



COURSE OVERVIEW ME0332
Roll Mills Reheating Furnace Walking Heart
Operation & Optimization

Course Title

Roll Mills Reheating Furnace Walking Heart
Operation & Optimization

Course Reference

ME0332

Course Duration/Credits

Five days/3.0 CEUs/30 PDHs

Course Date/Venue



Session(s)	Course Date	Venue
2	May 25-29, 2025	TBA Meeting Room, Taksim Square Hotel, Istanbul, Turkey
3	August 10-14, 2025	Boardroom 1, Elite Byblos Hotel Al Barsha, Sheikh Zayed Road, Dubai, UAE
4	December 14-18, 2025	TBA Meeting Room, Taksim Square Hotel, Istanbul, Turkey

Course Description



This practical and highly-interactive course includes real-life case studies and exercises where participants will be engaged in a series of interactive small groups and class workshops.

This course is designed to provide delegates with a detailed and up-to-date overview of roll mills reheating furnace (walking hearth) operation and optimization. It covers the mill layout and reheating furnace (walking hearth); the billets/blooms movement through the reheating furnace, cycle time of walking hearth furnaces and positions of billets/blooms; and the heat balance inside furnace, heat transmission, temperature differences between billets/blooms; and estimation of billet/bloom temperature.

Further, the course will also discuss the thermal radiation between billet/bloom and furnace walls; the heat transfer between billets/blooms, the furnace atmosphere and the hearths; the heat transfer coefficient, thermal conduction, thermal properties of materials and specific heat; the emissivity/absorption rate, thermal conductivity and mesh construction; the heat balance modeling in each component, factors from furnace walls, hearths and ceiling to a mesh; the heat transmission between billets/blooms and the hearths; and the local temperature of the hearths and interaction between billets/blooms.





During this interactive course, participants will learn the reheating during steel rolling; the methods of reducing the fuel cost; the primary causes of non-optimal furnace operation and prior work on reheating furnace control strategies; the effect of thermal conductivity on center temperature and parameters selection for optimization; estimating extraction temperature of billets/blooms; the selection of model and parameters for reheating furnace control; the optimization of furnace operation; the initial solution, unit increment of furnace temperature and schedule matrix and upper limit of temperature change; the effective zone and time period targeting for estimating billet temperature; the classified searching for efficient temperature changes; and the final treatment for the optimal control solution.

Course Objectives

Upon the successful completion of this course, each participant will be able to:-

- Apply and gain a comprehensive knowledge on roll mills reheating furnace (walking hearth) operation and optimization
- Discuss roll mill reheating furnace, mill layout and reheating furnace (walking hearth)
- Identify billets/blooms movement through the reheating furnace, cycle time of walking hearth furnaces and positions of billets/blooms
- Describe the heat balance inside the furnace, heat transmission, temperature differences between billets/blooms and estimation of billet/bloom temperature
- Differentiate thermal radiation between billet/bloom and furnace walls as well as heat transfer between billets/blooms, the furnace atmosphere and the hearths
- Explain heat transfer coefficient, thermal conduction, thermal properties of materials and specific heat
- Recognize emissivity/absorption rate, thermal conductivity and mesh construction
- Identify heat balance modeling in each component, view factors from furnace walls and hearths and ceiling to a mesh
- Distinguish heat transmission between billets/blooms and the hearths, recognize local temperature of the hearths and interaction between billets/blooms
- Apply reheating during steel rolling and proper methods to reduce the fuel cost
- Examine primary causes of non-optimal furnace operation and prior work on reheating furnace control strategies
- Recognize effect of thermal conductivity on center temperature and parameters selection for optimization
- Estimate extraction temperature of billets/blooms and select model and parameters for reheating furnace control
- Optimize furnace operation, apply optimization method and determine the initial solution
- Identify the unit increment of furnace temperature including the schedule matrix and upper limit of temperature change

- Recognize the effective zone and time period targeting for estimating billet temperature
- Carryout classified searching for efficient temperature changes and final treatment for the optimal control solution

Exclusive Smart Training Kit - H-STK®



Participants of this course will receive the exclusive “Haward Smart Training Kit” (H-STK®). The H-STK® consists of a comprehensive set of technical content which includes **electronic version** of the course materials conveniently saved in a **Tablet PC**.

Who Should Attend

This course provides an overview of all significant aspects and considerations of roll mills reheating furnace (walking hearth) operation and optimization for furnace operators and supervisors.

Training Methodology

All our Courses are including **Hands-on Practical Sessions** using equipment, State-of-the-Art Simulators, Drawings, Case Studies, Videos and Exercises. The courses include the following training methodologies as a percentage of the total tuition hours:-

- 30% Lectures
- 20% Practical Workshops & Work Presentations
- 30% Hands-on Practical Exercises & Case Studies
- 20% Simulators (Hardware & Software) & Videos

In an unlikely event, the course instructor may modify the above training methodology before or during the course for technical reasons.

Course Fee

Dubai	US\$ 10,000 per Delegate + VAT . This rate includes H-STK® (Haward Smart Training Kit), buffet lunch, coffee/tea on arrival, morning & afternoon of each day.
Istanbul	US\$ 10,000 per Delegate + VAT . This rate includes Participants Pack (Folder, Manual, Hand-outs, etc.), buffet lunch, coffee/tea on arrival, morning & afternoon of each day.

Accommodation


Accommodation is not included in the course fees. However, any accommodation required can be arranged at the time of booking.

Course Certificate(s)

Internationally recognized certificates will be issued to all participants of the course who completed a minimum of 80% of the total tuition hours.

Certificate Accreditations

Certificates are accredited by the following international accreditation organizations:-

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British Accreditation Council (BAC)

Haward Technology is accredited by the **British Accreditation Council** for **Independent Further and Higher Education** as an **International Centre**. BAC is the British accrediting body responsible for setting standards within independent further and higher education sector in the UK and overseas. As a BAC-accredited international centre, Haward Technology meets all of the international higher education criteria and standards set by BAC.

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The International Accreditors for Continuing Education and Training (IACET - USA)

Haward Technology is an Authorized Training Provider by the International Accreditors for Continuing Education and Training (IACET), 2201 Cooperative Way, Suite 600, Herndon, VA 20171, USA. In obtaining this authority, Haward Technology has demonstrated that it complies with the **ANSI/IACET 2018-1 Standard** which is widely recognized as the standard of good practice internationally. As a result of our Authorized Provider membership status, Haward Technology is authorized to offer IACET CEUs for its programs that qualify under the **ANSI/IACET 2018-1 Standard**.

Haward Technology’s courses meet the professional certification and continuing education requirements for participants seeking **Continuing Education Units (CEUs)** in accordance with the rules & regulations of the International Accreditors for Continuing Education & Training (IACET). IACET is an international authority that evaluates programs according to strict, research-based criteria and guidelines. The CEU is an internationally accepted uniform unit of measurement in qualified courses of continuing education.

Haward Technology Middle East will award **3.0 CEUs** (Continuing Education Units) or **30 PDHs** (Professional Development Hours) for participants who completed the total tuition hours of this program. One CEU is equivalent to ten Professional Development Hours (PDHs) or ten contact hours of the participation in and completion of Haward Technology programs. A permanent record of a participant’s involvement and awarding of CEU will be maintained by Haward Technology. Haward Technology will provide a copy of the participant’s CEU and PDH Transcript of Records upon request.



Course Instructor(s)

This course will be conducted by the following instructor(s). However, we have the right to change the course instructor(s) prior to the course date and inform participants accordingly:



Mr. Karl Thanasis, PEng, MSc, MBA, BSc, is Senior Mechanical & Maintenance Engineer with over 45 years of extensive industrial experience. His wide expertise includes Roll Mill Reheating Furnace, Mesh Construction, Steel Rolling, Heat Transmission, Piping & Pipeline, Maintenance, Repair, Shutdown, Turnaround & Outages, Maintenance & Reliability Management, Mechanical Maintenance Planning, Scheduling & Work Control, Advanced Techniques in Maintenance Management, Predictive & Preventive Maintenance, Maintenance & Operation Cost Reduction Techniques, Reliability Centered Maintenance (RCM), Machinery Failure Analysis, Rotating Equipment Reliability Optimization & Continuous Improvement, Material Cataloguing, Mechanical & Rotating Equipment Troubleshooting & Maintenance, Root Cause Analysis & Reliability Improvement, Condition Monitoring, Root Cause Failure Analysis (RCFA), Steam Generation, Steam Turbines, Power Generator Plants, Gas Turbines, Combined Cycle Plants, Boilers, Process Fired Heaters, Air Preheaters, Induced Draft Fans, All Heaters Piping Work, Refractory Casting, Heater Fabrication, Thermal & Fired Heater Design, Heat Exchangers, Heat Transfer, Coolers, Power Plant Performance, Efficiency & Optimization, Storage Tank Design & Fabrication, Thermal Power Plant Management, Boiler & Steam System Management, Pump Operation & Maintenance, Chiller & Chiller Plant Design & Installation, Pressure Vessel, Safety Relief Valve Sizing & Selection, Valve Disassembling & Repair, Pressure Relief Devices (PSV), Hydraulic & Pneumatic Maintenance, Advanced Valve Technology, Pressure Vessel Design & Fabrication, Pumps, Turbo-Generator, Turbine Shaft Alignment, Lubrication and Mechanical Seals,. Further, he is also versed in Wastewater Treatment Technology, Networking System, Water Network Design, Industrial Water Treatment in Refineries & Petrochemical Plants, Piping System, Water Movement, Water Filtering, Mud Pumping, Sludge Treatment and Drying, Aerobic Process of Water Treatment that includes Aeration, Sedimentation and Chlorination Tanks. His strong background also includes Design and Sizing of all Waste Water Treatment Plant Associated Equipment such as Sludge Pumps, Filters, Metering Pumps, Aerators and Sludge Decanters.

Mr. Thanasis has acquired his thorough and practical experience as the **Project Manager, Plant Manager, Area Manager - Equipment Construction, Construction Superintendent, Project Engineer and Design Engineer.** His duties covered **Plant Preliminary Design, Plant Operation, Write-up of Capital Proposal, Investment Approval, Bid Evaluation, Technical Contract Write-up, Construction and Sub-contractor Follow up, Lab Analysis, Sludge Drying and Management of Sludge Odor and Removal.** He has worked in various companies worldwide in the **USA, Germany, England and Greece.**

Mr. Thanasis is a **Registered Professional Engineer** in the **USA and Greece** and has a **Master's and Bachelor's degree in Mechanical Engineering with Honours** from the **Purdue University and SIU in USA** respectively as well as an **MBA** from the **University of Phoenix in USA.** Further, he is a **Certified Internal Verifier/Trainer/Assessor** by the **Institute of Leadership & Management (ILM)** a **Certified Instructor/Trainer** and has delivered numerous trainings, courses, seminars, workshops and conferences worldwide.





Course Program

The following program is planned for this course. However, the course instructor(s) may modify this program before or during the course for technical reasons with no prior notice to participants. Nevertheless, the course objectives will always be met:

Day 1

0730 - 0800	Registration & Coffee
0800 - 0815	Welcome & Introduction
0815 - 0830	PRE-TEST
0830 - 0845	Introduction to Roll Mill Reheating Furnace
0845 - 0900	Mill Layout
0900 - 0915	Break
0915 - 1030	Reheating Furnace (Walking Hearth)
1030 - 1100	Billets/Blooms Movement through the Reheating Furnace
1100 - 1200	Cycle Time of Walking Hearth Furnaces
1200 - 1215	Break
1215 - 1230	Positions of Billets/Blooms
1230 - 1300	Heat Balance Inside the Furnace
1300 - 1420	Heat Transmission
1420 - 1430	Recap
1430	Lunch & End of Day One

Day 2

0730 - 0800	Temperature Differences Between Billets/Blooms
0800 - 0830	Estimation of Billet/Bloom Temperature
0830 - 0900	Thermal Radiation Between Billet/Bloom & Furnace Walls
0900 - 0915	Break
0915 - 1030	Heat Transfer Between Billets/Blooms, The Furnace Atmosphere & the Hearths
1030 - 1200	Heat Transfer Coefficient
1200 - 1215	Break
1215 - 1300	Thermal Conduction
1300 - 1330	Thermal Properties of Materials
1330 - 1420	Specific Heat
1420 - 1430	Recap
1430	Lunch & End of Day Two

Day 3

0730 - 0800	Emissivity/Absorption Rate
0800 - 0830	Thermal Conductivity
0830 - 0900	Mesh Construction
0900 - 0915	Break
0915 - 1030	Heat Balance Modeling in Each Component
1030 - 1200	View Factors from Furnace Walls, Hearths & Ceiling to a Mesh
1200 - 1215	Break
1215 - 1300	Heat Transmission Between Billets/Blooms & the Hearths
1300 - 1330	Local Temperature of the Hearths
1330 - 1420	Interaction Between Billets/Blooms
1420 - 1430	Recap
1430	Lunch & End of Day Three





Day 4

0730 – 0800	<i>Reheating During Steel Rolling</i>
0800 - 0830	<i>Methods of Reduce the Fuel Cost</i>
0830 - 0900	<i>Primary Causes of Non-optimal Furnace Operation</i>
0900 – 0915	<i>Break</i>
0915 – 1030	<i>Prior Work on Reheating Furnace Control Strategies</i>
1030 – 1200	<i>Effect of Thermal Conductivity on Center Temperature</i>
1200 – 1215	<i>Break</i>
1215 – 1300	<i>Parameters Selection for Optimization</i>
1300 - 1330	<i>Estimating Extraction Temperature of Billets/Blooms</i>
1330 - 1420	<i>Selection of Model & Parameters for Reheating Furnace Control</i>
1420 – 1430	<i>Recap</i>
1430	<i>Lunch & End of Day Four</i>

Day 5

0730 – 0815	<i>Optimization of Furnace Operation</i>
0815 – 0900	<i>Outline of the Optimization Method</i>
0900 – 0915	<i>Break</i>
0915 – 1030	<i>Determining the Initial Solution</i>
1030 – 1100	<i>Unit Increment of Furnace Temperature</i>
1100 – 1130	<i>Determination of the Schedule Matrix & the Upper Limit of Temperature Change</i>
1130 - 1200	<i>Effective Zone & Time Period Targeting for Estimating Billet Temperature</i>
1200 – 1215	<i>Break</i>
1215 – 1230	<i>Classified Searching for Efficient Temperature Changes</i>
1230 - 1345	<i>Final Treatment for the Optimal Control Solution</i>
1345 – 1400	<i>Course Conclusion</i>
1400 – 1415	<i>POST-TEST</i>
1415 – 1430	<i>Presentation of Course Certificates</i>
1430	<i>Lunch & End of Course</i>



Practical Sessions

This practical and highly-interactive course includes real-life case studies and exercises:-



Course Coordinator

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