Chapter NR 254

IRON AND STEEL MANUFACTURING

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NR 254.001 Purpose. The purpose of this chapter is to establish effluent limitations, performance standards, and pretreatment standards for discharges of process wastes from the iron and steel making point source category and its subcategories.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

technology currently available.

NR 254.0015 Applicability. This chapter applies to any iron and steel making facility that discharges or may discharge pollutants to waters of the state or into a publicly owned treatment works.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.002 General definitions. The following definitions are applicable to the terms used in this chapter. Definitions of other terms and abbreviations are set forth in ss. NR 205.03, 205.04, and 211.03.

(1) "Ammonia-N" means the value obtained by manual distillation at pH 9.5 followed by the Nesslerization method set forth in ch. NR 219, table B, for parameter 4.

(2) "Benzene" means the value obtained by the standard method 602 as set forth in 44 FR 69464 to 69570 (December 3, 1979).

(3) "Benzo(a)pyrene" means the value obtained by the standard method 610 as set forth in 44 FR 69464 to 69570 (December 3, 1979).

(4) "Chromium" means total chromium as determined by the method set forth in ch. NR 219, table B, for parameter 19.

(5) "Copper" means total copper as determined by the method set forth in ch. NR 219, table B, for parameter 22.

(6) "Cyanide" means total cyanide as determined by the method set forth in ch. NR 219, table B, for parameter 23.

(7) "Existing source" means any point source, except a new source as defined in sub. (11), from which pollutants may be discharged either into the waters of the state or into a publicly owned treatment works,

(8) "Hexavalent chromium" means the value obtained by the method set forth in ch. NR 219, table B, for parameter 18.

(9) "Lead" means total lead as determined by the method set forth in ch. NR 219, table B, for parameter 32.

(10) "Naphthalene" means the value obtained by standard method 610 as set forth in 44 FR 69464 to 69571 (December 3, 1979).

(11) "New source", as defined for new source performance standards and pretreatment standards for new sources, means any point source for which construction commenced after January 7, 1981 and from which pollutants are or may be discharged directly to the waters of the state or to a publicly owned treatment works.

(12) "Nickel" means total nickel as determined by the method set forth in ch. NR 219, table B, for parameter 37.

(13) "O&G" means the value for oil and grease obtained by the method set forth in ch. NR 219, table B, for parameter 41.

(14) "pH" means the value obtained by the method set forth in ch. NR 219, table B, for parameter 28.

(15) "Phenols (4AAP)" means the value obtained by the method set forth in ch. NR 219, table B, for parameter 48.

(16) "Tetrachloroethylene" means the value obtained by standard method 610 as set forth in 44 FR 69464 to 69571 (December 3, 1979).

NR 254.123	Effluent limitations representing the degree of effluent reduction
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-	nomically achievable.

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- NR 254.125 · NR 254.126 Pretreatment standards for existing sources.
- Pretreatment standards for new sources
- Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant NR 254.127 control technology.

(17) "TRC" means total residual chlorine, which is the value obtained by iodometric titration using an amperometric endpoint method, as set forth in ch. NR 219, table B, for parameter 17.

(18) "TSS" means the value obtained for total suspended solids by the method set forth in ch. NR 219, table B, for parameter 55.

(19) "Zinc" means total zinc as determined by the method set forth in ch. NR 219, table B, for parameter 75.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

254.003 Alternative effluent limitations. NR (1) Except as provided in subs. (4) and (5), any existing point source subject to this chapter may qualify for alternative effluent limitations for BPT, BAT, and BCT. The alternative effluent limitations for each pollutant are determined for a combination of outfalls by totaling the mass limitations of each pollutant allowed under this chapter and subtracting from each total an appropriate net reduction amount. The permit authority shall determine an appropriate net reduction amount for each pollutant traded based upon consideration of additional available control measures which would result in substantial effluent reductions and which can be achieved without requiring significant additional expenditures at any outfall in the combination for which the discharge is projected to be better than required by this chapter.

(2) For total suspended solids and oil and grease, the minimum net reduction amount shall be approximately 15% of the amount by which any waste stream in the combination will exceed otherwise allowable effluent limitations. For all other pollutants, the minimum net reduction amount shall be approximately 10% of the amount by which the discharges from any waste stream in the combination will exceed otherwise allowable effluent limitations for each pollutant under this chapter.

(3) Each outfall from which process wastewaters are discharged shall have specific fixed effluent limitations for each pollutant limited by the applicable sections of this chapter.

(4) If the application of alternative effluent limitations results in a violation of any applicable water quality standard, alternative effluent limitations are not permitted.

(5) Alternative effluent limitations are not permitted for cokemaking and cold forming process wastewaters.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.004 Calculation of pretreatment standards. Pretreatment standards shall be calculated for each operation using the applicable average rate of production reported by the owner or operator of the facility to the control authority in accordance with s. NR 211.15.

(2) The average rate of production reported by the owner or operator in accordance with s. NR 211.15 may not be based upon the design production capacity, but rather upon a reasonable measure of actual production of the facility, such as the production during the high month of the previous year or the monthly average for the highest month of the previous 5 years. For new sources or new dischargers, actual production shall be estimated using projected production.

(3) If the average rate of production for an operation reported in accordance with s. NR 211.15 does not represent a reasonable measure of actual production due to a change of circumstances,

the owner or operator shall submit a modified average rate of production to the control authority.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.005 Compliance dates. (1) Any existing source subject to this chapter which discharges to waters of the state shall achieve:

(a) the effluent limitations representing BPT by July 1, 1977; and

(b) the effluent limitations representing BAT by July 1, 1984.

(2) Any new source subject to this chapter which discharges to waters of the state shall achieve NSPS at the commencement of discharge.

(3) Any existing source subject to this chapter which introduces process wastewater pollutants into a POTW shall achieve PSES by July 10, 1985.

(4) Any new source subject to this chapter which introduces process wastewater pollutants into a POTW shall achieve PSNS at the commencement of discharge.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.006 Removal credits for phenois (4AAP). Removal allowances pursuant to s. NR 211.13 may be granted for phenois (4AAP) limited by this chapter when phenois (4AAP) are used as an indicator or surrogate pollutant.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Subchapter I — Cokemaking Subcategory

NR 254.01 Applicability; description of the cokemaking subcategory. This subcategory applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from byproduct and bechive cokemaking operations.

History: Cr. Register, May, 1989, No. 401, eff. 6-1--89.

NR 254.011 Specialized definitions. The following definitions are applicable to the terms used in cokemaking subcategory:

(1) "Beehive cokemaking" means operations in which coal is heated with the admission of air in controlled amounts for the purpose of producing coke and which do not recover byproducts.

(2) "Byproduct cokemaking" means operations in which coal is heated in the absence of air to produce coke. Byproducts may be recovered from the gases and liquids driven from the coal.

(3) "Merchant byproduct cokemaking" means byproduct cokemaking operations which provide more than 50% of the produced coke to operations, industries, or processes other than iron making blast furnaces associated with steel production.

(4) "Iron and steel byproduct cokemaking" means byproduct cokemaking operations other than merchant cokemaking operations.

(5) "Wet desulfurization system" means systems which remove sulfur compounds from coke oven gases and produce contaminated process wastewater.

(6) "Indirect. ammonia recovery system" means systems which recover ammonium hydroxide as a byproduct from coke oven gases and waste ammonia liquors.

(7) "Physical chemical treatment system" means full scale coke plant wastewater treatment systems incorporating full scale granular activated carbon adsorption units which were in operation prior to January 7, 1981.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.012 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. (1) Except as provided in 40 CFR 125.30 to 125.32, any existing source subject to this subchapter shall achieve the

effluent limitations set forth in sub. (2), (3), or (4) representing the degree of effluent reduction attainable by the application of BPT.

(2) IRON AND STEEL BYPRODUCT COKEMAKING. (a) The following BPT effluent limitations apply:

Table 1	
l Byproduct Coke	making
ffluent Limitation:	<u> </u>
Maximum for any 1 day	Average of daily values for 30 consecutive days
kg/kkg (pounds per 1,000 pounds) of product	
0.253	0.131
0.0327	0.0109
0.274	0.0912
0.0657	0.0219
0.00451	0.00150
(1)	(1)
	Maximum for any 1 day kg/kkg (pounds 0.253 0.0327 0.274 0.0657 0.00451

(1) Within the range of 6.0 to 9.0

(b) Increased loadings, not to exceed 11% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 27% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(3) MERCHANT BYPRODUCT COKEMAKING. (a) The following BPT effluent limitations apply:

Table 2
Merchant Byproduct Cokemaking
BPT Effluent Limitations

DFII		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds of product	
TSS	0.270	0.140
O&G	0.0349	0.0116
Ammonia-N	0.292	0.0973
Cyanide	0.0701	0.0234
Phenois (4AAP)	0.00481	0.00160
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

(b) Increased loadings, not to exceed 10% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 25% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(4) BEEHIVE COKEMAKING. Beehive cokemaking operations may not discharge process wastewaters to waters of the state. History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.013 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. (1) Except as provided in 40 CFR 125.30 to 125.32, any existing source subject to this subchapter shall achieve the effluent limitations in sub. (2), (3), or (4) representing

the degree of effluent reduction attainable by the application of BAT.

(2) IRON AND STEEL BYPRODUCT COKEMAKING. (a) The following BAT effluent limitations apply:

Table 3 Iron and Steel Byproduct Cokemaking			
BAT	'Effluent Limitatio	ns	
	Maximum for any 1 day	Average of daily values for 30 consecutive days	
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product		
Ammonia-N	0.0543	0.0160	
Cyanide	0.00638	0.00351	
Phenols (4AAP)	0.0000638	0.0000319	
Benzene	0.0000319		
Naphthalene	0.0000319		
Benzo(a)pyrene	0.0000319		

(b) Increased loadings, not to exceed 16% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 39% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(d) The following BAT effluent limitations shall be applicable to plants with physical chemical treatment systems:

	Table 4			
Iron and Steel Byproduct Cokemaking				
BATI	BAT Effluent Limitations			
	Maximum for	Average of daily values for 30 consecutive		
	any 1 day	days		
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product			
Ammonia-N	0.0645	0.0322		
Phenols (4AAP)	0.0000859	0.0000430		
Benzene	0.0000215			
Naphthalene	0.0000215			
Benzo(a)pyrene	0.0000215			

(e) Increased loadings, not to exceed 24% above the limitations in par. (d), are allowed for plants with physical chemical pretreatment systems which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(3) MERCHANT BYPRODUCT COKEMAKING. (a) The following BAT effluent limitations apply:

Table 5 Merchant Byproduct Cokemaking			
BATI	Effluent Limitations	s	
	Maximum for any 1 day	Average of daily values for 30 consecutive days	
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product		
Ammonia-N	0.0603	0.0177	
Cyanide	0.00709	0.00390	
Phenols (4AAP)	0.0000709	0.0000355	
Benzene	0.0000355		
Naphthalene	0.0000355		
Benzo(a)pyrene	0.0000355		

(b) Increased loadings, not to exceed 15% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 35% of the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(d) The following BAT effluent limitations shall be applicable to plants with physical chemical treatment systems:

Table 6 Iron and Steel Byproduct Cokemaking			
BAT Effluent Limitations			
	Maximum for any 1 day	Average of daily values for 30 consecutive days	
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product		
Ammonia-N	0.0751	0.0375	
Phenols (4AAP)	0.000100	0.0000501	
Benzene	0.0000250		
Naphthalene	0.0000250		
Benzo(a)pyrene	0.0000250		

(e) Increased loadings, not to exceed 21% above the limitations in par. (d), are allowed for plants with physical chemical pretreatment systems which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(4) BEEHIVE COKEMAKING. Beehive cokemaking operations may not discharge process wastewaters to waters of the state. History: Cr. Register, May, 1989, No. 401, cff. 6--1-89.

NR 254.014 New source performance standards. (1) The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the NSPS in sub. (2), (3), or (4).

(2) IRON AND STEEL BYPRODUCT COKEMAKING. (a) The following NSPS apply:

	Table 7	
Iron and Stee	el Byproduct Coker	naking
	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant kg/kkg (pounds per 1,000 pounds) property of product		
TSS	0.172	0.0894
O&G	0.00638	
Ammonia-N	0.0543	0.0160
Cyanide	0.00638	0.00351
Phenols (4AAP)	0.0000638	0.0000319
Benzene	0.0000319	
Naphthalene	0.0000319	
Benzo(a)pyrene	0,0000319	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

(b) Increased loadings, not to exceed 16% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 39% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(3) MERCHANT BYPRODUCT COKEMAKING. (a) The following NSPS apply:

	Table 8	
Merchant	Byproduct Cokema	ıking
	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant kg/kkg (pounds per 1,000 pour property of product		
TSS	0.192	0.0993
O&G	0.00709	÷
Ammonia-N	0.0603	0.0177
Cyanide	0.00709	0.00390
Phenols (4AAP)	0.0000709	0.0000355
Benzene	0.0000355	
Naphthalene	0.0000355	
Benzo(a)pyrene	0.0000355	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

(b) Increased loadings, not to exceed 15% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 35% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(4) BEEHIVE COKEMAKING. Bechive cokemaking operations may not discharge process wastewaters to waters of the state. History: Cr. Register, May, 1989, No. 401, cff. 6-1-89. NR 254.015 Pretreatment standards for existing sources. (1) Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the PSES in sub. (2) or (3).

(2) JRON AND STEEL BYPRODUCT COKEMAKING. (a) The following PSES apply:

Iron and Steel	Table 9 Byproduct Cokerr	aking
	PSES	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Ammonia-N	0.0645	0.0322
Cyanide	0.0172	0.00859
Phenols (4AAP)	0.0430	0.0215

(b) Increased loadings, not to exceed 24% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 58% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(3) MERCHANT BYPRODUCT COKEMAKING. (a) The following PSES apply:

	Table 10	
Merchant	Byproduct Cokema	iking
	PSES	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Ammonia-N	0.0751	0.0375
Cyanide	0.0200	0.0100
Phenols (4AAP)	0.0501	0.0250

(b) Increased loadings, not to exceed 21% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 50% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.016 Pretreatment standards for new sources. (1) Except as provided in s. NR 211.13, any existing [new] source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the PSNS in sub. (2) or (3).

(2) IRON AND STEEL BYPRODUCT COKEMAKING. (a) The following PSNS apply:

Iron and Ste	Table 11 el Byproduct Coker	making
· · · · · · · · · · · · · · · · · · ·	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Ammonia-N	0.0645	0.0322
Cyanide	0.0172	0.00859
Phenols (4AAP)	0.0430	0.0215

(b) Increased loadings, not to exceed 24% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 58% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(3) MERCHANT BYPRODUCT COKEMAKING. (a) The following PSNS apply:

Table 12 Merchant Byproduct Cokemaking

	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
AmmoniaN	0.0751	0.0375
Cyanide	0.0200	0.0100
Phenols (4AAP)	0.0501	0.0250

(b) Increased loadings, not to exceed 21% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 50% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.017 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. (1) Except as provided in 40 CFR 125.30 to 125.32, any existing source subject to this subchapter shall achieve the effluent limitations in sub. (2), (3), or (4) representing the degree of effluent reduction attainable by the application of BCT.

(2) IRON AND STEEL BYPRODUCT COKEMAKING. (a) The following BCT effluent limitations apply:

Iron And Ste	Table 13 el Byproduct Coke	making	
BCT I	Effluent Limitation	s	
Average of daily values for Maximum for 30 consecutive any 1 day days			
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product		
TSS	0.253	0.131	
O&G	0.0327	0.0109	
pH	(1)	(1)	

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(1) Within the range of 6.0 to 9.0

(b) Increased loadings, not to exceed 11% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 27% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(3) MERCHANT BYPRODUCT COKEMAKING. (a) The following BCT effluent limitations apply:

Merchant 1	Table 14 Byproduct Cokema	king
BCT H	Effluent Limitation	S
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.270	0.140
O&G	0.0348	0.0116
pH (1) Within the range of 6.0 to 1	(1)	· (1)

(1) Within the range of 6.0 to 9.0

(b) Increased loadings, not to exceed 10% above the limitations in par. (a), are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

(c) Increased loadings, not to exceed 25% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

(4) BEEHIVE COKEMAKING. Beehive cokemaking operations may not discharge process wastewaters to waters of the state. History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

Subchapter II — Sintering Subcategory

NR 254.02 Applicability; description of the sintering subcategory. This subcategory applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from sintering operations conducted by the heating of iron bearing wastes, such as mill scale and dust from blast furnaces, together with fine iron ore, limestone, and coke fines in an ignition furnace to produce an agglomerate for charging to a blast furnace.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.022 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

	Table 15	
	Sintering	
BPT E	Effluent Limitation	S
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds of product	
TSS	0.0751	0.0250
O&G	0.0150	0.00501
pH (1) Within the range of 6.0 to 5	(1)	(1)

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.023 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BAT:

Table 16 Sintering

BAT E	ffluent Limitations	
		Average of
		daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or pollutant	kg/kkg (pounds j	per 1,000 pounds)
property	of product	
Ammonia-N(1)	0.0150	0.00501
Cyanide(1)	0.00300	0.00150
Phenols (4AAP)(1)	0.0001000	0.0000501
TRC(1)	0.000250	
Lead	0.000451	0.000150
Zinc	0.000676	0.000225

(1) The limitations for ammonia--N, cyanide, and phenois (4AAP) shall be applicable only when sintering wastewaters are treated with ironmaking wastewaters.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.024 New source performance standards. The discharge of wastewater pollutants from any new source subject to the sintering subcategory may not exceed the following standards:

	Table 17 Sintering	
	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.0200	0.00751
O&G	0.00501	
Ammonia-N(1)	0.0150	0.00501
Cyanide(1)	0.00100	0.000501
Phenols (4AAP)(1)	0.000100	0.0000501
TRC(1)	0.000250	
Lead	0.000451	0.000150
Zinc	0.000676	0.000225
pH	(2)	(2)

(1) The limitations for ammonia-N, cyanide, phenols (4AAP), and TRC shall be applicable only when sintering wastewaters are treated with ironmaking wastewaters.

(2) Within the range of 6.0 to 9.0 History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

NR 254.025 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSES:

	Table 18 Sintering	
	PSES	•.
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Ammonia-N(1)	0.0150	0,00501
Cyanide(1)	0.00300	0.000150
Phenols (4AAP)(1)	0.000100	0.0000501
Lead	0.000451	0.000150
Zinc	0.000676	0.000225

(1) the initiations for animonia-is, cyanice and pacifies (4AAr) shart be applicable only when sintering wastewaters are treated with ironmaking wastewa-

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.026 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to the subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSNS:

	Table 19 Sintering	
	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Ammonia-N(1)	0.0150	0.00501
Cyanide(1)	0,00100	0.000501
Phenols (4AAP)(1)	0.000100	0.0000501
Lead	0.000451	0.000150
Zinc	0.000676	0.000225

(1) The limitations for ammonia-N, cyanide and phenois (4AAP) shall be applicable only when sintering wastewaters are treated with ironmaking wastewaters.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Subchapter III — Ironmaking Subcategory

NR 254.03 Applicability; description of the ironmaking subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from ironmaking operations in which iron ore is reduced to molten iron in a blast furnace.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.031 Specialized definitions. The following definitions are applicable to the terms used in this subchapter:

(1) "Existing indirect dischargers" means only the 2 iron blast furnace operations with discharges to POTWs prior to May 27, 1982.

(2) "Ferromanganese blast furnace" means those blast furnaces which produce molten iron containing more than 50% manganese.

(3) "Iron blast furnace" means all blast furnaces except ferromanganese blast furnaces.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.032 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125,30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

Irc	Table 20 in Blast Furnace	
BPT I	Effluent Limitations	}
:		Average of daily values for
• *	Maximum for any 1 day	30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0782	0.0260
Ammonia-N	0.161	0.0537
Cyanide	0.0234	0.00782
Phenols (4AAP)	0.00626	0.00210
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 21 Ferromanganese Blast Furnace **BPT** Effluent Limitations Average of daily values for Maximum for 30 consecutive any 1 day days Pollutant or pollutant kg/kkg (pounds per 1,000 pounds) of product property TSS 0.313 0.104 0 100

AmmoniaN	1.29	0.429
Cyanide	0.469	0.156
Phenols (4AAP)	0.0624	0.0208
pH	(1)	. (1)

(1) Within the range of 6.0 to 9.0 History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.033 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BAT:

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Table 22	
n Blast Furnace	
Effluent Limitations	S
Maximum for any 1 day	Average of daily values for 30 consecutive days
	per 1,000 pounds) roduct
0.00876	0.00292
0.00175	0.000876
0.0000584	0.0000292
0.00146	
0.000263	0.0000876
0.000394	0.000131
	n Blast Furnace Iffluent Limitations Maximum for any 1 day kg/kkg (pounds of pr 0.00876 0.00175 0.0000584 0.00146 0.000263

(1) The limitations for TRC shall be applicable only when iron making wastewater is chlorinated.

History: Cr. Register, May, 1989, No. 401, cff. 6-1-89.

NR 254.034 New source performance standards. The discharge of process wastewater pollutants from any new source subject to this subchapter may not exceed the following standards:

. Irc	Table 23 m Blast Furnace	
	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0117	0.00438
O&G	0.00292	
AmmoniaN	0.00876	0.00292
Cyanide	0.000584	0.000292
Phenols (4AAP)	0.0000584	0.0000292
TRC(1)	0.000146	
Lead	0.000263	0.0000876
Zinc	0.000394	0.000131
рН	(2)	(2)

 The limitations for TRC shall be applicable only when iron making wastewater is chlorinated.

(2) Within the range of 6.0 to 9.0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.035 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSES:

	Table 24
Inon	Diast Europea

Iro	n Blast Furnace	
	PSES	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds of p	per 1,000 pounds) roduct
Ammonia–N	0.00876	0.00292
Cyanide	0.00175	0.000876
Phenols (4AAP)	0.0000584	0.0000292
Lead	0.000263	0.0000876
Zinc	0,000394	0.000131
Entiting	Indirect Discharge PSES	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds p of pr	er 1,000 pounds) oduct
Ammonia-N	0.0350	0.0175
Cyanide	0.00175	0.000876
Phenols (4AAP)	0.000175	0.0000584
Lead	0.000263	0.0000876
Zinc	0.000394	0.000131

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.036 Pretreatment standards for new sources. Except as provided in s. NR 211.13, a new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSNS:

	Table 26	
Irc	n Blast Furnace	
	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
AmmoniaN	0.00876	0.00292
Cyanide	0.000584	0.000292
Phenols (4AAP)	0.0000584	0.0000292
Lead	0.000263	0.0000876
Zinc	0.000394	0.000131
History: Cr Register May 1	989 No 401 eff 6-1-8	9

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Subchapter IV --- Steelmaking Subcategory

NR 254.04 Applicability; description of the steelmaking subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from steelmaking operations conducted in basic oxygen, open hearth, and electric arc furnaces.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.041 Specialized definitions. The following definitions are applicable to the terms used in the steelmaking subcategory:

(1) "Basic oxygen furnace steelmaking" means the production of steel from any combination of molten iron, steel scrap, and fluxes in refractory lined furnaces by adding oxygen.

(2) "Electric arc furnace steelmaking" means the production of steel principally from steel scrap and fluxes in refractory lined furnaces by passing an electric current through the scrap or steel bath.

(3) "Open combustion" means basic oxygen furnace steel making wet air cleaning systems which are designed to allow excess air to enter the air pollution control system for the purpose of combusting the carbon monoxide furnace gases.

(4) "Open hearth furnace steelmaking" means the production of steel from any combination of molten iron, steel scrap, and fluxes in refractory lined fuel fired furnaces equipped with regenerative chambers to recover heat from the flue and combustion gases.

(5) "Semi-wet" means steelmaking air cleaning systems that use water for the sole purpose of conditioning the temperature and humidity of furnace gases such that the gases may be cleaned in dry air pollution control systems.

(6) "Suppressed combustion" means basic oxygen furnace steelmaking wet air cleaning systems which are designed to limit or suppress the combustion of carbon monoxide in furnace gases by restricting the amount of excess air entering the air pollution control system.

(7) "Wet" means steelmaking air cleaning systems that primarily use water for furnace gas cleaning.

History: Cr. Register, May, 1989, No. 401, eff. 6-1--89.

NR 254.042 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT. Semi-wet basic oxygen furnace steelmaking operations and semi-wet electric arc furnace steelmaking operations may not discharge process wastewater pollutants to waters of the state. TSS

pН

Fur	Table 27 1 Combustion Basic nace Steelmaking	
BPT H	Effluent Limitations	:
· .	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.0312	0.0104
pН	(1)	(1)
(1) Within the range of 6.0 to	9.0	
Steelmaking, Wet Open 1	Table 28 oustion Basic Oxyg Hearth Furnace Stee rc Furnace Steelma	elmaking, and Wet
BPT H	Effluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct

(1) Within the range of 6.0 to 9.0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.043 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BAT. Semi-wet basic oxygen furnace steelmaking operations and semi-wet electric arc furnace steelmaking operations may not discharge process wastewater pollutants to waters of the state.

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(1)

0.0229

(1)

	Table 29 essed Combustion I Furnace Steelmaki	
BAT I	Iffluent Limitation	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Lead	0.000188	0.0000626
Zinc	0.000282	0.0000939

	Table 30 Basic Oxygen Furr th Furnace Steelma Arc Furnace Steelr	king and
BAT I	Effluent Limitations	•
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
Lead	0.000413	0.000138
Zinc	0.000620	0.000207

. . .

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.044 New source performance standards. The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the following standards:

Table 31
Wet Suppressed Combustion Basic Oxygen
Furnace Steelmaking

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.0146	0.00522
Lead	0.000188	0.0000626
Zinc	0.000282	0.0000939
pН	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 32

Wet Open Combustion Basic Oxygen Furnace Steelmaking and Wet Electric Arc Furnace Steelmaking

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.0321	0.0115
Lead	0.000413	0.000138
Zinc	0.000620	0.000207
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.045 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSES:

	Table 33 d Combustion Basic nace Steelmaking	c Oxygen
	PSES	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Lead	0.000188	0.0000626
Zinc	0.000282	0.0000939
	rth Furnace Steelma Arc Furnace Steela	iking and
	PSES	Average of daily
•	Maximum for any I day	values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Lead	0.000413	0.000138
Ting	0.000620	0 000207

Pollutant or pollutant property		per 1,000 pounds) roduct
Lead	0.000413	0.000138
Zinc	0.000620	0.000207
Hictory Cr Desister May 1	090 No 401 off 6 1 9	0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.046 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSNS:

Table 35
Wet Suppressed Combustion Basic Oxygen
Furnace Steelmaking

PSNS	
Maximum for any 1 day	Average of daily values for 30 consecutive days
kg/kkg (pounds per 1,000 pounds) of product	
0.000188	0.0000626
0.000282	0.0000939
	Maximum for any 1 day kg/kkg (pounds of pr 0.000188

Table 36 Wet Open Combustion Basic Oxygen Furnace Steelmaking, and Wet Electric Arc Furnace Steelmaking

	- · ·
PSES	
Maximum for any 1 day	Average of daily values for 30 consecutive days
kg/kkg (pounds per 1,000 pounds) of product	
0.000413	0.000138
0.000620	0.000207
	Maximum for any 1 day kg/kkg (pounds of pr 0.000413

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.047 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. Semi-wet basic oxygen furnace steelmaking operations and semi-wet electric arc furnace operations may not discharge process wastewater pollutants to waters of the state.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Subchapter V — Vacuum Degassing Subcategory

NR 254.05 Applicability; description of the vacuum degassing subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from vacuum degassing operations conducted by applying a vacuum to molten steel. History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.052 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently avallable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

Va	Table 37 cuum Degassing	14
BPTI	Effluent Limitation:	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0156	0.00521
pН	(1)	(1)
(1) Within the range of 6.0 to		

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.053 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BAT:

Va	Table 38 cuum Degassing	
BAT	Effluent Limitatio	ns
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469
History: Cr. Register, May, 1	989, No. 401, eff. 6-18	9.

NR 254.054 New source performance standards. The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the following standards:

	Table 39	
Va	cuum Degassing	
	NSPS	
		Average of daily values for
	Maximum for any 1 day	30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.00730	0.00261
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469
pH	(1)	(1)
(1) Within the range of 6.0 to	9.0	

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.055 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSES:

Va	Table 40 cuum Degassing	
	PSES	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469
History: Cr. Register, May, 1	989, No. 401, eff. 6-1-8	9.

matory. ci. Register, May, 1969, No. 401, cii. 0-1-69.

NR 254.056 Pretreatment standards for new sources. Any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSNS:

. Va	Table 41 cuum Degassing	
	PSNS	
·····	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Lead	0.0000939	0.0000313
Zinç	0.000141	0.0000469

History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

Subchapter VI — Continuous Casting Subcategory

NR 254.06 Applicability; description of the continuous casting subcategory. This subcategory applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from the continuous casting of molten steel into intermediate or semifinished steel products through water cooled molds.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.062 Effiuent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

uent Limitation	ns Average of daily values for
laximum for any 1 day	30 consecutive days
	per 1,000 pounds) coduct
0.0780	0.0260
0.0234	0.0078
(1)	(1)
	any 1 day g/kkg (pounds of pi 0.0780 0.0234

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.063 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BAT:

Con	Table 43 tinuous Casting	
BATE	ffluent Limitations	
••		Average of daily values for
	Maximum for any 1 day	30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469
History: Cr. Register, May, 19	89, No. 401, eff. 6-1-89	

NR 254.064 New source performance standards. The discharge of process wastewater pollutants from any new source subject to this subchapter may not exceed the following standards:

Co	Table 44 ntinuous Casting	
· .	NSPS	
2 1	Maximum for	Average of daily values for 30 consecutive
	any 1 day	days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.00730	0.00261
O&G	0.00313	0.00104
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469
pН	(1)	(1)
 Within the range of 6.0 to 5 	9.0	

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.065 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to the continuous casting subcategory which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSES:

	Table 45	
Co	ntinuous Casting	
,	PSES	
:	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469
History: Cr. Register, May, 1	989, No. 401, eff. 6-1-8	9.

NR 254.066 Pretreatment standards for new sources. Any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSNS:

Co	Table 46 ntinuous Casting	· · ·
	PSNS	2
· · ·	Maximum for	Average of daily values for 30 consecutive
	any 1 day	days
Pollutant or pollutant property		per 1,000 pounds) roduct
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469
History: Cr. Register, May, 1	989, No. 401, eff. 6-1-8	9.

Subchapter VII — Hot Forming Subcategory

NR 254.07 Applicability; description of hot forming subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from hot forming operations conducted in primary, section, flat, and pipe and tube mills.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.071 Specialized definitions. The following definitions are applicable to the terms used in this subchapter:

(1) "Carbon hot forming operation" means hot forming operations which produce a majority, on a tonnage basis, of carbon steel products.

(2) "Carbon steel" means steel products other than specialty steel products.

(3) "Hot forming" means steel operations in which solidified heated steel is shaped by rolls.

(4) "Hot strip and sheet mill" means steel hot forming operations that produce flat hot-rolled products other than plates.

(5) "Pipe and tube mill" means steel hot forming operations that produce butt welded or seamless tubular products,

(6) "Plate mill" means steel hot forming operations that produce flat hot rolled products which are either between 8 and 48 inches wide and over 0.23 inches thick or greater than 48 inches wide and over 0.18 inches thick.

(7) "Primary mill" means the first hot forming steel operations performed on solidified steel after it is removed from the ingot mold, such as steel hot forming operations that reduce ingots to blooms or slabs by passing the ingots between rotating steel rolls.

(8) "Scarfing" means steel surface conditioning operations in which flames generated by the combustion of oxygen and fuel are used to remove surface metal imperfections from slabs, billets, or blooms.

(9) "Section mill" means steel hot forming operations that produce finished and semifinished steel products other than the products of flat, pipe and tube, plate, and hot strip and sheet mills.

(10) "Specialty hot forming operation" means all hot forming operations other than carbon hot forming operations.

(11) "Specialty steel" means steel products containing alloying elements, such as aluminum, chromium, cobalt, columbium, molybdenum, nickel, titanium, tungsten, vanadium, or zirconium, which are added to enhance the properties of the steel product when individual alloying elements exceed 3% or the total of all alloying elements exceeds 5%.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

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NR 254.072 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

	y Primary Mills Wi Effluent Limitations	
BPIE	inuent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds) of pr	per 1,000 pounds) oduct
TSS	0.150	0.0561
O&G	0.0374	
рН	(1)	(1)
(1) Within the range of 6.0 to the	9.0	
Carbon and Specia	Table 48 Ity Primary Mills V	Vith Scarfing
	Effluent Limitations	
:.	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds) of pr	per 1,000 pounds) oduct
TSS	0.221	0.0830
O&G	0.0553	
pH	(1)	(1)
(I) Within the range of 6.0 to 2		
• . •	Table 49	
Carl	oon Section Mills	
BPT H	Effluent Limitations	1
		Average of
	Marian far	daily values for
	Maximum for any 1 day	3 consecutive days
Pollutant or pollutant property	kg/kkg (pounds)	per 1,000 pounds) oduct
TSS	0.357	0.134
0&G	0.0894	0.104
рН	(1)	(1)
(1) Within the range of 6.0 to		(1)
··· ·	Table 50 ialty Section Mills	
	Effluent Limitations	
		Average of
		daily values for
•	Maximum for	30 consecutive
• •	any 1 day	days
Pollutant or pollutant property	any 1 day kg/kkg (pounds j	
	any 1 day kg/kkg (pounds j	per 1,000 pounds)
property	any 1 day kg/kkg (pounds) of pr	per 1,000 pounds) oduct

Carbon and Spec	Table 51 ialty Hot Strip and	Sheet Mills
BPT E	Effluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.427	0.160
O&G	0.107	
pН	(1)	(1)
(1) Within the range of 6.0 to	9.0	
Ca	Table 52 rbon Plate Mills	
BPT E	Effluent Limitations	· · · · · · · · · · · · · · · · · · ·
ni		Average of
	Maximum for any 1 day	daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds p of pr	per 1,000 pounds) oduct
TSS	0.227	0.0851
O&G	0.0568	
pН	(1)	(1)
(1) Within the range of 6.0 to 9		
Spe	Table 53 cialty Plate Mills	
	Sffluent Limitations	;
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds	per 1,000 pounds) oduct
TSS	0.100	0.0376
0&G	0.0250	
рН	(1)	(1)
(1) Within the range of 6.0 to		.,
Carbon and Sr	Table 54 ecialty Pipe and Ta	ibe Mills
	Iffluent Limitations	
	Maximum for	Average of daily values for 30 consecutive
	any 1 day	days
Pollutant or pollutant property	kg/kkg (pounds	per 1,000 pounds) oduct
TSS	0.212	0.0795
O&G	0.0530	
		(1)
pH	(1) 9.0	(1)

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.073 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. The effluent limitations set forth in s. NR 254.072 represent BAT.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.074 New source performance standards. The discharge of process wastewater pollutants from any new source subject to the hot forming subchapter may not exceed the following standards:

O. J	Table 55	
Carbon and Specialt	NSPS	mout scaring
	INSES	Augrage of
al e comencia. A	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds p of pro	
TSS	0.0150	0.00563
O&G	0.00373	
pH	(1)	(1)
(1) Within the range of 6.0 to 9	9.0	
Carbon and Specia	Table 56 lty Primary Mills W	/ith Scarfing
	NSPS	
		Average of
	Maximum for any 1 day	daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds p of pre	er 1,000 pounds) oduct
TSS	0.0234	0.00876
O&G	0.00584	
pН	(1)	(1)
Carl	Table 57 oon Section Mills	
	NSPS	
	Maximum for	Average of daily values for
	Maximum for any 1 day	30 consecutive days
Pollutant or pollutant property	any 1 day kg/kkg (pounds p	days er 1,000 pounds) oduct
Pollutant or pollutant property TSS	any 1 day kg/kkg (pounds p	days er 1,000 pounds)
property	any 1 day kg/kkg (pounds p of pr	days er 1,000 pounds) oduct
property TSS O&G pH	any 1 day kg/kkg (pounds p of pr 0.0334 0.00834 (1)	days er 1,000 pounds) oduct
property TSS O&G	any 1 day kg/kkg (pounds p of pr 0.0334 0.00834 (1)	days per 1,000 pounds) oduct 0.0125
property TSS O&G pH (1) Within the range of 6.0 to	any 1 day kg/kkg (pounds p of pr 0.0334 0.00834 (1) 9.0 Table 58 ialty Section Mills	days per 1,000 pounds) oduct 0.0125
property TSS O&G pH (1) Within the range of 6.0 to	any 1 day kg/kkg (pounds p of pr 0.0334 0.00834 (1) 9.0 Table 58	days per 1,000 pounds) oduct 0.0125
property TSS O&G pH (1) Within the range of 6.0 to	any 1 day kg/kkg (pounds p of pr 0.0334 0.00834 (1) 9.0 Table 58 ialty Section Mills NSPS Maximum for	days per 1,000 pounds) oduct 0.0125
property TSS O&G pH (1) Within the range of 6.0 to Spec Pollutant or pollutant	any 1 day kg/kkg (pounds p of pr 0.0334 0.00834 (1) 9.0 Table 58 ialty Section Mills NSPS Maximum for any 1 day kg/kkg (pounds p	days ver 1,000 pounds) oduct 0.0125 (1) Average of daily values for 30 consecutive
property TSS O&G pH (1) Within the range of 6.0 to Spec	any 1 day kg/kkg (pounds p of pr 0.0334 0.00834 (1) 9.0 Table 58 ialty Section Mills NSPS Maximum for any 1 day kg/kkg (pounds p	days ver 1,000 pounds) oduct 0.0125 (1) Average of daily values for 30 consecutive days ver 1,000 pounds)
property TSS O&G pH (1) Within the range of 6.0 to Spec Pollutant or pollutant property	any 1 day kg/kkg (pounds p of pr 0.0334 0.00834 (1) 9.0 Table 58 ialty Section Mills NSPS Maximum for any 1 day kg/kkg (pounds p of pr	days ver 1,000 pounds) oduct 0.0125 (1) Average of daily values for 30 consecutive days ver 1,000 pounds) oduct

(1) Within the range of 6.0 to 9.0

Carbon and Spec	Table 59 ialty Hot Strip and 3	Sheet Mills
	NSPS	
		Average of
		daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or pollutant property	of pr	per 1,000 pounds) oduct
TSS	0.0435	0.0163
O&G	0.0109	
pH	(1)	(1)
(1) Within the range of 6.0 to	9.0	
Ca	Table 60 rbon Plate Mills	
	NSPS	
	Maximum for	Average of
. •	any 1 day	daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.0234	0.00876
0&G	0.00584	
pН	(1)	(1)
(1) Within the range of 6.0 to		
Spe	Table 61 cialty Plate Mills NSPS	
	nərə	A
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds)	per 1,000 pounds) oduct
TSS	0,0100	0.00375
O&G	0.00250	
pН	(İ)	(1)
(1) Within the range of 6.0 to		(-)
· · ·	2.0	
Carbon and Sp	Table 62 secialty Pipe and Tu	ıbe Mills
Carbon and SI	Table 62	ıbe Mills
Carbon and Sp	Table 62 secialty Pipe and Tu	Average of
Carbon and S	Table 62 pecialty Pipe and Tu NSPS Maximum for	Average of daily values for 30 consecutive
Pollutant or pollutant	Table 62 pecialty Pipe and Tu NSPS Maximum for any 1 day kg/kkg (pounds	Average of daily values for 30 consecutive days per 1,000 pounds)
Pollutant or pollutant property	Table 62 pecialty Pipe and Tu NSPS Maximum for any 1 day kg/kkg (pounds of pr	Average of daily values for 30 consecutive days per 1,000 pounds) roduct
Pollutant or pollutant property TSS	Table 62 pecialty Pipe and Tu NSPS Maximum for any 1 day kg/kkg (pounds of pr 0.0369	Average of daily values for 30 consecutive days per 1,000 pounds)
Pollutant or pollutant property	Table 62 pecialty Pipe and Tu NSPS Maximum for any 1 day kg/kkg (pounds of pr	Average of daily values for 30 consecutive days per 1,000 pounds) roduct

pH (1) (1) Within the range of 6.0 to 9.0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.075 Pretreatment standards for existing sources. Any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211. History: Cr. Register, May, 1989, No. 401, cff. 6-1-89.

NR 254.076 Pretreatment standards for new sources. Any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211. History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

NR 254.077 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. The BCT effluent limitations are identical to the limitations set forth in s. NR 254.072.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Subchapter VIII — Salt Bath Descaling Subcategory

NR 254.08 Applicability; description of the salt bath descaling subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from oxidizing and reducing salt bath descaling operations.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.081 Specialized definitions. The following definitions are applicable to the terms used in this subchapter:

(1) "Batch" means descaling operations in which the products are processed in discrete batches.

(2) "Continuous" means descaling operations that remove surface scale from sheet or wire products in continuous processes.

(3) "Oxidizing salt bath descaling" means the removal of scale from semi-finished steel products by the action of molten salt baths other than those containing sodium hydride.

(4) "Pipe and tube batch" means descaling operations that remove surface scale from pipe and tube products in batch processes.

(5) "Reducing salt bath descaling" means the removal of scale from semi-finished steel products by the action of molten salt baths containing sodium hydride.

(6) "Rod and wire batch" means descaling operations that remove surface scale from rod and wire products in batch processes.

(7) "Sheet and plate batch" means descaling operations that remove surface scale from sheet and plate products in batch processes.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.082 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

Sheet And Plate Bat	Table 63 ch Oxidizing Salt H	Bath Descaling
BPT I	Iffluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.204	0.0876
Chromium	0.00292	0.00117
Nickel	0.00263	0.000876
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 64 Rod And Wire Batch Oxidizing Salt Bath Descaling **BPT** Effluent Limitations Average of daily values for 30 consecutive Maximum for any 1 day days kg/kkg (pounds per 1,000 pounds) Pollutant or pollutant of product property TSS 0.123 0.0526 0.000701 Chromium 0.00175 Nickel 0.00158 0.000526 pН (1)(1)(1) Within the range of 6.0 to 9.0 Table 65 Pipe And Tube Batch Oxidizing Salt Bath Descaling **BPT** Effluent Limitations Average of daily values for Maximum for 30 consecutive days any 1 day kg/kkg (pounds per 1,000 pounds) Pollutant or pollutant of product property TSS 0.496 0.213 0.00709 0.00284 Chromium 0.00638 0.00213 Nickel pH (1)(1)(1) Within the range of 6.0 to 9.0 Table 66 Continuous Oxidizing Salt Bath Descaling **BPT Effluent Limitations** Average of daily values for 30 consecutive Maximum for any 1 day days Pollutant or pollutant kg/kkg (pounds per 1,000 pounds) of product property TSS 0.0964 0.0413 Chromium 0.00138 0.000551 Nickel 0.00124 0.000413 pН (1)(1)(1) Within the range of 6.0 to 9.0 Table 67 Batch Reducing Salt Bath Descaling **BPT Effluent Limitations** Average of daily values for Maximum for 30 consecutive any 1 day days Pollutant or pollutant kg/kkg (pounds per 1,000 pounds) of product property TSS 0.0949 0.0407 Cyanide 0.00102 0.000339 Chromium 0.00136 0.00542 0.00122 0.000407 Nickel nH (1)(1)

(1) Within the range of 6.0 to 9.0

Continuous Re	Table 68 ducing Salt Bath E	Descaling
BPT I	Effluent Limitations	; ;
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.532	0.228
Cyanide	0.00569	0.00190
Chromium	0.00759	0.00304
Nickel	0.00683	0.00228
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.083 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BAT:

Table 69
Sheet And Plate Batch Oxidizing Salt Bath Descaling
DATE TOOL

		Average of
	-	daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or pollutant		per 1,000 pounds)
property	of product	
Chromium	0.00292	0.00117
Nickel	0.00263	0.000876
	Table 70	
Dad And Wine Date		
		ath Llacestine
	h Oxidizing Salt B	
	In Oxidizing Salt B	
	<u> </u>	s Average of daily
	<u> </u>	s Average of daily values for 30
	<u> </u>	s Average of daily
	Sffluent Limitation	s Average of daily values for 30
	Iffluent Limitation Maximum for any 1 day	s Average of daily values for 30 consecutive days
BAT E	Summer Series Strategies Strategi	s Average of daily values for 30 consecutive days
BAT E Pollutant or pollutant	Summer Series Strategies Strategi	s Average of daily values for 30 consecutive days per 1,000 pounds)

Table '	71
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Pipe And Tube Batch	Oxidizing Salt Bath	Descaling

Iffluent Limitations	3
Maximum for any 1 day	Average of daily values for 30 consecutive days
kg/kkg (pounds per 1,000 pound of product	
0.00709	0.00284
0.00638	0.00213
	any 1 day kg/kkg (pounds of pr 0.00709

	Table 72	
	idizing Salt Bath E	
)	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds) of pr	per 1,000 pounds) oduct
Chromium	0.00138	0.000551
Nickel	0.00124	0.000413
	Table 73 cing Salt Bath Des Effluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds of pi	per 1,000 pounds) roduct
Cyanide	0.00102	0.000339
Chromium	0.00136	0.000542
Nickel	0.00122	0.000407
	Table 74 educing Salt Bath I Effluent Limitation	
·····		Average of
	Maximum for any 1 day	daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Cyanide	0.00569	0.00190
Cyanue	0.00302	0.00120

 Chromium
 0.00759
 0.00304

 Nickel
 0.00683
 0.00228

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.084 New source performance standards. The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the limitations set forth in s. NR 254.082.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.085 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the limitations set forth in s. NR 254.083.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.086 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the limitations set forth in s. NR 254.083.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.087 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. Except as provided in 40 CFR 125.30 to 125.32, any existing

point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BCT:

Table 75
Sheet And Plate Batch Oxidizing Salt Bath Descaling
DCT Effluent Limitations

BCT H	Effluent Limitations	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds) of pr	per 1,000 pounds) roduct
TSS	0.204	0.0876
pН	(1)	(1)
(1) Within the range of 6.0 to 9		
Rod And Wire Bate		
BCT H	Effluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	of pi	per 1,000 pounds) roduct
TSS	0.123	0.0526
рН	(1)	(1)
(1) Within the range of 6.0 to	9.0	
Pipe And Tube Bate		
BCT I	Effluent Limitation	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
		•
Pollutant or pollutant property	kg/kkg (pounds of p	per 1,000 pounds) roduct
Pollutant or pollutant property TSS		
property TSS pH	of p 0.496 (1)	roduct
property TSS	of p 0.496 (1) 9.0	o.213
property TSS pH (1) Within the range of 6.0 to Continuous O2	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I	oduct 0.213 (1) Descaling
property TSS pH (1) Within the range of 6.0 to Continuous O2	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation	oduct 0.213 (1) Descaling
property TSS pH (1) Within the range of 6.0 to Continuous O2	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I	oduct 0.213 (1) Descaling
property TSS pH (1) Within the range of 6.0 to Continuous O2	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds of p	roduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds) roduct
property TSS pH (1) Within the range of 6.0 to Continuous O BCT J Pollutant or pollutant	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds	oduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds)
property TSS pH (1) Within the range of 6.0 to Continuous O2 BCT J Pollutant or pollutant property	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds of p	roduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds) roduct
property TSS pH (1) Within the range of 6.0 to Continuous O2 BCT 1 Pollutant or pollutant property TSS	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds of p 0.0964 (1)	roduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds) roduct 0.0413
property TSS pH (1) Within the range of 6.0 to Continuous O2 BCT 1 Pollutant or pollutant property TSS pH (1) Within the range of 6.0 to	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds of p 0.0964 (1) 9.0 Table 79	roduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds) roduct 0.0413 (1)
property TSS pH (1) Within the range of 6.0 to Continuous Or BCT 1 Pollutant or pollutant property TSS pH (1) Within the range of 6.0 to Batch Redu	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds of p 0.0964 (1) 9.0	roduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds) roduct 0.0413 (1) scaling s
property TSS pH (1) Within the range of 6.0 to Continuous Or BCT 1 Pollutant or pollutant property TSS pH (1) Within the range of 6.0 to Batch Redu	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds of p 0.0964 (1) 9.0 Table 79 ucing Salt Bath Des Effluent Limitation Maximum for any 1 day	roduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds) roduct 0.0413 (1) scaling s Average of daily values for 30 consecutive days
property TSS pH (1) Within the range of 6.0 to Continuous Or BCT 1 Pollutant or pollutant property TSS pH (1) Within the range of 6.0 to Batch Redu	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds of p 0.0964 (1) 9.0 Table 79 ucing Salt Bath Des Effluent Limitation Maximum for any 1 day kg/kkg (pounds	roduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds) roduct 0.0413 (1) scaling s Average of daily values for 30 consecutive
property TSS pH (1) Within the range of 6.0 to Continuous O2 BCT J Pollutant or pollutant property TSS pH (1) Within the range of 6.0 to Batch Redu BCT J	of p 0.496 (1) 9.0 Table 78 xidizing Salt Bath I Effluent Limitation Maximum for any 1 day kg/kkg (pounds of p 0.0964 (1) 9.0 Table 79 ucing Salt Bath Des Effluent Limitation Maximum for any 1 day kg/kkg (pounds	roduct 0.213 (1) Descaling s Average of daily values for 30 consecutive days per 1,000 pounds) roduct 0.0413 (1) scaling s Average of daily values for 30 consecutive days per 1,000 pounds)

(1) Within the range of 6.0 to 9.0

Continuous Re	Table 80 ducing Salt Bath I	Descaling
BCT E	Iffluent Limitations	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.532	0.228
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0 History: Cr. Register, May, 1989, No. 401, eff. 6-1-89

Subchapter IX --- Acid Pickling Subcategory

NR 254.09 Applicability; description of the acid pickling subcategory. This subcategory applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from sulfuric acid, hydrochloric acid, or combination acid pickling operations.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.091 Specialized definitions. The following definitions are applicable to the terms used in this subchapter:

(1) "Acid recovery" means sulfuric acid pickling operations that include processes for recovering the unreacted acid from spent pickling solutions.

(2) "Acid regeneration" means hydrochloric acid pickling operations that include processes for regenerating acid from spent pickling solutions.

(3) "Bar, billet, and bloom" means acid pickling operations that pickle bar, billet, or bloom products.

(4) "Batch" means pickling operations which process steel products such as coiled wire, rods, and tubes in discrete batches or bundles.

(5) "Combination acid pickling" means operations in which steel products are immersed in solutions of more than one acid to chemically remove oxides and scale and the associated rinsing operations.

(6) "Continuous" means pickling operations other than batch operations.

(7) "Fume scrubber" means pollution control devices used to remove and clean fumes originating in the pickling operations.

(8) "Hydrochloric acid pickling" means operations in which steel products are immersed in hydrochloric acid solutions to chemically remove oxides and scale and the associated rinsing operations.

(9) "Neutralization" means acid pickling operations that do not include acid recovery or acid regeneration.

(10) "Pipe, tube, and other" means acid pickling operations that pickle pipes, tubes, or any steel product other than a rod, wire, coil, bar, billet, bloom, strip, sheet, or plate.

(11) "Rod, wire, and coil" means acid pickling operations that pickle rod, wire, or coiled rod and wire products.

(12) "Spent acid solution" means solutions of steel pickling acids which have been used in the pickling process and are discharged or removed.

(13) "Strip, sheet, and plate" means acid pickling operations that pickle strip, sheet, or plate products.

(14) "Sulfuric acid pickling" means operations in which steel products are immersed in sulfuric acid solutions to chemically remove oxides and scale and the associated rinsing operations. History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.092 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any

existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

Table 81
Rod, Wire, and Coil Sulfuric Acid Pickling
BPT Effluent Limitations

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pound of product	
TSS	0.0818	0.0350
O&G(1)	0.0350	0.0117
Lead	0.000526	0.000175
Zinc	0.000701	0.000234
рН	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Table 82
Bar, Billet, and Bloom Sulfuric Acid Pickling

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pound of product	
TSS	0.0263	0.0113
O&G(1)	0.0113	0.0375
Lead	0.000169	0.0000563
Zinc	0.000225	0.0000751
pH	(2)	(2)

(2) Within the range of 6.0 to 9.0

Table 83
Strip, Sheet, and Plate Sulfuric Acid Pickling
buip, blicet, and I late build i feld I felding

BPT H	Effluent Limitations	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.0526	0.0225
O&G(1)	0.0225	0.00751
Lead	0.000338	0.000113
Zinc	0.000451	0.000150
рН	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Table 84	
Pipe, Tube, and Other Products Sulfuric Acid Pickling	
BPT Effluent Limitations	

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pound of product	
TSS	0.146	0.0626
O&G(1)	0.0626	0.0209
Lead	0.000939	0.000313
Zinc	0.00125	0.000417
pН	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters. (2) Within the range of 6.0 to 9.0

Table 85
Sulfuric Acid Pickling Fume Scrubbers
BPT Effluent L imitations

BP1 Ennient Limitations		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		
TSS	5.72	2.45
O&G(1)	2.45	0.819
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
pН	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

(2) Within the range of 6.0 to 9.0

Table 86	
Rod, Wire, and Coil Hydrochloric Acid Pickling	
BDT Effluent 1 imitations	

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pound of product	
TSS	0.143	0.0613
O&G(1)	0.0613	0.0204
Lead	0.000920	0.000307
Zinc	0.00123	0.000409
pН	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

(2) Within the range of 6.0 to 9.0

-

Strip, Sheet, and P	Table 87 late Hydrochloric /	Acid Pickling
BPT I	Effluent Limitations	5
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.0818	0.0350
O&G(1)	0.0350	0.0117
Lead	0.000526	0.000175
Zinc	0.000701	0.000234
pH	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Table 88
Pipe, Tube, and Other Products Hydrochloric Acid Pickling

BPT I	3ffluent Limitations	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.298	0.128
O&G(1)	0.128	0.0426
Lead	0.00192	0.000638
Zinc	0.00255	0.000851
рН	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Hydrochloric A	Table 89 cid Pickling Fume	Scrubbers
BPT I	Effluent Limitations	š
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for ea	ach fume scrubber
TSS	5.72	2.45
O&G(1)	2.45	0.819
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
pH	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

	ent Scrubber Waste chloric Acid Regen	· · · · ·
BPT I	Iffluent Limitations	}
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant	In man days for a	ah fuma samihhar
property		ich fume scrubber
TSS	38.2	16.3
O&G(1)	16.3	5.45
Lead	0.245	0.0819
Zinc	0.327	0.109
pH	(2)	(2)
	wastewaters.	cid Pickling
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds) of pr	per 1,000 pounds) oduct
TSS	0.149	0.0638
O&G(1)	0.0638	0.0213
Chromium	0.00213	0.000852
Nickel	0.00192	0.000638
рН	(2)	(2)
 The limitation for O&G interacted with cold rolling (2) Within the sange of 6.0 to 1 	wastewaters,	pickling wastewaters are

Table 90

Table 92
Bar, Billet, and Bloom Combination Acid Pickling
BPT Effluent Limitations

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0672	0.0288
O&G(1)	0.0288	0.00960
Chromium	0.000960	0.000384
Nickel	0.000864	0.000288
pH	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

	Table 93 et, and Plate Contin nation Acid Picklin	
BPT I	Effluent Limitations	8
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.438	0.188
O&G(1)	0.188	0.0626
Chromium	0.00626	0.00250
Nickel	0.00563	0.00188
рH	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 (2) Within the range of 6.0 to 9.0

Table 94

Strip, Sheet, and Plate Batch Combination Acid Pickling
BPT Effluent Limitations

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.134	0.0576
• O&G(1)	0.0576	0.0192
Chromium	0.00192	0.000768
Nickel	0.00173	0.000576
pН	(2)	(2)

 The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Table	95
1000	11

BPT F	Iffluent Limitations	6
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 poun of product	
TSS	0.225	0.0964
O&G(1)	0.0964	0.0322
Chromium	0.00322	0.00129
Nickel	0.00289	0.000964
рН	(2)	(2)

 The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Combination A	Table 96 cid Pickling Fume	Scrubbers
BPT E	ffluent Limitations	1
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for ea	ich fume scrubber
TSS	5.72	2.45
O&G(1)	2.45	0.819
Chromium	0.0819	0.0327

pH (2) (2) (1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

0.0735

(2) Within the range of 6.0 to 9.0

Nickel

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.093 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BAT:

Table 97
Rod, Wire, and Coil Sulfuric Acid Pickling
D 100 2000 1 1 1 1

BAT E	Effluent Limitations	5
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Lead	0.000526	0.000175
Zinc	0.000701	0.000234
	Table 98 Bloom Sulfuric Aci Effluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Lead	0.000169	0.0000563
2000	0.000102	0.0000000

Strip, Sheet, and	Table 99 I Plate Sulfuric Aci	d Pickling
	Effluent Limitations	
~		Average of
		daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or pollutant property	kg/kkg (pounds)	per 1,000 pounds) oduct
Lead	0.000338	0.000113
Zinc	0.000451	0.000150
Pipe, Tube, and Othe	Table 100	· · · · ·
	Effluent Limitations	
	*	Average of
	Maximum for any 1 day	daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds)	per 1,000 pounds) oduct
Lead	0.000939	0,000313
Zinc	0.00125	0.000417
	Table 101 I Pickling Fume Sc	
BATE	Effluent Limitations	à
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
Rod, Wire, and C	Table 102 oil Hydrochloric A Effluent Limitations	cid Pickling
DAII	Sinucia Limitation:	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or		per 1,000 pounds)
pollutant property		oduct
Lead	0.000920	0.000307
Zinc	0.00123	0.000409
	Table 103 late Hydrochloric A	
DUI 1	sincent isomation:	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pound pounds) of	
Lead	0.000526	0.000175
Zinc	0.000701	0.000234

Pipe, Tube, and Other I BAT I	Effluent Limitations	
		Average of
		daily values for
	Maximum for	30 consecutiv
	any 1 day	days
Pollutant or pollutant property	kg/kkg (pounds p of pr	per 1,000 pound: oduct
Lead	0.00192	0.000638
Zinc	0.00255	0.000851
Hydrochloric A	Table 105 cid Pickling Fume	Scrubbers
	Effluent Limitations	
		Average of
		daily values for
	Maximum for	30 consecutiv
	any 1 day	days
Pollutant or pollutant	:	.1.6
property	kg per day for ea	
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
	Table 106 ent Scrubber Waste chloric Acid Regen	
•	Effluent Limitations	
		Average of
		daily values for
	Maximum for	30 consecutiv
	any 1 day	days
Pollutant or pollutant		
property	kg per day for ea	ch fume scrubbe
Lead	0.245	0.0819
Zinc	0.327	0.109
	Table 107	
	oil Combination Ac	
BATI	Effluent Limitations	•
		Average of
	Maximum for	daily values for 30 consecutiv
	any 1 day	days
Pollutant or pollutant	kg/kkg (pounds j	· · ·
property	verve (houngs h	see 19000 Found
	of pr	oduct
Chromium	0.00213	oduct 0.000852
Chromium	0.00213 0.00192	0.000852
Chromium Nickel	0.00213 0.00192 Table 108	0.000852 0.000638
Chromium Nickel Bar, Billet, and Ble	0.00213 0.00192 Table 108 com Combination A	0.000852 0.000638 Acid Pickling
Chromium Nickel Bar, Billet, and Ble	0.00213 0.00192 Table 108	0.000852 0.000638 Acid Pickling
Chromium Nickel Bar, Billet, and Ble	0.00213 0.00192 Table 108 com Combination A	0.000852 0.000638 Acid Pickling
Chromium Nickel Bar, Billet, and Ble	0.00213 0.00192 Table 108 com Combination A	0.000852 0.000638 Acid Pickling Average of daily values fo
Chromium Nickel Bar, Billet, and Bla	0.00213 0.00192 Table 108 com Combination A Stifluent Limitations Maximum for	0.000852 0.000638 Acid Pickling Average of daily values fo 30 consecutiv
Chromium Nickel Bar, Billet, and Bl BAT I	0.00213 0.00192 Table 108 com Combination A Stifluent Limitations Maximum for any 1 day	0.000852 0.000638 Acid Pickling Average of daily values fo 30 consecutiv days
Chromium Nickel Bar, Billet, and Bla BAT I Pollutant or	0.00213 0.00192 Table 108 com Combination A Effluent Limitations Maximum for any 1 day kg/kkg (pounds)	0.000852 0.000638 Acid Pickling Average of daily values for 30 consecutiv days per 1,000 pound
Chromium Nickel Bar, Billet, and Bl BAT I Pollutant or pollutant property	0.00213 0.00192 Table 108 com Combination A Stifluent Limitations Maximum for any 1 day kg/kkg (pounds p of pr	0.000852 0.000638 Acid Pickling Average of daily values for 30 consecutiv days per 1,000 pound oduct
Chromium Nickel Bar, Billet, and Bla BAT I Pollutant or	0.00213 0.00192 Table 108 com Combination A Effluent Limitations Maximum for any 1 day kg/kkg (pounds)	0.000852 0.000638 Acid Pickling Average of daily values for 30 consecutiv days per 1,000 pound

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Strip, Sheet, and	Table 109 Plate Continuous C	ombination			
- -	Acid Pickling				
BAT E	Effluent Limitations				
-	Maximum for any 1 day	Average of daily values for 30 consecutive days			
Pollutant or pollutant property		per 1,000 pounds) oduct			
Chromium	0.00626	0.00250			
Nickel	0.00563	0.00188			
Strip, Sheet, and Plate	Table 110 Batch Combinatio	n Acid Pickling			
BATT	Effluent Limitations				
	Maximum for any 1 day	Average of daily values for 30 consecutive days			
Pollutant or pollutant kg/kkg (pounds per 1,000 pounds) property of product					
Chromium	0.00192	0.000768			
Nickel	0.00173	0.000576			
Pipe, Tube, and Other 1 BAT I	Table 111 Products Combinati	ion Acid Pickling			
		Average of			
	Maximum for any 1 day	daily values for 30 consecutive days			
Pollutant or pollutant property	Pollutant or pollutant kg/kkg (pounds per 1,000 pounds)				
Chromium	0.00322	0.00129			
Nickel	0.00289	0.000964			
	Table 112 cid Pickling Fume				
BAT J	Effluent Limitations				
	Maximum for any 1 day	Average of daily values for 30 consecutive days			
Pollutant or pollutant property	kg per day for ea	ach fume scrubber			
Chromium	0.0819	0.0327			
Nickel	0.0735	0.0245			
History: Cr. Register, May, 1	989, No. 401, eff. 6-1-8	39.			

NR 254.094 New source performance standards. The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the following standards:

		Average of
		daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or pollutant		per 1,000 pounds)
property	of pr	oduct
TSS	0.0146	0.00626
O&G(1)	0.00626	0.00209
Lead	0.0000939	0.0000313
Zinc	0.000125	0.0000417
pН	(2)	(2)
 (1) The limitation for O&G i treated with cold rolling v (2) Within the range of 6.0 to 9 	wastewaters. 9.0 Table 114	
Bar, Billet, and I	Bloom Sulfuric Aci	id Pickling
	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds of pi	per 1,000 pounds) roduct
TSS	0.00876	0.00376
O&G(1)	0.00376	0.00125
Lead	0.0000563	0.0000188
Zinc	0.0000751	0.0000250
pH	(2)	(2)

Table 113 Rod, Wire, and Coil Hydrochloric Acid Pickling NSPS

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

(2) Wit	hin the ran	ge of 6.0	to 9.0
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Table 115
Strip, Sheet, and Plate Sulfuric Acid Pickling
NODO

	noro	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pour of product	
TSS	0.0117	0.00501
O&G(1)	0.00501	0.00167
Lead	0.0000751	0.0000250
Zinc	0.000100	0.0000334
pН	(2)	(2)

(I) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 (2) Within the range of 6.0 to 9.0

Pipe, Tube, and Othe	Table 116 r Products Sulfuri	Acid Dickling	
	NSPS		
	Maximum for any 1 day	Average of daily values for 30 consecutive days	
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product		
TSS	0.0204	0.00876	
O&G(1)	0.00876	0.00292	
Lead	0.000131	0.0000438	
Zinc	0.000175	0.0000584	
pН	(2)	(2)	
 The limitation for O&G i treated with cold rolling Within the range of 6.0 to 	wastewaters,	pickling wastewaters are	
Sulfuric Acid	Table 117 Pickling Fume Sc	rubbers	
· · · ·	NSPS	· · · · ·	
	Maximum for any 1 day	Average of daily values for 30 consecutive days	
Pollutant or pollutant	1 1 7	1.0	
property		ich fume scrubber	
TSS	5.72	2.45	
O&G(1)	2.45	0.819	
Lead	0.0368	0.0123	
Zinc	0.0491	0.0164	
pH (1) The limitation for O&G i treated with cold rolling y (2) Within the range of 6.0 to 9	wastewaters.	(2) pickling wastewaters are	
Rod, Wire, and Co	Table 118 oil Hydrochloric A	cid Pickling	
	NSPS		
	Maximum for any 1 day	Average of daily values for 30 consecutive days	
Pollutant or pollutant property	kg/kkg (pounds)	per 1,000 pounds) oduct	
TSS	0.0175	0.00751	
O&G(1)	0.00751	0.00250	
T 1	0.000440	~ ~ ~ ~ ~ ~ ~ ~	

Table 116
Pipe, Tube, and Other Products Sulfuric Acid Pickling

Strip, Sheet, and Plate Hydrochloric Acid Pickling NSPS Average of daily values for 30 consecutive Maximum for any 1 day days kg/kkg (pounds per 1,000 pounds) of product Pollutant or pollutant property TSS 0.0117 0.00501 O&G(1) 0.00501 0.00167 0.0000751 0.0000250 Lead Zinc 0.000100 0.0000334 pН (2)(2)

Table 119

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Table 120

Pipe, Tube, and Other Products Hydrochloric Acid Pickling NSPS

	Maximum for any I day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0321	0.0138
O&G(1)	0.0138	0.00459
Lead	0.000206	0.0000688
Zinc	0.000275	0.0000918
pН	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

			Table 121
		-	

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.0175	0.00751
O&G(1)	0.00751	0.00250
Lead	0.000113	0.0000376
Zinc	0.000150	0.0000501
рН	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Hydrochloric Acid Pickling Fume Scrubbers MCDC

Noro	
Maximum for any 1 day	Average of daily values for 30 consecutive days
kg per day for ea	ach fume scrubber
5.72	2.45
2.45	0.819
0.0368	0.0123
0.0491	0.0164
(2)	(2)
	Maximum for any 1 day kg per day for ea 5.72 2.45 0.0368 0.0491

(1) The limitation for O&G is applicable when acid pickling wastewaters are (1) The initiation for odd is appreaded treated with cold rolling wastewaters.(2) Within the range of 6.0 to 9.0

Table 122
Rod, Wire, and Coil Combination Acid Pickling
a a de seu de

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0204	0.00876
O&G(1)	0.00876	0.00292
Chromium	0.000292	0.000117
Nickel	0,000263	0.0000876
pН	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Bar, Billet, and Bl	Table 123 oom Combination A	Acid Pickling
· · · · · · · · · · · · · · · · · · ·	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0117	0.00501
O&G(1)	0.00501	0.00167
Chromium	0.000167	0.0000667
Nickel	0.000150	0.0000501
pH (1) The limitation for O&G	(2)	(2)

(2) The annuality for Occo is applicable treated with cold rolling wastewaters.(2) Within the range of 6.0 to 9.0

Table 124
Strip, Sheet, and Plate Continuous Combination
Acid Pickling

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds of p	per 1,000 pounds) roduct
TSS	0.0496	0.0213
O&G(1)	0.0213	0.00710
Chromium	0.000710	0.000284
Nickel	0.000638	0.000213
pH	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 (2) Within the range of 6.0 to 9.0

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Table 125 Strip, Sheet, and Plate Batch Combination Acid Pickling MODO

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0175	0.00751
O&G(1)	0.00751	0.00250
Chromium	0.000250	0.000100
Nickel	0.000225	0.0000751
pH	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 (2) Within the range of 6.0 to 9.0

Table 126

Pipe,	Tube,	and	Other Products Combination	Acid Pickling	_
			NSPS		

	1101.0	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0292	0.0125
O&G(1)	0.0125	0.00418
Chromium	0.000418	0.000167
Nickel	0.000376	0.000125
pН	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 (2) Within the range of 6.0 to 9.0

Table 127
Combination Acid Pickling Fume Scrubbers
NODO

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for e	ach fume scrubber
TSS	5.72	2.45
O&G(1)	2.45	0.819
Chromium	0.0819	0.0327
Nickel	0.0735	0.0245
pH	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
(2) Within the range of 6.0 to 9.0
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

NR 254.095 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the limitations set forth in s. NR 254.093.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.096 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSNS:

	Table 128	
Rod, Wire, an	d Coil Sulfuric Acid PSNS	Pickling
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds j	per 1,000 pounds) oduct
Lead	0.0000939	0.0000313
Zinc	0.000125	0.0000417
Bar, Billet, and	Table 129 Bloom Sulfuric Aci	id Pickling
	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
Lead	0.0000563	0.0000188
Zinc	0.0000751	0.0000250
	m 11 100	
Strip, Sheet, an	Table 130 d Plate Sulfuric Aci PSNS	d Pickling
Strip, Sheet, an	d Plate Sulfuric Aci PSNS Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	d Plate Sulfuric Aci PSNS Maximum for any 1 day kg/kkg (pounds 1	Average of daily values for 30 consecutive days
Pollutant or pollutant property Lead	d Plate Sulfuric Aci PSNS Maximum for any 1 day kg/kkg (pounds p of pr 0.0000751	Average of daily values for 30 consecutive days per 1,000 pounds)
Pollutant or pollutant property	d Plate Sulfuric Aci PSNS Maximum for any 1 day kg/kkg (pounds p of pr	Average of daily values for 30 consecutive days per 1,000 pounds) oduct
Pollutant or pollutant property Lead Zinc	d Plate Sulfuric Aci PSNS Maximum for any 1 day kg/kkg (pounds p of pr 0.0000751	Average of daily values for 30 consecutive days per 1,000 pounds) oduct 0.0000250 0.0000334
Pollutant or pollutant property Lead Zinc	d Plate Sulfuric Aci PSNS Maximum for any 1 day kg/kkg (pounds p of pr 0.0000751 0.000100 Table 131 ter Products Sulfuric PSNS Maximum for any 1 day	Average of daily values for 30 consecutive days per 1,000 pounds) oduct 0.0000250 0.0000334 e Acid Pickling Average of daily values for 30 consecutive days
Pollutant or pollutant property Lead Zinc	d Plate Sulfuric Aci PSNS Maximum for any 1 day kg/kkg (pounds p of pr 0.0000751 0.000100 Table 131 ter Products Sulfuric PSNS Maximum for any 1 day kg/kkg (pounds p	Average of daily values for 30 consecutive days per 1,000 pounds) oduct 0.0000250 0.0000334 e Acid Pickling Average of daily values for 30 consecutive
Pollutant or pollutant property Lead Zine Pipe, Tube, and Oth Pollutant or	d Plate Sulfuric Aci PSNS Maximum for any 1 day kg/kkg (pounds p of pr 0.0000751 0.000100 Table 131 ter Products Sulfuric PSNS Maximum for any 1 day kg/kkg (pounds p	Average of daily values for 30 consecutive days per 1,000 pounds) oduct 0.0000250 0.0000334 e Acid Pickling Average of daily values for 30 consecutive days per 1,000 pounds)

Sulfurie Acie	Table 132 I Pickling Fume Sc	rubbers
	PSNS	1005013
	6/101	Auguage of
		Average of daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or pollutant property		ach fume scrubber
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
	Table 133 oil Hydrochloric A	
	PSNS	····
		Average of daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or		per 1,000 pounds)
pollutant property		oduct
Lead	0.000113	0.0000376
Zinc	0.000150	0.0000501
Line		0.0000001
Strip, Sheet, and P	Table 134 late Hydrochloric A PSNS	Acid Pickling
· · · · · · · · · · · · · · · · · · ·	Pono	
		Average of daily values for 30
	Maximum for	consecutive
	any I day	days
Pollutant or pollutant property	of pr	per 1,000 pounds) oduct
Lead	0.0000751	0.0000250
Zinc	0.000100	0.0000334
Pipe, Tube, and Other I	Table 135 Products Hydrochle PSNS	oric Acid Pickling
•	1 0110	Average of
		daily values for
	Maximum for	30 consecutive
	any i day	days
Pollutant or		per 1,000 pounds)
pollutant property		oduct
Lead	0.000206	0.0000688
Zinc	0.000275	0.0000918
Zinç	0.000275	0,000910
Hydrochloric A	Table 136 cid Pickling Fume	Scrubbers
	PSNS	
	Maximum for any 1 day	Average of daily values for
		30 consecutive days
Pollutant or pollutant	ka per day for er	ich fume scrubber
property		
Lead	0.0368	0.0123
Zinc	0.0491	0.0164

0.000292 0.000263 Table 138 om Combination A PSNS Maximum for any 1 day	oduct 0.000117 0.0000876
any 1 day kg/kkg (pounds p of pr 0.000292 0.000263 Table 138 om Combination A PSNS Maximum for any 1 day	daily values for 30 consecutive days oer 1,000 pounds) oduct 0,000117 0,0000876 Acid Pickling Average of daily values for 30 consecutive
any 1 day kg/kkg (pounds p of pr 0.000292 0.000263 Table 138 om Combination A PSNS Maximum for any 1 day	30 consecutive days per 1,000 pounds) oduct 0,000117 0,0000876 Acid Pickling Average of daily values for 30 consecutive
any 1 day kg/kkg (pounds p of pr 0.000292 0.000263 Table 138 om Combination A PSNS Maximum for any 1 day	days ber 1,000 pounds) oduct 0,000117 0.0000876 Acid Pickling Average of daily values for 30 consecutive
kg/kkg (pounds p of pr 0.000292 0.000263 Table 138 om Combination A PSNS Maximum for any 1 day	er 1,000 pounds) oduct 0,000117 0.0000876 Acid Pickling Average of daily values for 30 consecutive
of pr 0.000292 0.000263 Table 138 om Combination A PSNS Maximum for any 1 day	oduct 0.000117 0.0000876 Acid Pickling Average of daily values for 30 consecutive
0.000263 Table 138 om Combination A PSNS Maximum for any 1 day	0.0000876 Acid Pickling Average of daily values for 30 consecutive
Table 138 om Combination A PSNS Maximum for any 1 day	Acid Pickling Average of daily values for 30 consecutive
om Combination A PSNS Maximum for any 1 day	Average of daily values for 30 consecutive
Maximum for any 1 day	daily values for 30 consecutive
any 1 day	daily values for 30 consecutive
	daily values for 30 consecutive
kalkka (nounda-	
kalkka (nounda)	davs
kalkka (nounda -	2
- verver (bounds t	er 1,000 pounds
of pr	oduct
0.000167	0.0000667
0.000150	0.0000501
Table 130	
Plate Continuous C Acid Pickling	ombination
PSNS	
	Average of
	daily values for
	30 consecutive
	· days
	per 1,000 pounds oduct
0.000710	0.000284
0.000638	0.000213
Table 140	
	n Acid Pickling
	a rivia i loting
סחסז	A
	Average of daily values fo
Maximum for	30 consecutive
	days
ka/kka (nounde)	
of pr	oduct
	0.000100
	0.0000751
0.000223	0.000751
Table 141	
	ion Acid Pickling
PSNS	
	Average of daily values fo
Maximum for	30 consecutive
	days
	oduct
-	0.000167
	0.000125
	0.000150 Table 139 Plate Continuous C Acid Pickling PSNS Maximum for any 1 day kg/kkg (pounds p of pr 0.000710 0.000638 Table 140 Batch Combinatio PSNS Maximum for any 1 day kg/kkg (pounds p of pr 0.000250 0.000225 Table 141 Products Combinati PSNS Maximum for any 1 day kg/kkg (pounds p

	Table 142	
Combination A	cid Pickling Fume	Scrubbers
	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for ea	ach fume scrubber
Chromium	0.0819	0.0327
Nickel	0.0735	0.0245
History: Cr. Register, May, 1	989, No. 401, eff. 6-1-8	19.

NR 254.097 Effluent limitations representing the degree of effluent reduction attainable by the applica-tion of the best conventional pollutant control technol-ogy. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BCT:

Table 143

Rod, Wire, and	d Coil Sulfuric Acid	ł Pickling
BCT	Effluent Limitation:	S
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.0819	0.0350
O&G(1)	0.0350	0.0117
pH	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

	Table 144
	1000
•	Bar, Billet, and Bloom Sulfuric Acid Pickling
	BCT Effluent Limitations

	Maximum for	Average of daily values for 30 consecutive
Pollutant or pollutant property		days per 1,000 pounds) roduct
TSS	0.0263	0.0113
O&G(1)	0.0113	0.00376
pH	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Strip, Sheet, an BCT	Effluent Limitations	
		Average of
		daily values for
	Maximum for	30 consecutive
,	any 1 day	days
Pollutant or	kg/kkg (pounds)	per 1,000 pounds)
pollutant property	of pr	oduct
TSS	0.0526	0.0225
O&G(1)	0.0225	0.00751
pН	(2)	(2)
(1) The limitation for O&G	is applicable when acid	pickling wastewaters a
treated with cold rolling (2) Within the range of 6.0 to		
(2) mann me fange et e.e k		
Dina Taba and Oth	Table 146 her Products Sulfurio	A aid Diakling
וטמ	Effluent Limitations	
		Average of daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or		per 1,000 pounds)
pollutant property		oduct
TSS	0.146	0.0626
O&G(1)	0.0626	0.0209
pH	(2)	(2)
 The limitation for O&G treated with cold rolling Within the range of 6.0 to 	wastewaters. 9.0	pickling wastewaters a
Sulfania Ani	Table 147	
	d Pickling Fume Sc Effluent Limitations	
DC1		
		Average of daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or pollutant		ch fume scrubber
property	01 1	
TSS	5,72	2.45
O&G(1)	2.45	0.819
nH	(2)	121
pH (1) The limitation for O&G	(2) is applicable when acid	(2) pickling wastewaters a
(1) The limitation for O&G treated with cold rolling	is applicable when acid wastewaters. 9.0	
 The limitation for O&G treated with cold rolling Within the range of 6.0 to 	is applicable when acid wastewaters. 9.0 Table 148	pickling wastewaters a
 The limitation for O&G treated with cold rolling Within the range of 6.0 to Rod, Wire, and 0 	is applicable when acid wastewaters. 9.0 Table 148 Coil Hydrochloric A	pickling wastewaters a
 The limitation for O&G treated with cold rolling Within the range of 6.0 to Rod, Wire, and 0 	is applicable when acid wastewaters. 9.0 Table 148 Coil Hydrochloric A Effluent Limitations	pickling wastewaters a cid Pickling
 The limitation for O&G treated with cold rolling Within the range of 6.0 to Rod, Wire, and 0 	is applicable when acid wastewaters. 9.0 Table 148 Coil Hydrochloric A Effluent Limitations Maximum for	pickling wastewaters a cid Pickling Average of
 The limitation for O&G treated with cold rolling Within the range of 6.0 to Rod, Wire, and 0 	is applicable when acid wastewaters. 9.0 Table 148 Coil Hydrochloric A Effluent Limitations	pickling wastewaters a cid Pickling Average of daily values for
 The limitation for O&G treated with cold rolling (2) Within the range of 6.0 to Rod, Wire, and (BCT 	is applicable when acid wastewaters. 9.0 Table 148 Coil Hydrochloric A Effluent Limitations Maximum for any 1 day	cid Pickling cid Pickling Average of daily values for 30 consecutive days
 The limitation for O&G treated with cold rolling Within the range of 6.0 to Rod, Wire, and 0 	is applicable when acid wastewaters. 9.0 Table 148 Coil Hydrochloric A Effluent Limitations Maximum for any 1 day kg/kkg (pounds)	cid Pickling cid Pickling Average of daily values for 30 consecutive
(1) The limitation for O&G treated with cold rolling (2) Within the range of 6.0 to Rod, Wire, and C BCT Pollutant or	is applicable when acid wastewaters. 9.0 Table 148 Coil Hydrochloric A Effluent Limitations Maximum for any 1 day kg/kkg (pounds)	cid Pickling cid Pickling Average of daily values for 30 consecutive days per 1,000 pounds)
(1) The limitation for O&G treated with cold rolling (2) Within the range of 6.0 to Rod, Wire, and C BCT Pollutant or pollutant property	is applicable when acid wastewaters. 9.0 Table 148 Coil Hydrochloric A Effluent Limitations Maximum for any 1 day kg/kkg (pounds) of pr	cid Pickling Average of daily values for 30 consecutive days per 1,000 pounds) oduct

pН (2)(2)The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters,
 Within the range of 6.0 to 9.0

Strip, Sheet, and	Table 149 Plate Hydrochloric A	cid Pickling		
BCI	BCT Effluent Limitations			
		Average of daily values for		
	Maximum for	30 consecutive		
	any 1 day	days		
Pollutant or	kg/kkg (pounds)	per 1,000 pounds)		

pollutant property		
TSS	0.0819	0.0350
O&G(1)	0.0350	0.0117
рH	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 (2) Within the range of 6.0 to 9.0

Pipe, Tube, and Other Products Hydrochloric Acid Pickling **BCT Effluent Limitations**

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.298	0.128
O&G(1)	0.128	0.0426
pH	(2)	(2)

The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Table 151

14010 151	
Hydrochloric Acid Pickling Fume Scrubbers	
BCT Effluent Limitations	-

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for ea	ach fume scrubber
TSS	5.72	2.45
O&G(1)	2.45	0.819
Ha	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 (2) Within the range of 6.0 to 9.0

Absorber Ve From Hydrod	Table 152 ent Scrubber Waste chloric Acid Regen	water
BCT E	ffluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant		
property		ch fume scrubber
TSS	38.2	16.3
O&G(1)	16.3	5.45
pН	(2)	(2)
 The limitation for O&G i treated with cold rolling v Within the range of 6.0 to 9 	vastowaters.	picking wastewaters at
	Table 153 oil Combination Ad	-
BCT E	Iffluent Limitations	۱
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds) of pr	per 1,000 pounds) oduct
TSS	0.149	0.0638
O&G(1)	0.0638	0.0213
pH	(2)	(2)
 (1) The limitation for O&G i treated with cold rolling v (2) Within the range of 6.0 to 9 	wastewaters.	pickling wastewaters an
Bar, Billet, and Blo		-
BCT H	Effluent Limitations	\$
•	Maximum for	Average of daily values for 30 consecutive

	Maximum for any 1 day	30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0672	0.0288
O&G(1)	0.0288	0.00960
pH	(2)	(2)

(1) The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

- - -

(2) Within the range of 6.0 to 9.0

Table 155	
Strip, Sheet, and Plate Continuous Combinatio	n
Acid Pickling	

BCT	Effluent Limitation	S
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pour of product	
TSS	0.438	0.188
O&G(1)	0.188	0.0626
pН	(2)	(2)

 The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

(2) Within the range of 6.0 to 9.0

Table 156
Strip, Sheet, and Plate Batch Combination Acid Pickling
BCT Effluent Limitations

BCLI	Effluent Limitation:	S
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.134	0.0576
O&G(1)	0.0576	0.0192
pН	(2)	(2)
 The limitation for O&G treated with cold rolling Within the range of 6.0 to 	wastewaters.	[
Pipe, Tube, and Other	Table 157	ion Acid Pickling
	Table 157	
	Table 157 Products Combinat	
	Table 157 Products Combinat Effluent Limitation Maximum for any 1 day kg/kkg (pounds	s Average of daily values for 30 consecutive
BCT I Pollutant or	Table 157 Products Combinat Effluent Limitation Maximum for any 1 day kg/kkg (pounds	s Average of daily values for 30 consecutive days per 1,000 pounds)
BCT Pollutant or pollutant property	Table 157 Products Combinat Effluent Limitation Maximum for any 1 day kg/kkg (pounds of pi	s Average of daily values for 30 consecutive days per 1,000 pounds) roduct

 The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.
 Within the range of 6.0 to 9.0

Table 158 Combination Acid Pickling Furne Scrubbers

BCL	Effluent Limitation:	8
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for ea	ach fume scrubber
TSS	5.72	2.45
O&G(1)	2.45	0.819
pH	(2)	(2)

 The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

(2) Within the range of 6.0 to 9.0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Subchapter X — Cold Forming Subcategory

NR 254.10 Applicability; description of the cold forming subcategory. (1) This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from cold rolling and cold working pipe and tube operations in which unheated steel is passed through rolls or otherwise processed to reduce its thickness, to produce a smooth surface, or to develop controlled mechanical properties in the steel.

(2) The limitations and standards set forth in ss. NR 254.102 to 254.107 for cold worked pipe and tube operations shall be applicable only when cold worked pipe and tube wastewaters are discharged at steel plant sites. No limitations are applicable or allowable when these wastewaters are hauled off-site for disposal or are otherwise not discharged at steel plant sites. The limitations and standards set forth in ss. NR 254.102 to 254.107 for cold

worked pipe and tube operations shall be applicable only to the blowdown of soluble oil or water solutions used in cold worked pipe and tube forming operations. Limitations for other wastewater sources from these operations shall be established on a site specific basis.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.101 Specialized definitions. The following definitions are applicable to the terms used in this subchapter:

(1) "Cold worked pipe and tube" means cold forming operations which process unheated pipe and tube products using either water or oil solutions for cooling and lubrication.

(2) "Combination" means cold rolling operations which include recirculation of rolling solutions at one or more mill stands and once through use of rolling solutions at the remaining mill stands.

(3) "Direct application" means cold rolling operations which include once through use of rolling solutions at mill stands.

(4) "Multiple stand" means recirculation or direct application cold rolling mills which include more than one stand of work rolls.

(5) "Recirculation" means cold rolling operations which include recirculation of rolling solutions at all mill stands.

(6) "Single stand" means recirculation or direct application cold rolling mills which include only one stand of work rolls. History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.102 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

m 11 180

	Table 159	
Single Stand Rec	circulation Cold Ro	olling Mills
BPT E	Effluent Limitations	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.00125	0.000626
O&G	0.000522	0,000209
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.000063
Zinc	0.0000063	0.0000021
Naphthalene	0.0000021	
Tetrachloroethylene	0.0000031	
pH (1) The limitations for chromiu	(2)	(2)

The limitations for chromium and nickel are applicable in lieu of those for lead and zine when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.
 Within the range of 6.0 to 9.0

Table 160 Multiple Stand Recirculation Cold Rolling Mills **BPT Effluent Limitations**

prid	Allacin Management	•
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or	kg/kkg (pounds)	per 1,000 pounds)
pollutant property	of pr	oduct
TSS	0.00626	0.00313
O&G	0.00261	0.00104
Chromium(1)	0.000104	0.0000418
Lead	0.0000469	0.0000156
Nickel(1)	0.0000939	0.0000313
Zinc	0.0000313	0.0000104
Naphthalene	0.0000104	
Tetrachloroethylene	0.0000156	
pH	(2)	(2)

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zine when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters. (2) Within the range of 6.0 to 9.0

Table 161 Combination Cold Rolling Mills **BPT Effluent Limitations**

		Average of daily values for
	Maximum for any 1 day	30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.0751	0.0376
0&G	0.0313	0.0125
Chromium(1)	0.00125	0.000501
Lead	0.000563	0.000188
Nickel(1)	0.00113	0.000376
Zinc	0.000376	0.000125
Naphthalene	0.000125	
Tetrachloroethylene	0.000188	
pH	(2)	(2)

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zine when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters. (2) Within the range of 6.0 to 9.0

Table 162 Single Stand Direct Application Cold Rolling Mills **BPT Effluent Limitations** Average of daily values for Maximum for 30 consecutive days any 1 day Pollutant or kg/kkg (pounds per 1,000 pounds) pollutant property of product TSS 0.0225 0.0113 0&G 0.00939 0.00376 Chromium(1) 0.000376 0.000150 0.0000563 Lead 0.000169 Nickel(1) 0.000338 0.000113 0.000113 0.0000376 Zinc 0.0000376 Naphthalene Tetrachloroethylene 0.0000563 pН (2)(2)(1) The limitations for chromium and ickel are applicable in lieu of those for lead and zine when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.
 (2) Within the range of 6,0 to 9,0

Table 163 Multiple Stand Direct Application Cold Rolling Mills **BPT** Effluent Limitation

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.100	0.0501
O&G	0.0417	0.0167
Chromium(1)	0.00167	0.000668
Lead	0.000751	0,000250
Nickel(1)	0.00150	0.000501
Zinc	0.000501	0.000167
Naphthalene	0.000167	
Tetrachloroethylene	0.000250	
pH	(2)	(2)

The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.
 Within the range of 6.0 to 9.0

Table 164 Cold Worked Pipe and Tube Using Water

BPT	Effluent Limitations	3
• •	Maximum for any I day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pound of product	
TSS	0.00125	0.000626
O&G	0.000522	0.000209
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0,0000063	0.0000021
pН	(2)	(2)

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.
 Within the range of 6.0 to 9.0

	Table 165
·	Cold Worked Pipe and Tube Using Oil Solutions
	BPT Effluent L imitations

DELE	mucht Linnauons	i
	Maximum for	Average of daily values for 30 consecutive
	any 1 day	days
Pollutant or	kg/kkg (pounds	per 1,000 pounds)
pollutant property	of pr	oduct
TSS	0.00125	0.000626
O&G	0.000522	0.000209
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021
Naphthalene	0.0000021	4
Tetrachloroethylene	0.0000031	
рН	(2)	. (2)

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.
(2) Within the range of 6.0 to 9.0
History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.103 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BAT:

Single Stand Dee	Table 166	Hine Mille
	irculation Cold Ro ffluent Limitations	
	indone Brinderono	Average of
	Maximum for any 1 day	daily values for 30 consecutive days
Pollutant or	kg/kkg (pounds p	er 1,000 pounds)
pollutant property		oduct
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.000063	0.0000021
Naphthalene	0.0000021	
Tetrachloroethylene	0.0000031	
 The limitations for chromiu and zinc when cold rollin bination acid pickling way 	g wastewaters are treate	ble in lieu of those for lead d with descaling or com-
	Table 167	
	circulation Cold R	
BATE	ffluent Limitations	
		Average of
	Maximum for	daily values for 30 consecutive
	any 1 day	days
Pollutant or		er 1,000 pounds)
pollutant property		oduct
Chromium(1)	0.000104	0.0000418
Lead	0.0000469	0.0000156
Nickel(1)	0.0000939	0.0000313
Zinc	0.0000313	0.0000104
Naphthalene	0.0000104	
Tetrachloroethylene	0.0000156	
 The limitations for chromiu and zinc when cold rollin bination acid pickling wa 	g wastewaters are treate	
	Table 168	
-	ion Cold Rolling M	
BATE	ffluent Limitations	
	Maximum for	Average of daily values for 30 consecutive
D. 11	any 1 day	days
Pollutant or pollutant property	kg/kkg (pounds p	er 1,000 pounds) oduct
Chromium(1)	0,00125	0.000501
Lead	0.000563	0.000188
Nickel(1)		
	0.00113	0.000376
Zinc	0.000376	0.000125
Naphthalene	0.000125	
Tetrachloroethylene	0.000188	

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.

Table 169	
Single Stand Direct Application Cold Rolling Mills	
BAT Effluent Limitations	

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds of product	
Chromium(1)	0.000376	0.000150
Lead	0.000169	0.0000563
Nickel(1)	0.000338	0.000113
Zinc	0.000113	0.0000376
Naphthalene	0.0000376	
Tetrachloroethylene	0,0000563	

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.

Table 170 Multiple Stand Direct Application Cold Rolling Mills **BAT Effluent Limitations**

· · · · · · · · · · · · · · · · · · ·	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
Chromium(1)	0.00167	0.000668
Lead	0.000751	0.000250
Nickel(1)	0.00150	0.000501
Zinc	0.000501	0.000167
Naphthalene	0.000167	
Tetrachloroethylene	0.000250	

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.

Table 171
Cold Worked Pipe and Tube Using Water
BAT Effluent Limitations

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pound of product	
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.

-

Cold Worked Pipe	Table 172 and Tube Using C	Dil Solutions
BAT E	ffluent Limitation	S
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021
Naphthalene	0.0000021	
Tetrachloroethylene	0.0000031	

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zine when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.
 History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

NR 254.104 New source performance standards. The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the following standards:

Single Stand Rec	Table 173 circulation Cold Ro	olling Mills
	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.00125	0.000626
O&G	0.000522	0.000209
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021
Naphthalene	0.0000021	
Tetrachloroethylene	0.0000031	
pH	(2)	(2)

The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.
 Within the range of 6.0 to 9.0

Table 174 Multiple Stand Recirculation Cold Rolling Mills

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or		per 1,000 pounds)
pollutant property	of pr	oduct
TSS	0.00250	0.00125
O&G	0.00104	0.000417
Chromium(1)	0.0000418	0.0000167
Lead	0.0000188	0.0000063
Nickel(1)	0.0000376	0.0000125
Zinc	0.0000125	0.0000042
Naphthalene	0.0000042	
Tetrachloroethylene	0.0000063	
pH	(2)	(2)

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.
 (2) Within the range of 6.0 to 9.0

Table 175 Combination Cold Rolling Mills

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0326	0.0163
O&G	0.0136	0.00543
Chromium(1)	0.000543	0.000217
Lead	0.000244	0,0000814
Nickel(1)	0.000488	0.000163
Zinc	0.000163	0.0000542
Naphthalene	0.0000542	
Tetrachloroethylene	0.0000813	
pH	(2)	(2)

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.
(2) Within the range of 6.0 to 9.0

Pollutant or pollutant property	Maximum for any 1 day	Average of daily values for
	any 1 day	30 consecutive
		days
	kg/kkg (pounds j of pr	per 1,000 pounds) oduct
TSS	0.00626	0.00313
O&G	0.00261	0.00104
Chromium(1)	0.000104	0.0000418
Lead	0.0000469	0.0000156
Nickel(1)	0.0000939	0.0000313
Zinc	0.0000313	0.0000104
Naphthalene	0.0000104	
Tetrachloroethylene	0.0000156	
pH	(2)	(2)
Within the range of 6.0 to	9.0	
2) Within the range of 6.0 to Multiple Stand Dire	Table 177	l Rolling Mills
•	Table 177	Rolling Mills
•	Table 177 ct Application Cold	Average of daily values for
•	Table 177 ct Application Cold NSPS Maximum for	Average of daily values for 30 consecutive
Multiple Stand Dire	Table 177 ct Application Cold NSPS Maximum for any 1 day	Average of daily values for 30 consecutive days
Multiple Stand Dire	Table 177 ct Application Cold NSPS Maximum for any 1 day kg/kkg (pounds	Average of daily values for 30 consecutive days per 1,000 pounds)
Multiple Stand Dire	Table 177 ct Application Cold NSPS Maximum for any 1 day kg/kkg (pounds) of pr	Average of daily values for 30 consecutive days per 1,000 pounds) roduct
Multiple Stand Dire Pollutant or pollutant property TSS	Table 177 ct Application Cold NSPS Maximum for any 1 day kg/kkg (pounds) of pr 0.0726	Average of daily values for 30 consecutive days per 1,000 pounds) oduct 0.0363
Multiple Stand Dire Pollutant or pollutant property TSS O&G	Table 177 ct Application Cold NSPS Maximum for any 1 day kg/kkg (pounds) of pr 0.0726 0.0302	Average of daily values for 30 consecutive days per 1,000 pounds) roduct 0.0363 0.0121
Multiple Stand Dire Pollutant or pollutant property TSS O&G Chromium(1)	Table 177 ct Application Cold NSPS Maximum for any 1 day kg/kkg (pounds) of pr 0.0726 0.0302 0.00121	Average of daily values for 30 consecutive days per 1,000 pounds) oduct 0.0363 0.0121 0.000484
Pollutant or pollutant property TSS O&G Chromium(1) Lead	Table 177 ct Application Cold NSPS Maximum for any 1 day kg/kkg (pounds) of pr 0.0726 0.0302 0.00121 0.000545	Average of daily values for 30 consecutive days per 1,000 pounds) roduct 0.0363 0.0121
Multiple Stand Dire Pollutant or pollutant property TSS O&G Chromium(1)	Table 177 ct Application Cold NSPS Maximum for any 1 day kg/kkg (pounds) of pr 0.0726 0.0302 0.00121 0.000545 0.00109	Average of daily values for 30 consecutive days per 1,000 pounds) oduct 0.0363 0.0121 0.000484 0.000182
Pollutant or pollutant property TSS O&G Chromium(1) Lead Nickel(1)	Table 177 ct Application Cold NSPS Maximum for any 1 day kg/kkg (pounds) of pr 0.0726 0.0302 0.00121 0.000545	Average of daily values for 30 consecutive days per 1,000 pounds) oduct 0.0363 0.0121 0.000484 0.000182 0.000363
•	Table 177 ct Application Cold	

Table 176 Single Stand Direct Application Cold Polling Mills

(2)pН (1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.
 (2) Within the range of 6.0 to 9.0

(2)

Table 178 Cold Worked Pipe and Tube Using Water

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.00125	0.000626
O&G	0.000522	0.000209
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021
pН	(2)	(2)

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.
 (2) Within the range of 6.0 to 9.0

Table 179 Cold Worked Pipe and Tube Using Oil Solutions	
NSPS	

	Noro	
	Maximum for	Average of daily values for 30 consecutive
	any 1 day	days
Pollutant or	kg/kkg (pounds	per 1,000 pounds)
pollutant property	of pi	roduct
TSS	0.00125	0.000626
0&G .	0.000522	0.000209
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021
Naphthalene	0.0000021	-
Tetrachloroethylene	0.0000031	
pH	(2)	. (2)

The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.
 Within the range of 6.0 to 9.0 History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.105 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the limitations set forth in s. NR 254.103.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.106 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSNS:

	PSNS	lling Mills
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds	per 1,000 pounds) oduct
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021
Naphthalene	0.0000021	
Tetrachloroethylene	0.0000031	
 The limitations for chromiu and zinc when cold rollin bination acid pickling wa 	ig wastewaters are treate	
Multiple Stand Re	Table 181 circulation Cold R	olling Mills
	PSNS	
		Average of daily values for
	Maximum for any 1 day	30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds)	per 1,000 pounds) oduct
Chromium(1)	0.0000418	0.0000167
Lead	0.0000188	0.0000063
Nickel(1)	0.0000376	0.0000125
Zinc	0.0000125	0.0000042
Naphthalene	0.0000042	
Tetrachloroethylene	0.0000063	
(1) The limitations for chromiu and zinc when cold rollir bination acid pickling wa	ig wastewaters are treate	
Combinat	Table 182 ion Cold Rolling N	fills
	PSNS	
		Average of
	Maximum for any 1 day	daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds	per 1,000 pounds) oduct
Chromium(1)	0,000543	0.000217
Lead	0.000244	0.0000814

0.000163

0.0000542

0.0000813 (1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.

0.000163

0.0000542

Table 183 Single Stand Direct Application Cold Rolling Mills

	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Chromium(1)	0.000104	0.0000418
Lead	0.0000469	0.0000156
Nickel(1)	0.0000939	0.0000313
Zinc	0.0000313	0.0000104
Naphthalene	0.0000104	
Tetrachloroethylene	0.0000156	

The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.

Table 184
Multiple Stand Direct Application Cold Rolling Mills
DOMO

	PSNS	· · ·
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds of p	per 1,000 pounds) roduct
Chromium(1)	0.00121	0.000484
Lead	0.000545	0.000182
Nickel(1)	0.00109	0.000363
Zinc	0.000363	0.000121
Naphthalene	0.000121	
Tetrachloroethylene	0.000182	

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.

	Tal	ble 1	.85	
Wanter d	Dine		The bas	Tain

14010 105
Cold Worked Pipe and Tube Using Water
DOMO

	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pound of product	
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021

(1) The limitations for chronvium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or com-bination acid pickling wastewaters.

Nickel(1)

Naphthalene Tetrachloroethylene

Zinc

Cold Worked Pipe	Table 186 and Tube Using C	Dil Solutions
••••••••••••••••••••••••••••••••••••••	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds of product	
Chromium(1)	0.0000209	0.0000084
Lead	0.0000094	0.0000031
Nickel(1)	0.0000188	0.0000063
Zinc	0.0000063	0.0000021
Naphthalene	0.0000021	
Tetrachloroethylene	0.0000031	

(1) The limitations for chromium and nickel are applicable in lieu of those for lead and zinc when cold rolling wastewaters are treated with descaling or combination acid pickling wastewaters.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.107 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BCT:

*		
	Table 187	
Single Stand Re	circulation Cold Ro	lling Mills
BCT	Effluent Limitations	3
		Average of daily
		values for 30
	Maximum for	consecutive
	any 1 day	days
Pollutant or	kg/kkg (pounds j	per 1,000 pounds)
pollutant property	of product	
TSS	0.00125	0.000626
O&G	0.000522	0.000209
рН	(1)	(1)
(1) Within the range of 6.0 to	9.0	
	Table 188	
Multiple Stand R	ecirculation Cold R	olling Mills
BCT	Effluent Limitation	3
		Average of
		daily values for
	Maximum for	30 consecutive
	any 1 day	days
Pollutant or	kg/kkg (pounds	per 1,000 pounds)
pollutant property		roduct
TSS	0.00626	0.00313
O&G	0.00261	0.00104

(1)

(1)

BCT	Effluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds j	per 1,000 pounds) oduct
TSS	0.0751	0.0376
0&G	0.0313	0.0125
pН	(1)	(1)
1) Within the range of 6.0 to Single Stand Dire	Table 190 ct Application Cold	Rolling Mills
BCT	Effluent Limitations	3
Pollutant or	Maximum for any 1 day kg/kkg (pounds)	Average of daily values for 30 consecutive days per 1,000 pounds
pollutant property		oduct
TSS	0.0225	0.0113
0&G	0.00939	0.00376
pH 1) Within the range of 6.0 to Multiple Stand Dir	Table 191	(1) I Rolling Mills
1) Within the range of 6.0 to Multiple Stand Dir	59.0 Table 191 ect Application Cold Effluent Limitations	l Rolling Mills s Average of daily values fo
1) Within the range of 6.0 to Multiple Stand Dir	59.0 Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day	l Rolling Mills Average of daily values fo 30 consecutive days
1) Within the range of 6.0 to Multiple Stand Dir BCT Pollutant or pollutant property	59.0 Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds) of pr	l Rolling Mills Average of daily values for 30 consecutive days per 1,000 pounds oduct
1) Within the range of 6.0 to Multiple Stand Dir BCT Pollutant or pollutant property TSS	59.0 Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds) of pr 0.100	Average of daily values fo 30 consecutive days per 1,000 pounds oduct 0.0501
Pollutant or TSS O&G	59.0 Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds) of pr 0.100 0.0417	Average of daily values fo do consecutive days per 1,000 pounds oduct 0.0501 0.0167
1) Within the range of 6.0 to Multiple Stand Dir BCT Pollutant or pollutant property TSS O&G pH	Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds of pr 0,100 0,0417 (1)	Average of daily values fo 30 consecutive days per 1,000 pounds oduct 0.0501
Pollutant or pollutant or pollutant property TSS O&G pH 1) Within the range of 6.0 to Cold Worked	Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds of pr 0,100 0,0417 (1)	Average of daily values fo daily values fo days consecutive days per 1,000 pounds coduct 0.0501 0.0167 (1)
Pollutant or pollutant or pollutant property TSS O&G pH 1) Within the range of 6.0 to Cold Worked	Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds) of pr 0,100 0,0417 (1) o 9.0 Table 192 1 Pipe and Tube Usin Effluent Limitation Maximum for	Average of daily values fo 30 consecutive days per 1,000 pounds oduct 0.0501 0.0167 (1) ng Water s Average of daily values fo
1) Within the range of 6.0 to Multiple Stand Dir BCT Pollutant or pollutant property TSS O&G pH 1) Within the range of 6.0 to Cold Worked BCT Pollutant or	Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds of pr 0,100 0,0417 (1) 09.0 Table 192 1 Pipe and Tube Usin Effluent Limitations Maximum for any 1 day kg/kkg (pounds	Average of daily values fo 30 consecutive days per 1,000 pounds oduct 0.0501 0.0167 (1) ng Water s Average of daily values fo 30 consecutive
1) Within the range of 6.0 to Multiple Stand Dir BCT Pollutant or pollutant property TSS O&G pH 1) Within the range of 6.0 to Cold Worked BCT	Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds of pr 0,100 0,0417 (1) 09.0 Table 192 1 Pipe and Tube Usin Effluent Limitations Maximum for any 1 day kg/kkg (pounds	I Rolling Mills Average of daily values fo 30 consecutive days per 1,000 pounds oduct 0.0501 0.0167 (1) ng Water s Average of daily values fo 30 consecutive days per 1,000 pounds
Pollutant or pollutant property TSS O&G pH 1) Within the range of 6.0 to Cold Worked BCT	Table 191 ect Application Cold Effluent Limitations Maximum for any 1 day kg/kkg (pounds) 0,100 0,0417 (1) 0.	l Rolling Mills Average of daily values fo 30 consecutive days per 1,000 pounds oduct 0.0501 0.0167 (1) ng Water s Average of daily values fo 30 consecutive days per 1,000 pounds roduct

(1) Within the range of 6.0 to 9.0

(1) Within the range of 6.0 to 9.0

pН

Cold Worked Pip	Table 193 e and Tube Using C	il Solutions
BCT	Effluent Limitations	3
· ·	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) oduct
TSS	0.00125	0.000626
O&G	0.000522	0.000209
pH (1) Within the range of 6.0 to	(1)	(1)

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Subchapter XI — Alkaline Cleaning Subcategory

NR 254.11 Applicability; description of the alkaline cleaning subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from operations in which steel and steel products are immersed in alkaline cleaning baths to remove mineral and animal fats or oils from the steel. The alkaline cleaning subcategory includes rinsing operations which follow such immersions.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89,

NR 254.111 Specialized definitions. The following definitions are applicable to the terms used in this subchapter:

(1) "Batch" means alkaline cleaning operations which process steel products such as coiled wire, rods, and tubes in discrete batches or bundles.

(2) "Continuous" means alkaline cleaning operations other than batch operations.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.112 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

Detal	Table 194	~
	h Alkaline Cleanin	~
BPT	Effluent Limitation	15
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) product
TSS	0.0730	0.0313
O&G	0.0313	0.0104
pН	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 195	
Continuous Alkaline Cleaning	
BPT Effluent Limitations	

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds of product	
TSS	0.102	0.0438
O&G	0.0438	0.0146
pH	(1)	(1)
(1) Within the range of 6.0 to	9.0	······································

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.113 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. The effluent limitations representing BAT are identical to the limitations set forth in s. NR 254.112. History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

NR 254.114 New source performance standards. The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the following standards:

Batch and Cont	Table 196 tinuous Alkaline (Cleaning
· · · · · · · · · · · · · · · · · · ·	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pound pounds) of	
TSS	0.0146	0.00626
O&G	0.00626	0.00209
pH (1) Within the range of 6.0 to 9.	(1)	(1)

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.115 Pretreatment standards for existing sources. Any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211. History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

NR 254.116 Pretreatment standards for new sources. Any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211. History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

NR 254.117 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. The effluent limitations representing BCT are identical to the limitations set forth in s. NR 254.112.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Subchapter XII — Hot Coating Subcategory

NR 254.12 Applicability; description of the hot coating subcategory. (1) This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from operations in which steel is coated with zinc, terne metal, or other metals by the hot dip process. The hot coating subcategory includes the associated rinsing operations.

(2) For zinc, the BPT limitations set forth in s. NR 254.122 and the BAT limitations set forth in s. NR 254.123 are not applicable to hot coating operations with wastewater treatment facilities achieving, during normal production, zinc discharge levels more stringent than the BPT and BAT limitations. For such operations, the BPT and BAT limitations for zinc shall be determined on a case-by-case basis based upon the existing performance of the wastewater treatment facility. The permitting authority shall evaluate effluent data from the wastewater treatment facility during periods of normal production to establish the case-by-case BPT and BAT limitations. The BPT and BAT limitations specified in ss. NR 254.122 and 254.123 may be used for calculating the total mass limitations for zinc pursuant to s. NR 254.003.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.121 Specialized definitions. The following definitions are applicable to the terms used in this subchapter:

(1) "Fume scrubber" means wet air pollution control devices used to remove and clean fumes originating from hot coating operations.

(2) "Galvanizing" means coating steel products with zinc by the hot dip process including the immersion of the steel product in a molten bath of zinc metal, along with the related preceding and subsequent operations.

(3) "Other coatings" means coating steel products with metals other than zinc or terne metal by the hot dip process including the immersion of the steel product in a molten bath of metal, along with the related preceding and subsequent operations.

(4) "Strip, sheet, and miscellaneous products" means steel products other than wire products and fasteners.

(5) "Terne coating" means coating steel products with terne metal by the hot dip process including the immersion of the steel product in a molten bath of lead and tin, along with the related preceding and subsequent operations.

(6) "Wire products and fasteners" means steel wire, products manufactured from steel wire, and steel fasteners manufactured from steel wire or other steel shapes.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.122 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

Table 197
Strip, Sheet, and Miscellaneous Products
Galvanizing, Terne Coating, and Other Coatings

BPT	Effluent Limitations	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) coduct
TSS	0.175	0.0751
O&G	0.0751	0.0250
Lead	0.00113	0.000376
Zinc	0.00150	0.000500
Hexavalent chro- mium(1)	0.000150	0,0000501
pH	(2)	(2)

 The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.
 Within the range of 6.0 to 9.0

Table 198 Wire Products and Fasteners Galvanizing and Other Coatings

BPTE	Situent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or	kg/kkg (pounds)	per 1,000 pounds)
pollutant property	of product	
TSS	0.701	0.300
O&G	0.300	0.100
Lead	0.00451	0.00150
Zinc	0.00601	0.00200
Hexavalent chro- mium(1)	0.000600	0.000200
pH	(2)	(2)

 The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.
 Within the range of 6.0 to 9.0

Table	199
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I	Jume Scrubbers	
BPT	Effluent Limitations	}
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		or each fume ibber
TSS	38.1	16.3
O&G	16.3	5.45
Lead	0.245	0.0819
Zinc	0.327	0,109
Hexavalent chro- mium(1)	0.0327	0.0109
pН	(2)	(2)
(1) The limitations for hexa	valent chromium apply i	o galvanizing operations

 The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.
 Within the range of 6.0 to 9.0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.123 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT:

Table 200
Strip, Sheet, and Miscellaneous Products
Galvanizing, Terne Coating, and Other Coatings

BAT	Effluent Limitation	S	
	Maximum for any 1 day	Average of daily values for 30 consecutive days	
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds of product		
Lead	0.00113	0.000376	
Zinc	0.00150	0.000500	
Hexavalent chro- mium(1)	0.000150	0.0000501	

(1) The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

Table 201
Wire Products and Fasteners
Galvanizing and Other Coatings

BAT	Effluent Limitation	S	
	Maximum for any 1 day	Average of daily values for 30 consecutive days	
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product		kg/kkg (pounds of p
Lead	0.00451	0.00150	
Zinc	0.00601	0.00200	
Hexavalent chro- mium(1)	0.000601	0.000200	

(1) The limitations for hexavalent chromium apply to galvanizing operations

P	Table 202 ume Scrubbers	
BATE	Iffluent Limitation:	S
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		or each fume ibber
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
Hexavalent chro- mium(1)	0.00490	0.00163
pН	(2)	(2)

which discharge wastewaters from the chromate rinse step.

(2) Within the range of 6.0 to 9.0 History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.124 New source performance standards. The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the following standards:

Table 203
Strip, Sheet, and Miscellaneous Products
Galvanizing, Terne Coating, and Other Coatings

	NSPS	
······································	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.0438	0.0188
O&G	0.0188	0.00626
Lead	0.000282	0.0000939
Zinc	0.000376	0.000125
Hexavalent chro- mium(1)	0.0000376	0.0000125
pН	(2)	(2)
(1) The limitations for hex	avalent chromium apply	to galvanizing operatio

which discharge wastewaters from the chromate rinse step. (2) Within the range of 6.0 to 9.0

Table 204
Wire Products and Fasteners
Galvanizing and Other Coatings

	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
TSS	0.175	0.0751
O&G	0.0751	0.0250
Lead	0.00113	0.000376
Zinc	0.00150	0.000500
Hexavalent chro- mium(1)	0.000150	0.0000501
pH	(2)	(2)

(1) The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step. (2) Within the range of 6.0 to 9.0

Tabla	205

	Table 205	
F	ume Scrubbers	
	NSPS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		or each fume Ibber
TSS	5.72	2.45
O&G	2.45	0.819
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
Hexavalent chro-	0.00490	0.00163

pH (2)(2)(1) The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step. (2) Within the range of 6.0 to 9.0

mium(1)

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.125 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the standards set forth in s. NR 254.123.

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.126 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following PSNS:

Table 206
Strip, Sheet, and Miscellaneous Products
Galvanizing, Terne Coating, and Other Coatings

	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property		per 1,000 pounds) roduct
Lead	0.000282	0.0000939
Zinc	0.000376	0.000125
Hexavalent chro- mium(1)	0.0000376	0.0000125

 The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

Table 207	
Wire Products and Fasteners	
Galvanizing and Other Coatings	

PSNS		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Lead	0.00113	0.000376
Zinc	0.00150	0.000500
Hexavalent chro- mium(1)	0.000150	0.0000501

(1) The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

F	Table 208 ume Scrubbers	
annan ilin ta anno 19	PSNS	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for each fume scrubber	
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
Hexavalent chro- mium(1)	0.00490	0.00163

 The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.
 Within the range of 6.0 to 9.0

History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

NR 254.127 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BCT:

 Table 209

 Strip, Sheet, and Miscellaneous Products

 Galvanizing, Terne Coating, and Other Coatings

 BCT Effluent Limitations

	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.175	0.0751
O&G	0.0751	0.0250
pН	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 210 Wire Products and Fasteners

Galvanizing and Other Coatings

BCI	Enduent Limitations	8
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.701	0.300
O&G	0.300	0.100
pН	(1)	(1)
(1) Within the range of 6.0 to	9.0	

Table 211 Fume Scrubbers

Tune Serubbers

BCUI	Effluent Limitations	3
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for each fume scrubber	
TSS	38.1	16.3
O&G	16.3	5.45
pH	(1)	· (1)

(1) Within the range of 6.0 to 9.0 History: Cr. Register, May, 1989, No. 401, eff. 6-1-89.

Note: The Wisconsin administrative code corresponds to the code of federal regulations as cross referenced in the following table:

State Code	Corresponding Federal Regulation
s. NR 205.03	40 CFR 401,11
s. NR 205.04	40 CFR 401.11
ch. NR 211	40 CFR. Part 403
s. NR 211.03	40 CFR 403.3
s. NR 211.13	40 CFR 403.7
s.NR 211.14	40 CFR 403.13
s. NR 211.15	40 CFR 403.12
ch. NR 219	40 CFR Part 136
ch. NR 254	40 CFR Part 420