

Zinc/Zinc-Alloy/Aluminum Continuous Sheet Coating Lines - North America

Colour Code → Operating HD Lines

EG Lines

Under Construction

Idle Lines

METRIC (SI) VERSION

(Master Sheet - CoatingLinesInLb sheet calculates sizes and tons from this sheet)

Producer	Location	Line ID	Date Built	Latest Rebuild	Thickness (mm)		Width (mm)		Furnace Type(*)	Annual Hot-Dip Capacity - 1000's of metric tonnes (k MT)							Total Company H-D MT	Annual EG Capacity - k MT				Roll Coatings	Est. Zn Usage: MT/yr.	Comments
					Min	Max	Min	Max		GI only	GA/GI	AZ	GF, ZM	AI, Al-Si	Combi	Total		Zn	Zn-Ni	Zn-Fe	Total			
AK Steel Corp	Ashland, KY	No.3	1967	1982	0.43	2.0	610	1524	V-DFRT	-	0	-	-	-	-	0	2,295	-	-	-	-	0	IDLE 11/11/2019: Induc. GA; N2 wipe; 336k MT/yr cap.; 14.3k T Zn use	
	Dearborn, MI	No. 1	2011	2016	0.57	2.7	914	1829	V-RT	-	454	-	-	-	-	454	Pre-phos	11,000	Exposed GI, GA; NexMet™ AHSS; Severstal NA up to 2014					
	Middletown, OH	No.2 EG	1991	1995	0.48	1.9	1900	NA	-	-	-	-	-	-	-	-	454	10,000	Gravitel process, 21 plating cells					
		No. 3	1961	2002	0.53	3.5	810	1880	H-RRFT	508	-	-	-	-	-	-	508	22,000	Nitrogen wiping; not automotive exposed					
	Rockport, IN	No. 4	1971	-	0.38	3.5	610	1575	V-DFRT	-	-	-	-	426	-	-	426	0	2	2	0	2 coreless pots; Aluminized type I, II on C-steel & 40x stainless		
CGL		1998	2003	0.46	2.0	1040	2032	V-RT	-	907	-	-	-	-	-	907	Prephos	29,000	Max speed 750 fpm, coil wt.1 70,000 lb.; Widest N.A. Clg line					
AcerorMittal	Burns Harbor, IN	HDCL	1992	-	0.51	2.0	915	1829	V-RT	-	550	-	-	-	-	550	Prephos, CT	18,000	Induction GA; roll coater; entry & exit auto inspection					
	Cleveland, OH	HDGL	2006	2013	0.55	2.5	990	1830	V-DFRT	-	650	-	-	-	-	650	CT	25,000	Converted 1000 fpm LTV CAL to auto CGL; added GA '07; electromag. Stabilizer					
	Columbus, OH	HDGL	2000	2005	0.50	1.7	800	1829	V-RT	-	400	-	-	-	-	400	Prephos	19,950	L-S II EG line converted to CGL; 100% GA, 2 main pots + pre-melt; e-mag stabilizer					
	AcerorMittal Dofasco G. P., Hamilton, ON	No.3	1967	2005	0.20	1.1	610	1321	H-DFRT	-	220	-	-	-	-	220	Cr6 CT	12,000	Gas fired GA furnace installed 1989					
		No.4	1981	2016	0.25	2.31	610	1537	H-DFRT	100	-	136	-	-	-	236	Acrylic, Cr6 CT	6,300	Dual pots, cleaner for FH AZ, CMI Blowstab APC; new cleaner, furnace upgrades; new dco. Pot hardware: dual roll coater					
		No.5	1999	2003	0.51	2.1	863	1829	V-RT	-	490	-	-	-	-	490	7,300	Originally "DSG", a Dofasco/Sollac 80/20 JV; exposed GI & GA; AHSS						
		No.6	2014	-	1.00	4.3	610	1651	H-DFRT	-	650	-	-	-	-	650	7,900	Began operating 2015 (GI, GA, HR HDG, AHSS)						
	AcerorMittal Windsor Windsor, ON	No.1	1993	2017	0.40	2.1	610	1829	V-DFRT	-	440	-	-	-	-	440	Prephos + Cr3, Cr6	6,000	100% AM Dofasco 2013, formerly JV with JFE Steel; formerly DNN Galvanizing renamed DJ Galvanizing Corp. in '04; pre-melt '97					
	Indiana Harbor-West, East Chicago, IN	No.2	1963	2016	0.38	4.8	610	1830	H-DFRT	-	557	-	-	-	-	557	28,800	Gas fired GA; horizontal fce.; 577k MT cap.; 28.8 kt Zn						
Indiana Harbor-East, East Chicago, IN	5 CGL	1968	2004	0.51	2.5	610	1830	H-RT	-	0	-	-	-	-	0	0	0	IDLE - Gas fired GA; hot bridle & new RT furnace 1997, ceramic tubes; formerly ISPAT-Inland; 376 kMT cap.						
AM Coteau-du-Lac Coteau-du-Lac, PQ	No. 1	1991	1995	0.23	3.4	610	1372	H-DFRT	-	230	-	-	-	-	230	7,000	Formerly Sorevco; 1kg ctg wt golf ball finish; induction GA, Cr ² & Cr ³ CT							
AMNS Calvert (JV of AcerorMittal Steel and Nippon Steel Corp.)	Calvert (Mobile), AL	HDGL1	2011	2015	0.50	2.3	920	1870	V-RT	-	500	-	-	-	-	500	Pre-phos	14,600	GI, (Zn-Al-Mg?) GA; DEMCO e-mag stabilizer; 2 main pots; side trim; Drever furnace oxidation control chamber					
		HDGL3	2012	2017	0.50	2.5	800	1670	V-RT	-	500	-	-	-	-	500	Pre-phos, CT	14,600	GI, GA (likely begins production 2014, after sale- included in totals); 2 main pots					
		HDGL4	2011	2014	0.30	2.5	800	1670	L-DFRT	220	-	stop 2013	-	300	-	520	CT, Acrylic	7,700	GI, 55Al-Zn until 2013, Al-Si, CMI-EFCO; side trim; 2 main pots, 1 pre-melt; space for future 3rd main+ pre-melt. Alum. announced Apr '18					
Big River Steel (JV, BRS & U. S. Steel)	Osceola, AR	HDGL	2016	-	0.36	3.0	900	1850	V-DF, H-RT	475	-	-	-	-	475	238	-	-	-	-	12,000	Construction line, SMS-Seimag, Drever, Fontaine; 49.9% U. S. Steel as of 10-31-19; can operate as a combination CAGL		
California Steel Industries (CSI)	Fontana, CA	No.1	1966	1999	0.38	4.3	610	1524	H-DFRT	-	430	-	-	-	-	430	730	-	-	-	-	12,000	Subsidiary of JFE Steel and CVRD.	
		No.2	1998	-	0.25	1.5	610	1321	V-DFRT	-	300	-	-	-	-	300	-	-	-	-	-	11,000		
Galvasid (Grupo Ind. L.M.)	Apodaca, NL, Mexico	No.1	2005	-	0.25	1.90	610	1524	V-DFRT	109	-	109	-	-	-	218	218	-	-	-	-	6,200		
Gregory Industries	Canton, OH	No.1	1980	2018	0.76	4.57	51	495	L-IND	-	132	-	-	-	-	132	132	-	-	-	-	6,185	Cold line with preheat induction furnace; thick ctgs, no cut edge	
J/N Kote (JV of AcerorMittal and Nippon Steel Corp.)	New Carlisle, IN	KOGL	1991	2004	0.38	2.3	610	1829	V-RT	-	454	-	-	-	-	454	454	-	-	-	Prephos	7,600	In-line side trimmer; exposed GA; all GA	
		EG	1991	-	0.43	2.0	610	1829	NA	-	-	-	-	-	-	-	363	-	-	363	-	6,800	24 Gravitel plating cells; Ni flash in 25th	
Materials Science Corp. (MSC)	Canfield Metal Coating (CMC), Canfield, OH	EG	1957	2003	0.20	2.0	610	1219	NA	-	-	-	-	-	-	-	60	-	-	60	Organic & inorganic	1,200	Orig. Wheeling-Pittsburgh until 2001; acquired by New Star Metals Jul-2013	
	Electric Coating Technologies (ECT), East Chicago, IN	EG	1996	-	0.25	2.20	610	1829	NA	-	-	-	-	-	-	-	181	-	-	181	-	6,000	Able to coat UHSS up to 1585 MPa (230 ksi) yield strength; acquired by Insight Equity 2012; started as Metro Metals, 1996	
	Rexdale (Toronto), ON	No.1 EG	1968	-	0.20	2.03	356	1524	NA	-	-	-	-	-	-	-	41	-	-	41	-	800	Can coat UHSS YS up to 1517 MPa (220 ksi)	
	Walbridge, OH	No.1 EG	1986	-	0.46	2.5	610	1829	NA	-	-	-	-	-	-	-	263	100	-	363	Organic	7,300	Formerly Materials Sciences; was JV with AcerorMittal, Gravitel plating process, 20 cells; can coat 1000 MPa AHSS	
National Galvanizing L.P.	Monroe, MI	No.1	1984	2017	1.52	6.35	610	1219	H-DFRT	-	204	-	-	-	-	204	204	-	-	-	-	9,600	Push/Pull line - POG only, induction GA	
NMLK Pennsylvania	Sharon, PA	No.2	1998	-	0.30	1.8	610	1524	L-DFRT	250	-	-	-	-	-	250	704	-	-	-	-	-	10,300	NMLK since 2011; formerly Sharon Coating, a 2008 JV of Duferco-Novolipetsk (NMLK) and Severstal; in past was Winner Steel
		No.3	2004	-	0.51	2.5	610	1829	L-DFRT	-	454	-	-	-	-	454	-	-	-	-	-	20,000		
		No.1	1999	-	0.30	2.7	762	1575	H-DFRT	544	-	-	-	-	-	544	-	-	-	-	-	20,000		
Nucor Steel	Nucor Steel Arkansas, Blytheville (Hickman), AR	No. 2 CAGL	1H 2021	-	0.23	2.70	890	1900	V-DFRT	435	-	-	-	-	-	435	435	-	-	-	-	-	13,000	Construction, HVAC
		No. 1	1999	-	0.30	2.7	762	1575	H-DFRT	544	-	-	-	-	-	544	-	-	-	-	-	20,000	Combination CAGL; Andritz PR 11/3/2018; GEN3 steels	
	Nucor Steel Berkeley, Huger, SC	No.1	1998	2007	0.25	2.7	762	1676	V-DFRT	-	635	-	-	-	-	635	2,930	-	-	-	Acrylic	14,300	Robot skimmer, roll coater	
	Nucor Steel Decatur LLC, Trinity, AL	No.1	2009	-	0.51	6.3	762	1829	V-RT	-	544	-	-	-	-	544	-	-	-	-	-	18,000	*2/17/20 Charleston Post-Courier: \$260M + \$30M construction of new C(A)GL, Huger, SC or eval. 3 locations	
	Nucor Steel Gallatin, Ghent, KY	No.1 PAGL	2019	-	TBA	6.35	TBA	1854	H-IND-HTC	-	454	-	-	-	-	454	-	-	-	-	-	13,500	Combined hot band pickling & vertical galvanizing; started coating 9/27/2019	
Nucor Steel Indiana, Crawfordsville, IN	No.1	1993	-	0.38	3.3	762	1346	H-DFRT	318	-	-	-	-	-	318	-	-	-	-	-	10,000	Construction & appliance; coats Castrip Si-killed steel		

Zinc/Zinc-Alloy/Aluminum Continuous Sheet Coating Lines - North America

Colour Code → Operating HD Lines

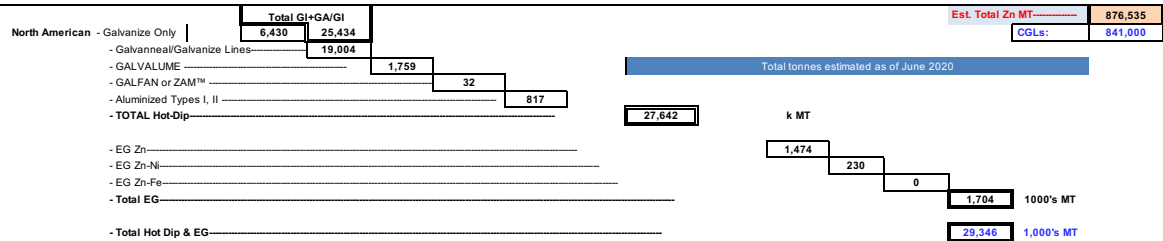
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Idle Lines

METRIC (SI) VERSION
(Master Sheet - CoatingLinesInLb sheet calculates sizes and tons from this sheet)

Producer	Location	Line ID	Date Built	Latest Rebuild	Thickness (mm)		Width (mm)		Furnace Type(*)	Annual Hot-Dip Capacity - 1000's of metric tonnes (k MT)						Total Company H-D MT	Annual EG Capacity - k MT				Roll Coatings	Est. Zn Usage: MT/yr	Comments	
					Min	Max	Min	Max		GI only	GA/GI	AZ	GF_ZM	Al, Al-Si	Combi		Total	Zn	Zn-Ni	Zn-Fe				Total
PRO-TEC Coating Co., Leipsic, OH		CGL 1	1993	2007	0.58	2.6	914	1880	V-RT	-	635	-	-	-	-	635	Coatings, + 49.9% of BRS tonnes	-	-	-	-	Prephos, CT, DFL	9,500	US Steel/Kobe Steel JV; 2 roll coaters; UHSS & exposed GA; robot skim; LIBS pot chem. Sensor
		CGL 2	1998	2006	0.38	1.7	610	1702	V-RT	-	499	-	-	-	-	499		-	-	-	-	Prephos	9,500	US Steel/Kobe JV; roll coater, exposed GA & AHSS; robot skim
		CGL 3	2020	-	TBA	TBA	TBA	TBA	TBA	-	454	-	-	-	-	454		-	-	-	-	TBA	13,500	USS/Kobe JV; to produce UHS HDG - start 2020 (AMM - Sep '17)
UPI (USS-POSCO Industries), Pittsburg, CA		No. 200 Line	1963	1997	0.38	3.19	610	1410	V-RT	-	363	-	-	-	363	-	-	-	-	n/a	11,200	Induction GA, RoHS CT; 50-50 JV since 1984; was 50-50 JV of U. S. Steel and POSCO; 100% U. S. Steel Feb. 29, 2020		
Grupo Villacero	Cintacero Guadalupe, NL, Mexico	EG	1990	-	0.30	3.17	3	610	NA	-	-	-	-	-	-	48	-	-	-	48		100	Acquired in 1998 by Villacero from Fisacero	
	Zincacero Apodaca, NL, Mexico	HDGL	1994	-	0.28	1.56	914	1222	H-RT	91	-	-	-	-	91	91	-	-	-	-		3,000		
Wheeling Nisshin	Follansbee, WV	No. 1 AGL	1988	-	0.36	2.7	610	1549	H-DFRT	-	272	-	12	91	375	674	-	-	-	-		5,400	ZAM™ added in 2013-2014; Makes Aluminized stainless; Gas fired GA furnace; 100% Nisshin Steel Co., Ltd. since 2008	
		No. 2 CGL	1993	2000	0.20	1.2	610	1270	H-DFRT	218	-	81	-	-	299		-	-	-	-	Acrylic	8,600	Construction; Carousel reels; roll coater	
Worthington Industries	Delta, OH	No. 1	1997	2008	0.64	6.35	813	1575	L-DFRT	-	363	-	-	-	363	907	-	-	-	-		13,600	CQ, culvert, guardrail markets (mostly HR substrate)	
	Spartan Steel Coating, Monroe, MI	No. 1	1998	2019	0.43	1.9	711	1575	V-DFRT	-	544	-	-	-	544		-	-	-	-	Prephos, CT, acrylic	8,000	Worthington 52%/AK Steel 48% JV; DFF lining change to fiber; RJC upgrade	



Type	Total	Operating	Being Built	Combi.	Idle
Hot Dip Lines - TOTAL (all coatings)	82	76	4	4	2
Hot Dip Galvanize Lines (GI but no GA)	32	30	2		0
HDG Lines with GI & GA capability	47	44	1		2
Lines with GALVALUME capability	14	13	1		0
Lines with Galfan capability	2	2	0		0
Lines with ZAM™ capability	1	1	0		0
Lines with Aluminizing capability	3	3	0		0
EG Lines	12	10	0		2

EGLs + CGLs 94 86 4 4 4

- NOTES:
- Production tonnes based on most recent data
 - GI = Galvanize - GF = Galfan
 - GA = Galvanneal - AL = Aluminized I, II
 - AZ = 55Al-Zn (GALVALUME, ZINCALUME, etc.)
 - ZAM™ Zn-Al-Mg alloy coating
 - Zinc usage from 2004 ILZSG World Directory: CG Lines
 - TBA = To Be Announced
 - (*) Furnace types
 - V = Vertical
 - H = Horizontal
 - L = Vert & Horiz (may or may not be "L" shaped)
 - NA = not applicable / not available
 - *Suffix: DF = Direct Fired; RT = Radiant Tube; IND = Induction; HTC = Heat to Coat
 - OP Operating Hot-Dip Line
 - OPE Operating EGL
 - BB Being Built
 - ID Idle Hot-Dip Line
 - IDE Idle EGL

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Ref. F. E Goodwin, E. A. Silva Galvatech 2020 and AIST GTC Feb. 2020