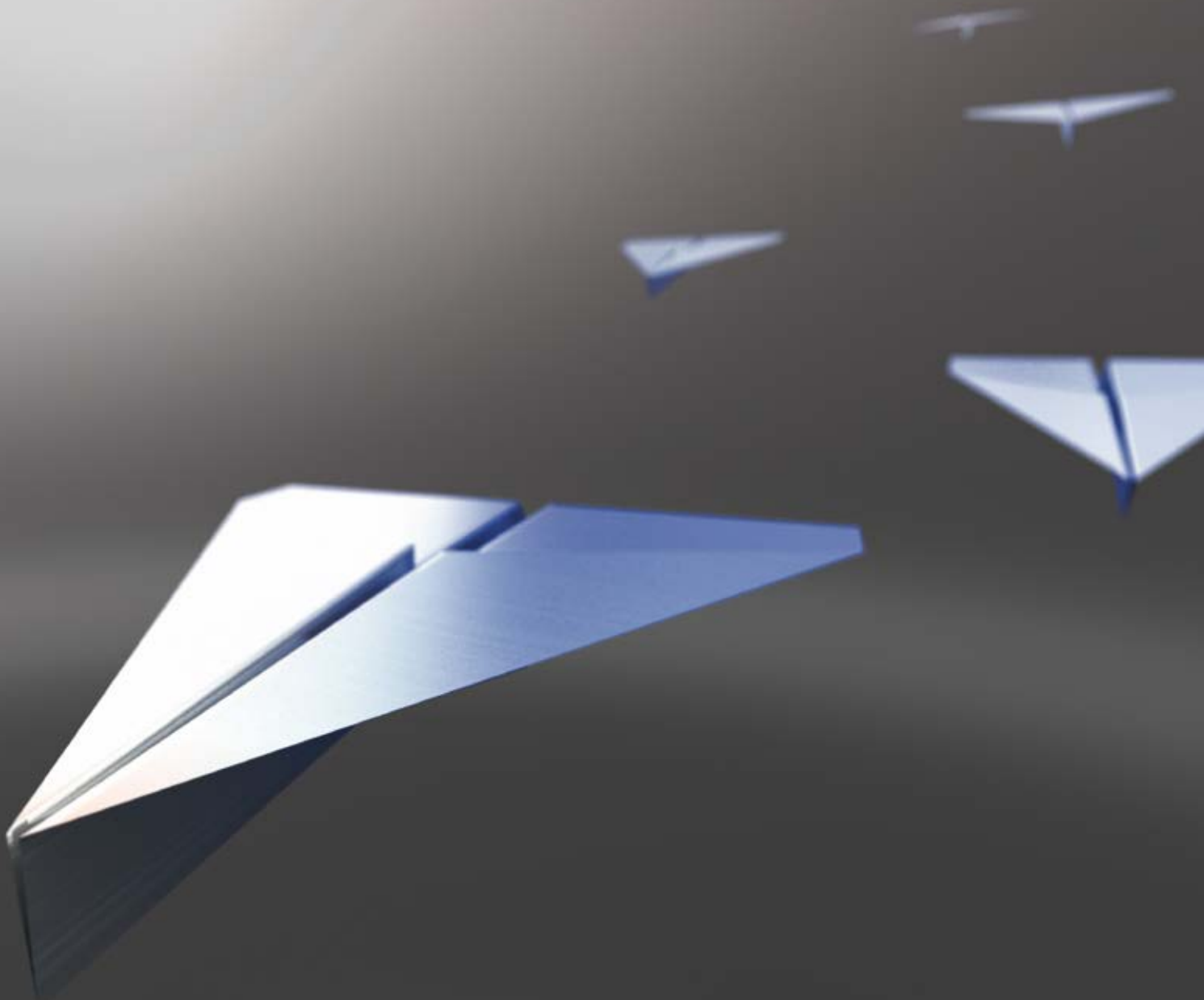
The zinc bath housing collects all the fumes arising when the products are dropped into the liquid zinc. From the housing the fumes are extracted to the fume purification plant.

Tenova LOI Thermprocess high-temperature Galvanizing Furnace with Zinc Bath Housing ►



# ALUMINIUM – LIGHTWEIGHT, INNOVATIVE AND COMPLETELY RECYCLABLE

Due to its unique properties and the optimal recyclability of used aluminium components, aluminium is a trend-setting material in the automotive, mechanical engineering and aviation industries. Aluminium outclasses alternative materials with regard to many future-oriented solutions.





# Aluminium Melting, Casting and Recycling Furnaces



## TCF® RECYCLING TECHNOLOGY

Contaminated scrap is recycled without pre-treatment. Organics are pyrolyzed and burned inside the furnace. The pyrolysis gas, which contains combustibles, contributes to heating the furnace. The salt-free melting process allows the environmentally compatible recycling of aluminium scrap.



## TWIN-CHAMBER MELTING FURNACE TCF®

The Tenova LOI Thermprocess Twin-Chamber Melting Furnace TCF® provides a process for recycling end-of-life and production return scrap with high metal yield. Typical liquid metal production rates are in the range of 80 to 180 t/day.



## MELTING CASTING HOLDING FURNACES

These furnaces can be tilted for the controlled and reliable transfer of liquid metal to the casting equipment. The furnace chambers are heated by ambient air or regenerative hot air burners and can be equipped with porous plugs, rotary gas injectors or electromagnetic stirrers.

▼ Melting Furnaces MCF with a bath capacity of 55 t each



# Heat Treatment of Aluminium Automotive Components



## HEAT TREATMENT LINES FOR CAST ALUMINIUM PARTS

The heat treatment of castings like engine blocks and suspensions is a combination of solution annealing, quenching and ageing.

## HEAT TREATMENT LINES FOR FORGED ALUMINIUM PARTS

The heat treatment of forgings is a combination of solution annealing, quenching and ageing, where accurate quenching of individual parts is required.

- ▲ Tenova LOI Thermprocess multi-lane chain conveyor furnace with single-part quenching



- ▲ Tenova LOI Thermprocess AirQuenchSystem AQS for structural components
- ◀ Tenova LOI Thermprocess age hardening line (Overhead Annealing Line OAL) with MediaQuenchSystem MQS, quench baths move under the furnaces

## HEAT TREATMENT LINES FOR ALUMINIUM STRUCTURAL PARTS

For thin structural parts for automobiles air quenching is applied. This ensures less distortion and less residual stress. Sensitive cooling and adequate quenching technologies are required.

All lines can be offered as continuous or batch type.

## HEAT TREATMENT OF AUTOMOTIVE PARTS

**al-loi**  
THERMAL PROCESSES  
FOR ALUMINIUM





# Heat Treatment of Aluminium Strip Coils and Foils



▲ Tenova LOI Thermprocess Single-Coil Annealing Line SCL for aluminium strip

▲ Tenova LOI Thermprocess Final Annealing Line FAL for heat treatment of aluminium foil rolls

## FINAL ANNEALING LINES FAL

FAL are used for the heat treatment of aluminium foil rolls. The multi-chamber furnace design combines several individual chambers in one furnace casing. One furnace consists of up to five individual chambers, which operate independently.

▼ Tenova LOI Thermprocess Final Annealing Line FAL for heat treatment of aluminium foil rolls

## FURNACES FOR ALUMINIUM COILS

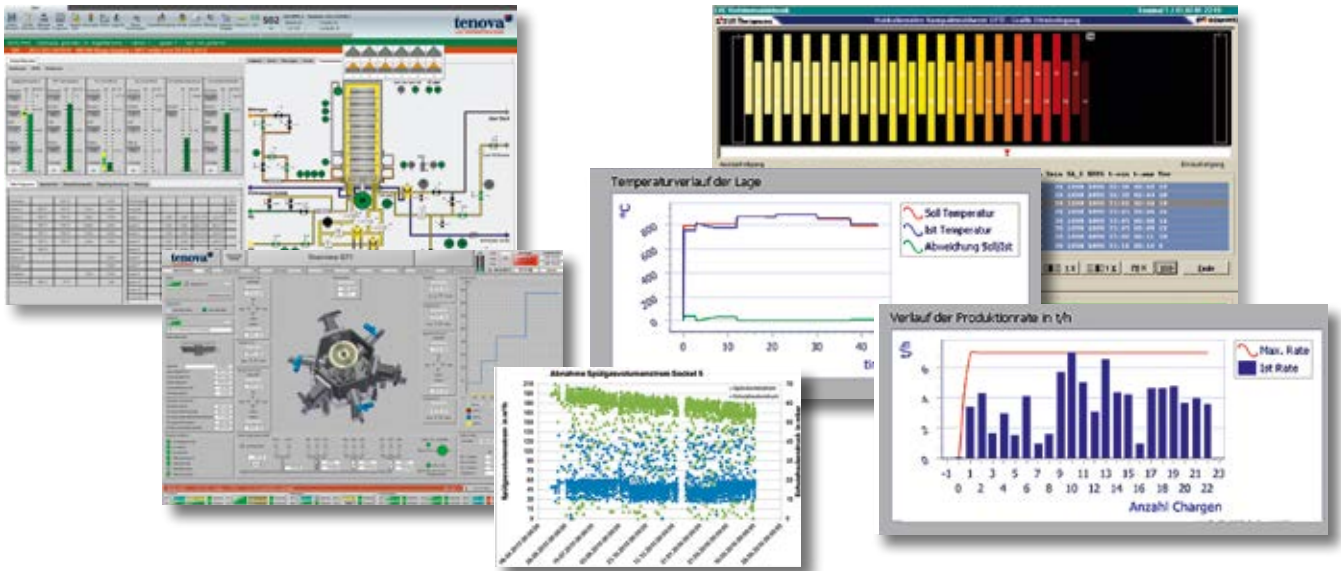
Single-coil annealing improves the flexibility of production schedules and avoids complex batches of different coils.

For larger batches of the same coils the Multi-Coil Annealing Line MCL is the right choice. Furnaces are loaded automatically with one batch consisting of several coils.



# Controls for Furnaces and Thermal Processes

*Fully automated control systems are indispensable. Modern control systems ensure:*



- High safety
- Optimized processes
- Constant, high product quality
- High plant availability
- High productivity
- Optimum conditions for operation and maintenance
- Minimal energy and utility consumption
- Lower pollutant emissions

Tenova LOI Thermprocess offers control systems including all the hardware and software required from the switchgear assembly to the supervisory control system.

- Comprehensive expertise in process electronics, control system engineering and automation

- Switchgear assemblies, components
- Automation
- Supervisory systems
- Mathematical modelling online and offline
- Throughput and material flow optimization





# SERVICE AND SPARE PARTS



Services backed by the expertise developed by Tenova LOI Thermprocess are available to our customers at all times and places. The world-wide presence of Tenova offers our customers direct access to our maintenance and modernization specialists.



## SERVICES

We provide our customers with tailor-made maintenance programs, regular technological updates, operation assessment and personnel training.

## SPARE PARTS

The right spare parts can be supplied within the shortest time (e.g. 24 h). On request, a web-based catalog for new and old equipment can be created, which facilitates the identification of spare parts and simplifies procurement considerably.

## MAINTENANCE AND REPAIR

Our experts are available for maintenance work on process control systems including mathematical models and on systems including mechanical and electrical elements, refractory linings, burners, heating/cooling systems, controllers and automation devices.

## MODEM AND TELEPHONE SERVICE

Control systems and connected plants can also be inspected online by remote diagnosis.

## RETROFIT AND MODERNIZATION

Our specialized service solutions allow customers to operate at the highest possible productivity and efficiency levels at the same time as focusing on safety and sustainable development.

## CONSULTANCY

Our process engineers and our commissioning and control systems specialists are available to provide advice to customers either on-site or via remote diagnosis.



# Sustainable solutions for a green transition of metals

## Tenova LOI Thermprocess Poland

**LOI Poland Sp. z o.o.**  
ul. Zagórska 79  
Tarnowskie Góry  
42-680 - Poland  
T +48 32 284 1639  
F +48 32 284 2223  
loi@tenova.com

## Tenova LOI Thermprocess India

**Tenova Technologies Pvt Ltd**  
IThink Techno Campus  
A Wing, 5<sup>th</sup> Floor  
Off Pokhran Road No. 2  
Thane (West)  
Thane, Maharashtra 400601  
India  
T +91 22 6248 9700  
tenova.in@tenova.com

## Tenova LOI Thermprocess Tianjin

**Tenova Technologies  
(Tianjin) Co., Ltd.**  
2<sup>nd</sup> Floor - Tower B,  
Keyuan Keji  
Development Centre No. 8,  
Keyuan East Road Tianjin  
Hi-Tech Industry Park  
Tianjin, 300192 - China  
T +86 22 87 890 588  
F +86 22 87 892 018  
loitj@tenova.com

## Tenova LOI Thermprocess United States

**Tenova Inc.**  
Cherrington Corporate  
Center Corporate Center  
Drive 100  
Corapolis  
PA 15108-3185 - United States  
T +1 412 262 2240  
F +1 412 262 2055  
tenova.usa@tenova.com



[www.tenova.com](http://www.tenova.com)

## Headquarters

Tenova S.p.A.  
Via Gerenzano, 58  
21053 Castellanza, VA  
Italy

TECHINT GROUP

**tenova**  
LOI THERMPROCESS

## LOI Thermprocess GmbH

Schifferstrasse 80  
47059 Duisburg  
Germany  
e-mail: [loi@tenova.com](mailto:loi@tenova.com)

[www.loi.tenova.com](http://www.loi.tenova.com)