







## 2025 AIST Cold Mill Roundup

AIST Roundup data is based on information submitted in the fourth quarter of 2024. Data is supplied by the AIST Cold Sheet Rolling Technology Committee and is intended for reference information only. No warranty is implied. Please send updates or corrections to Ken Landau at klandau@aist.org.

Company and location	Identification (unit name/type)	Start-up/ modernization	Mill builder (mechanical/electrical)	Configuration (No./type of standards)
<b>Argentina</b>				
<b>Ternium Argentina</b> Ensenada, BA	Tandem Cold Mill	1969	—	4-stand, 4-hi tandem
San Nicolás, BA	Tandem Cold Mill	—	—	4-stand, 4-hi tandem
<b>Canada</b>				
<b>Algoma Steel Inc.</b> Sault Ste. Marie, Ont.	80, 1-Stand Reversing Cold Mill	1965/1998– 1999	Dominion Engineering/ SAF, Westinghouse	1-stand, 4-hi
	80 Temper Mill	1965/1999	Dominion Engineering/ SAF, GE	1-stand, 4-hi
<b>ArcelorMittal North America</b> ArcelorMittal Dofasco G.P. Hamilton, Ont.	No. 1 CPCM	1992	Wean (pickle line), Hitachi (cold mill)/ Toshiba	5-stand, 4-hi tandem
	No. 2 - CPCM 72 Tandem Cold Mill	1999/2004 (elec. revamp)	cM-H	5-stand, 4-hi
ArcelorMittal Long Products Canada G.P. Contrecoeur, Que.	#1	1966	Waterbury Farrel	1-stand reversing
	#2	1992	DMS-France	1-stand reversing
<b>Stelco Holdings, a wholly owned subsidiary of Cleveland-Cliffs Inc.</b> Hamilton, Ont.	No. 3 Temper Mill	1965	Blaw-Knox/GE	1-stand, 4-hi
	Cold Mill	1963/1985, 1987, 2001	Blaw-Knox/GE, Alstom	4-stand, 4-hi tandem
<b>Mexico</b>				
<b>Altos Hornos de México</b> Monclova, Coah.	60 Cold Reversing Mill 	1960/1998	United/INSISA	1-stand, 4-hi
	Tandem Cold Mill 	1976	Hitachi	4-stand, 4-hi
	Tandem Cold Mill 	1965/1985	Mesta	5-stand, 4-hi
	No. 1 Temper Mill 	1967	Bliss	2-stand, 4-hi
	No. Temper Mill 	1977	Bliss	1-stand, 4-hi
<b>Ternium</b> Churubusco Plant Monterrey, N.L.	21.5 and 56 x 56 Tandem Cold Mill	1968/1995	Blaw-Knox/ Westinghouse; 1995 Bliss/Cegelec	4-stand, 4-hi
	Cold Mill No. 2	1984/1992	Bliss/GE	1-stand
	Cold Mill No. 3	1977/1994	Bliss/GE	1-stand
Guerrero Plant Nuevo León, N.L.	Cold Mill No. 4	1998 (AGC shape control)	Sendzimir/GE	1-stand
	Pesquería Plant Pesquería, N.L.	PLTCM	2013	Primetals Technologies
Universidad Plant San Nicolás de los Garza, N.L.	Reversing Mill 2	1991	Bliss	1-stand, 4-hi
	Reversing Mill 3	1997	Kavernier	1-stand, 4-hi

 idle AGC - automatic gauge control CDCM - continuous descale cold mill CPCM - coupled pickle line and tandem cold mill  
CM - cold mill CRM - cold reversing mill HB - hot band JV - joint venture PLTCM - pickle line tandem cold mill

Sponsored by



Nominal width (max width/ avg. width, mm)	Finished sizes (thickness range/ gauge x width, mm)	Coil size (max coil weight, kg)	Capacity (‘000 metric tons/year)
1,575/1,200	0.30–3.08 x 1,575	28,500	1,000
1,505/1,100	0.18–2.55 x 1,092–1,505	22,000	550
1,880/1,200	0.38–3.40 x 1,880	33,566	363
1,880/1,200	0.38–4.32 x 1,880	33,566	635
1,626/1,181	0.18–2.16 x 660–1,626	32,660 (entry), 45,360 (exit)	1,179
1,626/1,143	0.32–3.43 x 685–1,626	27,216	1,300
1,308/1,092	0.38–3.23 x 610–1,308	18,114	227
1,308/1,092	0.38–3.23 x 610–1,308	18,114	227
1,854	0.51–3.45 x 610–1,854	32,659	544
1,854	0.33–4.17 x 610–1,854	45,359	1,451
1,525/1,142	0.30–1.12 x 1,118–1,524	20,000	90
1,320/1,083	0.46–2.67 x 1,320	20,000	840
965/892	0.18–0.91 x 965	20,000	375
965/887	0.15–0.36 x 965	13,500	200
1,320/1,071	0.46–2.64 x 1,320	20,000	625
—	0.23–3.42 x 732–1,290	21,500	1,000
1,016/864	0.20–1.52 x 610–1,000	18,144	120
1,257/1,041	0.23–2.16 x 838–1,257	19,958	209
1,320/1,118	0.42–3.05 x 610–1,320	19,958	218
1,850/1,220	0.18–3.50 x 900–1,850	35,000	1,550
1,270/1,006	0.30–1.90/3.05 x 610–1,270	20,000	300
1,270/963	0.22–1.90/3.05 x 610–1,270	20,000	200

RCM - reversing cold mill TCM - tandem cold mill Z-mill - Sendzimir mill

Interested in becoming a member of the AIST Cold Sheet Rolling Technology Committee? Contact Ken Landau at [klandau@aist.org](mailto:klandau@aist.org).

## 2025 AIST Cold Mill Roundup

Company and location	Identification (unit name/type)	Start-up/ modernization	Mill builder (mechanical/electrical)	Configuration (No./type of standards)
<b>United States</b>				
<b>ArcelorMittal North America</b> AM/NS Calvert LLC Calvert, Ala.	PLTCM	2010	SMS Demag/ ConverTeam	5-stand, 4-hi tandem
<b>California Steel Industries, a Nucor-JFE Co.</b> Fontana, Calif.	TCM	1953/1997	United, Bliss-Salem/GE	5-stand, 4-hi
	Temper Mill	1970	Bliss/GE	2-stand, 4-hi tandem
<b>Cleveland-Cliffs Inc.</b> Burns Harbor, Ind.	80-in. TCM	1965/2000	Blaw-Knox/GE	5-stand, 4-hi
Butler Works Butler, Pa.	#2 Tandem Cold Mill	1958/1995	United/Mesta	4-stand, 4-hi
	#3 Tandem Cold Mill	1990/2017	Italimpianti of America	3-stand, 4-hi
Cleveland Works Cleveland, Ohio	84-in. TCM	1969/2012	Wean United/ Westinghouse	5-stand, 4-hi
Coshocton Works Coshocton, Pa.	36-in. Z-Mill (ZR-22BB-40)	1965/1996	Sendzimir/GE	1-stand, 20-hi
	52-in. Z-Mill (Zr-22-52)	1985	Waterbury Farrel/GE	1-stand, 20-hi
	#1 - Z-High Cold Reduction Mill	1959/1992	Bliss/Reliance	1-stand, 18-hi
	#2 - Z-High Cold Reduction Mill	1961/1998	Bliss/Westinghouse	1-stand, 18-hi
	30-in. Temper Mill	1959	Bliss/Elliott	1-stand, 2-hi
	48-in. Temper Mill	1978/2017	Nash/Westinghouse	1-stand, 2-hi
Dearborn Works Dearborn, Mich.	PLTCM	2011	Mitsubishi/Hitachi	5-stand, 6-hi tandem
Indiana Harbor East Chicago, Ind.	29-in. Temper Mill	1971	United/GE	1-stand, 4-hi
	80-in. TCM	1970/2018	United/GE	5-stand, 4-high tandem
Middletown Works Middletown, Ohio	No. 3 86-in. Cold Strip Mill	1968/2019	United/Westinghouse, Siemens	5-stand, tandem
	No. 5 80-in. Temper Mill	1950	Mesta/GE	1-stand, 4-hi
	No. 6 80-in. Temper Mill	1968	Bliss/GE	1-stand, 4-hi
New Carlisle New Carlisle, Ind.	66-in. CDCM	1990/2016	Mitsubishi/GE, Hitachi	4-stand, 6-hi tandem
Rockport Works Rockport, Ind.	Continuous Cold Mill	1998	SMS/Siemens	5-stand tandem (3) 4-hi + (2) 6-hi
	No. 1 Temper Mill	1999	SMS/Siemens	1-stand, 4-hi tandem
Zanesville Works Zanesville, Ohio	#1 Z-Mill	—	—	1-stand, 20-hi
<b>NLMK</b> NLMK Pennsylvania Farrell, Pa.	No. 4 TCM	1999	dms Bliss/Alstom	5-stand, 4-hi tandem
NLMK Pennsylvania Farrell, Pa.	No. 26 Z-Mill	~1960s	Waterbury Farrel	20-roll cluster/ 1-stand, 20-hi
	No. 27 Temper Mill	~1960s	Bliss	1-stand, 4-hi
	No. 28 Temper Mill	~1960s	Bliss	1-stand, 4-hi
	No. 35 Temper Mill	2007	Bliss/Siemens	1-stand, 4-hi

ⓘ idle AGC · automatic gauge control CDCM · continuous descale cold mill CPCM · coupled pickle line and tandem cold mill  
 CM · cold mill CRM · cold reversing mill HB · hot band JV · joint venture PLTCM · pickle line tandem cold mill

Sponsored by






Nominal width (max width/ avg. width, mm)	Finished sizes (thickness range/ gauge x width, mm)	Coil size (max coil weight, kg)	Capacity ( <sup>'000</sup> metric tons/year)
1,870/1,448	0.30–3.00 x 800–1,870	36,015	2,500
1,524/1,200	0.20–3.50 x 610–1,524	31,751	907
1,524/1,200	0.23–3.43 x 610–1,524	27,216	327
1,880/1,384	0.36–3.18 x 610–1,880	40,823	1,770
—	0.33–6.35 x 610–1,270	18,144	299
—	0.15–2.54 x 610–1,283	22,680	544
1,930/1,372	0.48–3.18 x 890–1,930	52,165 (entry), 38,555 (exit)	1,663
—	0.25–4.45 x 660–980	14,107	55
—	0.38–5.59 x 838–1,295	18,144	79
—	0.46–4.57 x 508–959	14,152	52
—	0.20–3.18 x 457–711	9,979	27
—	0.25–1.90 x 305–749	9,979	15
—	0.25–3.81 x 533–1,283	18,144	54
1,892/1,270	0.37–2.67 x 737–1,829	67,585 (entry), 32,668 (exit)	1,905
1,857/1,334	0.54–3.18 x 762–1,857	—	—
1,857/1,295	0.40–2.30 x 710–1,857	45,000	1,200
2,032/1,397	0.38–3.30 x 610–1,930	49,895 (entry), 39,916 (exit)	2,722
1,854/1,397	0.35–3.20 x 610–1,930	24,948	726
1,930/1,397	0.40–2.92 x 610–1,930	39,916	1,542
1,676/1,270	0.40–2.40 x 850–1,680	44,905	1,500
—	0.30–4.04 x 508–2,032	54,431	2,087
—	0.30–4.04 x 508–2,057	54,431	1,542
—	0.38–3.81 x 559–1,118	17,690	133
1,270/1,090	0.25–3.10 x 1,270	87 kg/mm	910
1,270/1,090	0.38–3.20 x 1,270	87 kg/mm	90
1,270/1,090	0.38–3.20 x 1,270	87 kg/mm	90
1,270/1,090	0.25–3.10 x 1,270	87 kg/mm	410
1,270/1,090	0.25–3.10 x 1,270	87 kg/mm	410

RCM - reversing cold mill TCM - tandem cold mill Z-mill - Sendzimir mill

Interested in becoming a member of the AIST Cold Sheet Rolling Technology Committee? Contact Ken Landau at [klandau@aist.org](mailto:klandau@aist.org).

## 2025 AIST Cold Mill Roundup

Company and location	Identification (unit name/type)	Start-up/ modernization	Mill builder (mechanical/electrical)	Configuration (No./type of standards)
Nucor Corp. Nucor Steel–Arkansas Armored, Ark.	CM1 Reversing/ Temper Mill	1998	Danieli/GE	1-stand, 4-hi
	CM2 Reversing/ Temper Mill	2019	Andritz	1-stand, 4-hi
	CM2 S6H Reversing Mill	2019	Andritz	1-stand, 4-hi/6-hi
Nucor Steel–Berkeley Huger, S.C.	Reversing Mill 1	1996/2019	SMS	1-stand, 4-hi
	Reversing Mill 2	2001/2013	Voest Alpine	1-stand, 4-hi
	Temper Mill	1996/2013	SMS	1-stand
Nucor Steel–Decatur LLC Decatur, Ala.	Tandem Mill	1998/2011	Bliss/TMEIC	4-stand, 4-hi
	Temper Mill	1998	Bliss/TMEIC	1-stand
Nucor Steel–Indiana Crawfordsville, Ind.	Reversing Mill	1988/2018	SMS/TMEIC	1-stand, 4-hi
	Reversing/Temper Mill	1988/1996	SMS/TMEIC	1-stand, 4-hi
Steel Dynamics Inc. Flat Roll Group Butler Division Butler, Ind.	Reversing Mill	1997/2011	SMS/TMEIC	2-stand, 4-hi reversing
Flat Roll Group Columbus Division Columbus, Miss.	PLTCM	2007	SMS/TMEIC	5-stand, 4-hi tandem
Flat Roll Group Heartland Division Terre Haute, Ind.	Cold Mill	1999/2010	VAI/Siemens, TMEIC	2-stand, 4-hi reversing
Flat Roll Group Southwest- Sinton Division Sinton, Texas	PLTCM	2022	SMS/TMEIC	5-stand, 6-hi tandem
Steel Technologies LLC Ottawa, Ohio	51-in. Z Mill	1996	Bliss	1-stand, Z-hi reversing
	49.5-in. Temper Mill	1996	Bliss	1-stand, 2-hi reversing
United States Steel Corporation Big River Steel Works Osceola, Ark.	PLTCM	2017	SMS	5-stand, 4-hi tandem
	SPM1	2017	SMS	1-stand, 4-hi
Gary Works Gary, Ind.	80 in.	1966/1998	Mesta/GE, GEC	5-stand, 4-hi
	52 in.	1967/1988	United/Westinghouse	6-stand, 4-hi
Granite City Works  Granite City, Ill.	56 in.	1948/1995	Mesta/Allis Chalmers, GE	4-stand, 4-hi
Great Lakes Works  Ecorse, Mich.	80 in.	1965/2000	Mesta/GE	5-stand, 4-hi
Midwest Plant Portage, Ind.	52 in.	1961/1990	Mesta/Westinghouse, GEC	5-stand, 4-hi
	80 in.	1970/1991	United/Westinghouse	5-stand, 4-hi
Mon Valley Works Irvin Plant West Mifflin, Pa.	84 in.	1970/2000	Bliss/Alstom	5-stand, 4-hi
Worthington Steel Cleveland, Ohio	56-in. Reversing Mill	1997	I <sup>2</sup> S	1 stand, 4-hi reversing
	42-in. Reversing Mill	1967	Waterbury Farrel	1-stand, 4-hi reversing

 idle AGC - automatic gauge control CDCM - continuous descale cold mill CPCM - coupled pickle line and tandem cold mill  
 CM - cold mill CRM - cold reversing mill HB - hot band JV - joint venture PLTCM - pickle line tandem cold mill

Sponsored by



Nominal width (max width/ avg. width, mm)	Finished sizes (thickness range/ gauge x width, mm)	Coil size (max coil weight, kg)	Capacity (‘000 metric tons/year)
1,590/1,295	0.30–2.79 x 915–1,590	29,030	205 temper; 650 reversing
1,650/1,220	0.25 x 915–1,650	29,485	327 temper; 200 reversing
1,650/1,220	0.25 x 915–1,650	29,485	345
1,650/1,250	0.28 x 915–1,650	36,290	454
1,830/1,300	0.33 x 915–1,830	36,290	680
1,830/1,300	0.28 x 915–1,830	36,290	680
1,650/1,245	0.30–4.06 x 915–1,650	36,287	1,179
1,651/1,245	0.30 x 915–1,650	36,287	1,089
1,525/1,200	0.36–2.54 x 865–1,385	36,290	635
1,525/1,200	0.36–1.93 x 865–1,385	36,290	454 temper; 109 reversing
1,575/1,234	0.23–2.54 x 915–1,575	29,030	907
1,829/1,245	0.27–1.40 x 915–1,880	29,484	1,200
1,524/1,200	0.25–1.27 x 1,040–1,525	38,555	726
1,930/1,050	0.20–2.54 x 965–1,980	47,800	850
1,295/1,219	0.35–5.64 x 813–1,295	22,680	131
1,257/1,219	0.35–3.40 x 737–1,257	22,680	100
1,850/1,300	0.25–3.00 x 915–1,850	36,290	1,451
1,800/1,245	0.32–1.50 x 915–1,800	36,290	408
1,880/1,364	0.36–3.40 x 710–1,880	34,473	2,631
–	0.18–0.69 x 1,168	33,112	748
1,270/1,050	0.48–2.08 x 610–1,270	21,772	708
–	0.33–3.05 x 610–1,880	31,751	2,132
1,930/1,041	0.30–4.19 x 1,930	38,555	1,996
–	0.30–3.05 x 610–1,830	40,823	1,252
–	0.18–2.03 x 510–1,219	38,102	590
1,321/1,143	0.25–6.35 x 1,321	23,586	335
914/760	0.25–7.62 x 914	16,325	195

RCM - reversing cold mill TCM - tandem cold mill Z-mill - Sendzimir mill

Interested in becoming a member of the AIST Cold Sheet Rolling Technology Committee? Contact Ken Landau at [klandau@aist.org](mailto:klandau@aist.org)