State of Wisconsin \ DEPARTMENT OF NATURAL RESOURCES

Carroll D. Besadny
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CR 88-153

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STATE OF WISCONSIN)
)
DEPARTMENT OF NATURAL RESOURCES)

TO ALL TO WHOM THESE PRESENTS SHALL COME, GREETINGS:

I, Bruce B. Braun, Deputy Secretary of the Department of Natural Resources and custodian of the official records of said Department, do hereby certify that the annexed copy of Natural Resources Board Order No. WW-36-88 was duly approved and adopted by this Department on December 15, 1988. I further certify that said copy has been compared by me with the original on file in this Department and that the same is a true copy thereof, and of the whole of such original.

IN TESTIMONY WHEREOF, I have hereunto set my hand and affixed the official seal of the Department at the Natural Resources Building in the City of Madison, this 13th day of February, 1989.

Bruce B. Braun, Deputy Secretary

(SEAL)

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6-1-89

ORDER OF THE STATE OF WISCONSIN
NATURAL RESOURCES BOARD
REPEALING AND RECREATING RULES

IN THE MATTER of repealing and recreating ch. NR. 254 of the Wisconsin Administrative Code pertaining to the effluent limitations and pretreatment standards for the iron and steel manufacturing industry

WW-36-88

Analysis Prepared by Department of Natural Resources

Statutory authority: ss. 147.01, 147.035, 147.04, 147.06, 147.07, and 227.11(2)(a), Stats.
Statutes interpreted: ss. 147.035, 147.04, 147.06, and 147.07, Stats.

The Federal Water Pollution Control Act amendments of 1972 established a comprehensive program to "restore and maintain the chemical, physical and biological integrity of the Nation's waters" (section 101(a)). To implement the act, the U.S. Environmental Protection Agency issues effluent limitation guidelines, pretreatment standards, and new source performance standards for industrial wastewater discharges. The Clean Water Act of 1977 expanded the federal pollution control program by setting different types of effluent limitations: "best practicable technology" (BPT), "best available technology" (BAT), "best conventional technology" (BCT), "new source performance standards" (NSPS), "pretreatment standards for existing sources" (PSES), and "pretreatment standards for new sources" (PSNS). The Clean Water Act stressed control of toxic pollutants, including 65 "priority" pollutants and classes of pollutants from 21 major industries.

The Wisconsin Department of Natural Resources instituted the Wisconsin pollutant discharge elimination system in 1976. This system includes regulating effluent discharges of various industries. The Wisconsin Department of Natural Resources is promulgating ch. NR 254, Wis. Adm. Code, to regulate the iron and steel manufacturing industry. The provisions of this chapter are based upon the U.S. Environmental Protection Agency's regulations in 40 C.F.R. Part 420.

The purpose of this rule is to specify effluent limitations for BPT, BAT, BCT, and NSPS for the direct discharge of pollutants to waters of the state and to establish pretreatment standards for the introduction of pollutants to publicly owned treatment works. The effect of the repeal and recreation of ch. NR 254, Wis. Adm. Code, will be to clarify and update standards and limitations for industrial wastewater discharges from the iron and steel manufacturing industry. The code will reflect changes made by the U.S. Environmental Protection agency under authority of sections 301, 304, 306, 307, 308, and 501 of the Clean Water Act.

Iron and steel manufacturing encompasses those plants which produce intermediate and final steel products. In the first major step of the manufacturing process, coal is converted to coke. In the next major process, the coke is combined with iron ore and limestone in a blast furnace to produce iron. The third major process consists of the purification of iron in either an open hearth, basic oxygen, or electric arc furnace to produce steel. Refining and forming steps follow.

Water is essential to the iron and steel manufacturing industry. An average of 40,000 gallons of water is used for every ton of finished steel. This makes the iron and steel manufacturing industry one of the largest water users of any industrial category.

The iron and steel manufacturing category has been divided into twelve subcategories based upon manufacturing process: cokemaking, sintering, ironmaking, steelmaking, vacuum degassing, continuous casting, hot forming, salt bath descaling, acid pickling, cold forming, alkaline cleaning, and hot coating. The wastewaters of the various processes contain different pollutants and therefore require treatment by different control systems. The most important pollutants generated by the iron and steel manufacturing industry are ammonia nitrogen, total and hexavalent chromium, cyanide, iron, lead, nickel, oil and grease, phenols, suspended solids, tin, and zinc. Cokemaking and cold rolling generate toxic organic pollutants.

Three federal documents form the basis for 40 CFR Part 420 and ch. NR 254: (1) development document for effluent limitations guidelines, new source performance standards, and pretreatment standards for the iron and steel manufacturing point source category (USEPA, Washington, D.C., EPA 440/2-82/024, May, 1982); (2) economic impact analysis of effluent limitations guidelines and standards for the iron and steel manufacturing industry (USEPA, Washington, D.C., EPA 440/2-81/009, December, 1980); and (3) sampling and analysis procedures for screening of industrial effluents for priority pollutants (USEPA, Cincinnatti, Ohio, April 1977). Copies of these documents are available for inspection at the central office of the Wisconsin Department of Natural Resources, 101 south Webster street, Madison, and may be obtained from the National Technical Information Service (NTIS), Springfield, Virginia 22161, (703) 487-4600.

This rule uses the format and text of 40 CFR Part 465 and is identical to the federal regulation for purposes of s. 227.14(1m)(a), Stats. However, changes have been made in the text of the federal regulation to make the rule useful to Wisconsin citizens, industry and regulating authorities. These changes are consistent with the current state regulatory framework and reflect as much as possible the conventions of state rule drafting.

As required by the administrative rules procedures manual, a purpose section has been added. In addition, revisions have been made to the numbering system, citation formats and definition formats. Where possible, Wisconsin Administrative Code References were substituted in the text for references to the Code of Federal Regulations. Citations in the text to the Code of Federal Regulations may be cross-referenced to corresponding sections of the Wisconsin Administrative Code in the table which has been added at the end of the rule. The authority section and subpart divisions in the federal regulation have been deleted. Definitions for "existing source" and "new source" have been added to the general definitions section in the state rule.

SECTION 1. Chapter NR 254 is repealed and recreated to read:

Chapter NR 254

IRON AND STEEL MANUFACTURING

Subchapter III - The ironmaking subcategory

Subchapter IV - The steelmaking subcategory

Subchapter V - The vacuum degassing subcategory

Subchapter VI - The continuous casting subcategory

Subchapter VII - The hot forming subcategory

Subchapter VIII - The salt bath descaling subcategory

Subchapter IX - The acid pickling subcategory

Subchapter X - The cold forming subcategory

Subchapter XI - The alkaline cleaning subcategory

Subchapter XII - The hot coating subcategory

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.

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.

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, 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).

(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.

NR 254.003 ALTERNATIVE EFFLUENT LIMITATIONS. (1) Except as provided in subs. (4) and (5), any existing point source subject to ch. NR 254 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.

NR 254.004 CALCULATION OF PRETREATMENT STANDARDS. (1) 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.

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.

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

SUBCHAPTER I - THE COKEMAKING SUBCATEGORY

NR 254.010 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 beehive cokemaking operations.

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 adsorbtion units which were in operation prior to January 7, 1981.

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 C.F.R. ss. 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

Iron and Steel Byproduct Cokemaking

	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	0.253	0.131
O&G	0.0327	0.0109
Ammonia-N	0.274	0.0912
Cyanide	0.0657	0.0219
Phenols (4AAP)	0.00451	0.00150
pH	(1)	(1)

(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		
	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
Phenols (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.

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 C.F.R. ss. 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 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	0.0543	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

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	0.0645	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

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	0.0603	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 imitations 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) BEEHIVE COKEMAKING. Beehive cokemaking operations may not discharge process wastewaters to waters of the state.

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 Steel Byproduct Cokemaking

	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	0.172	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 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 Cokemaking

	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	0.192	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. Beehive cokemaking operations may not discharge process wastewaters to waters of the state.

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

Table 9

Iron And Steel Byproduct Cokemaking

	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 Cokemaking

	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.

NR 254.016 PRETREATMENT STANDARDS FOR NEW SOURCES. (1) Except as provided in s. NR 211.13, any existing 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:

Table 11

Iron And Steel 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	
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	
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.

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 C.F.R. ss. 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:

Table 13

Iron And Steel Byproduct Cokemaking

	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	0.253	0.131
O&G	0.0327	0.0109
pH	(1)	(1)

(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 % 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.

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

Table 14

Merchant Byproduct Cokemaking

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	0.270	0.140
O&G	0.0348	0.0116
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.

(3) BEEHIVE COKEMAKING. Beehive cokemaking operations may not discharge process wastewaters to waters of the state.

SUBCHAPTER II - SINTERING SUBCATEGORY

NR 254.020 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.

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 C.F.R. ss. 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 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	0.0751	0.0250
O&G	0.0150	0.00501
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

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 C.F.R. ss. 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 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(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, phenols (4AAP), and TRC shall be applicable only when sintering wastewaters are treated with ironmaking wastewaters.

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	kg/kkg (pounds per 1,000 pounds) of product	
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

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	0.00150
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 phenols (4AAP) shall be applicable only when sintering wastewaters are treated with ironmaking wastewaters.

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	kg/kkg (pounds per 1,000 pounds) of product	
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 phenols (4AAP) shall be applicable only when sintering wastewaters are treated with ironmaking wastewaters.

SUBCHAPTER III - THE IRONMAKING SUBCATEGORY

NR 254.030 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.

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.

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 C.F.R. ss. 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 20

Iron Blast Furnace

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	0.0782	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		
	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	0.313	0.104
Ammonia-N	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

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 C.F.R. ss. 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 22

Iron Blast Furnace

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	0.00876	0.00292
Cyanide	0.00175	0.000876
Phenols (4AAP)	0.0000584	0.0000292
TRC(1)	0.000146	
Lead	0.000263	0.0000876
Zinc	0.000394	0.000131

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

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:

Table 23

Iron Blast Furnace

	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	0.0117	0.00438
O&G	0.00292	
Ammonia-N	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
pH	(2)	(2)

(1) The limitations for TRC shall be applicable only when ironmaking wastewater is chlorinated.
(2) Within the range of 6.0 to 9.0

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

Iron Blast Furnace

	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	0.00876	0.00292
Cyanide	0.00175	0.000876
Phenols (4AAP)	0.0000584	0.0000292
Lead	0.000263	0.0000876
Zinc	0.000394	0.000131

Table 25

Existing Indirect Dischargers

	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	0.0350	0.0175
Cyanide	0.00175	0.000876
Phenols (4AAP)	0.000175	0.0000584
Lead	0.000263	0.0000876
Zinc	0.000394	0.000131

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

Iron Blast Furnace

	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	0.00876	0.00292
Cyanide	0.000584	0.000292
Phenols (4AAP)	0.0000584	0.0000292
Lead	0.000263	0.0000876
Zinc	0.000394	0.000131

SUBCHAPTER IV - THE STEELMAKING SUBCATEGORY

NR 254.040 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.

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.

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 C.F.R. ss. 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.

Table 27

Wet Suppressed Combustion Basic Oxygen Furnace Steelmaking

	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	0.0312	0.0104
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 28

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

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	0.0687	0.0229
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

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 C.F.R. ss. 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.

Table 29

Wet Suppressed Combustion Basic Oxygen Furnace Steelmaking

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	
Lead	0.000188	0.0000626
Zinc	0.000282	0.0000939

Table 30

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

	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	
Lead	0.000413	0.000138
Zinc	0.000620	0.000207

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
pH	(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

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

Wet Suppressed Combustion Basic Oxygen Furnace Steelmaking

	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

Table 34

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

	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	0.000413	0.000138
Zinc	0.000620	0.000207

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
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Lead	0.000188	0.0000626
Zinc	0.000282	0.0000939

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
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Lead	0.000413	0.000138
Zinc	0.000620	0.000207

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.

SUBCHAPTER V - THE VACUUM DEGASSING SUBCATEGORY

NR 254.050 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.

NR 254.052 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 C.F.R. ss. 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 37

Vacuum Degassing

	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	0.0156	0.00521
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

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 C.F.R. ss. 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 38

Vacuum Degassing

	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	
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469

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

Vacuum Degassing

	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	0.00730	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

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:

Table 40

Vacuum Degassing

	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	0.0000939	0.0000313
Zinc	0.000141	0.0000469

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:

Table 41

Vacuum Degassing

	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	0.0000939	0.0000313
Zinc	0.000141	0.0000469

SUBCHAPTER VI - THE CONTINUOUS CASTING SUBCATEGORY

NR 254.060 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.

NR 254.062 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 C.F.R. ss. 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 42

Continuous Casting

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	0.0780	0.0260
O&G	0.0234	0.0078
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

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 C.F.R. ss. 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 43

Continuous Casting

	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	
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469

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:

Table 44

Continuous Casting

	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	0.00730	0.00261
O&G	0.00313	0.00104
Lead	0.0000939	0.0000313
Zinc	0.000141	0.0000469
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

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

Continuous Casting

	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	0.0000939	0.0000313
Zinc	0.000141	0.0000469

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:

Table 46

Continuous Casting

	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	0.0000939	0.0000313
Zinc	0.000141	0.0000469

SUBCHAPTER VII - THE HOT FORMING SUBCATEGORY

NR 254.070 APPLICABILITY; DESCRIPTION OF THE 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.

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, tungston, 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 %.

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 C.F.R. ss. 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 47

Carbon and Specialty Primary Mills Without Scarfing

	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	0.150	0.0561
O&G	0.0374	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 48

Carbon and Specialty Primary Mills With Scarfing

	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	0.221	0.0830
O&G	0.0553	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 49

Carbon Section Mills

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	0.357	0.134
O&G	0.0894	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 50

Specialty Section Mills

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	0.224	0.0841
O&G	0.0561	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 51

Carbon and Specialty Hot Strip and Sheet Mills

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	0.427	0.160
O&G	0.107	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 52

Carbon Plate Mills

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	0.227	0.0851
O&G	0.0568	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 53

Specialty Plate Mills

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	0.100	0.0376
O&G	0.0250	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 54

Carbon and Specialty Pipe and Tube Mills

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	0.212	0.0795
O&G	0.0530	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

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.

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:

Table 55

Carbon and Specialty Primary Mills Without Scarfing

	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	0.0150	0.00563
O&G	0.00373	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 56

Carbon and Specialty Primary Mills With Scarfing

	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	0.0234	0.00876
O&G	0.00584	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 57

Carbon Section Mills

	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	0.0334	0.0125
O&G	0.00834	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 58

Specialty Section Mills

	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	0.0217	0.00813
O&G	0.00542	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 59

Carbon and Specialty Hot Strip and Sheet Mills

	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	0.0435	0.0163
O&G	0.0109	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 60

Carbon Plate Mills

	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	0.0234	0.00876
O&G	0.00584	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 61

Specialty Plate Mills

	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	0.0100	0.00375
O&G	0.00250	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 62

Carbon and Specialty Pipe and Tube Mills

	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	0.0369	0.0138
O&G	0.00917	
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

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.

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.

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.

SUBCHAPTER VIII - THE SALT BATH DESCALING SUBCATEGORY

NR 254.080 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.

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.

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 C.F.R. ss. 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 63

Sheet And Plate Batch Oxidizing Salt Bath Descaling

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	0.204	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		
	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	0.123	0.0526
Chromium	0.00175	0.000701
Nickel	0.00158	0.000526
pH	(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		
	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	0.496	0.213
Chromium	0.00709	0.00284
Nickel	0.00638	0.00213
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 66

Continuous Oxidizing Salt Bath Descaling

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	0.0964	0.0413
Chromium	0.00138	0.000551
Nickel	0.00124	0.000413
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 67

Batch Reducing Salt Bath Descaling

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	0.0949	0.0407
Cyanide	0.00102	0.000339
Chromium	0.00136	0.000542
Nickel	0.00122	0.000407
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 68

Continuous Reducing Salt Bath Descaling

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	0.532	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

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 C.F.R. ss. 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

	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	0.00292	0.00117
Nickel	0.00263	0.000876

Table 70

Rod And Wire Batch Oxidizing Salt Bath Descaling

	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	0.00175	0.000701
Nickel	0.00158	0.000526

Table 71

Pipe And Tube Batch Oxidizing Salt Bath Descaling

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	0.00709	0.00284
Nickel	0.00638	0.00213

Table 72

Continuous Oxidizing Salt Bath Descaling

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	0.00138	0.000551
Nickel	0.00124	0.000413

Table 73

Batch Reducing Salt Bath Descaling

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	
Cyanide	0.00102	0.000339
Chromium	0.00136	0.000542
Nickel	0.00122	0.000407

Table 74

Continuous Reducing Salt Bath Descaling

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	
Cyanide	0.00569	0.00190
Chromium	0.00759	0.00304
Nickel	0.00683	0.00228

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.

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.

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.

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 C.F.R. ss. 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

	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	0.204	0.0876
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 76

Rod And Wire Batch Oxidizing Salt Bath Descaling

	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	0.123	0.0526
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 77

Pipe And Tube Batch Oxidizing Salt Bath Descaling

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	0.496	0.213
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 78

Continuous Oxidizing Salt Bath Descaling

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	0.0964	0.0413
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 79

Batch Reducing Salt Bath Descaling

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	0.0949	0.0407
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 80

Continuous Reducing Salt Bath Descaling

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	0.532	0.228
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

SUBCHAPTER IX - THE ACID PICKLING SUBCATEGORY

NR 254.090 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.

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.

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 C.F.R. ss. 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 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)

(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 82

Bar, Billet, and Bloom 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 pounds) 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)

(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 83

Strip, Sheet, and Plate 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 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
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 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 pounds) of product	
TSS	0.146	0.0626
O&G(1)	0.0626	0.0209
Lead	0.000939	0.000313
Zinc	0.00125	0.000417
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 85

Sulfuric Acid Pickling Fume Scrubbers

BPT Effluent Limitations		
	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	5.72	2.45
O&G(1)	2.45	0.819
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
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 86

Rod, Wire, and Coil Hydrochloric 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 pounds) of product	
TSS	0.143	0.0613
O&G(1)	0.0613	0.0204
Lead	0.000920	0.000307
Zinc	0.00123	0.000409
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 87

Strip, Sheet, and Plate Hydrochloric 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 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)

(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 88

Pipe, Tube, and Other Products Hydrochloric 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 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
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 89

Hydrochloric Acid Pickling Fume Scrubbers

	BPT Effluent Limitations	
	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	5.72	2.45
O&G(1)	2.45	0.819
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
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 90

Absorber Vent Scrubber Wastewater
From Hydrochloric Acid Regeneration

	BPT Effluent Limitations	
	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	38.2	16.3
O&G(1)	16.3	5.45
Lead	0.245	0.0819
Zinc	0.327	0.109
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 91

Rod, Wire, and Coil Combination 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 pounds) of product	
TSS	0.149	0.0638
O&G(1)	0.0638	0.0213
Chromium	0.00213	0.000852
Nickel	0.00192	0.000638
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 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	kg/kkg (pounds per 1,000 pounds) of product	
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)

(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 93

Strip, Sheet, and Plate Continuous Combination 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 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
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 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	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.134	0.0576
O&G(1)	0.0576	0.0192
Chromium	0.00192	0.000768
Nickel	0.00173	0.000576
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 95

Pipe, Tube, and Other Products Combination 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 pounds) of product	
TSS	0.225	0.0964
O&G(1)	0.0964	0.0322
Chromium	0.00322	0.00129
Nickel	0.00289	0.000964
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 96

Combination Acid Pickling Fume Scrubbers

BPT Effluent Limitations		
	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	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

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 C.F.R. ss. 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

	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	
Lead	0.000526	0.000175
Zinc	0.000701	0.000234

Table 98

Bar, Billet, and Bloom Sulfuric Acid Pickling

	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	
Lead	0.000169	0.0000563
Zinc	0.000225	0.0000751

Table 99

Strip, Sheet, and Plate Sulfuric Acid Pickling

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	
Lead	0.000338	0.000113
Zinc	0.000451	0.000150

Table 100

Pipe, Tube, and Other Products Sulfuric Acid Pickling

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	
Lead	0.000939	0.000313
Zinc	0.00125	0.000417

Table 101

Sulfuric Acid Pickling Fume Scrubbers

BAT Effluent Limitations		
	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

Table 102

Rod, Wire, and Coil Hydrochloric Acid Pickling

	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	
Lead	0.000920	0.000307
Zinc	0.00123	0.000409

Table 103

Strip, Sheet, and Plate Hydrochloric Acid Pickling

	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	
Lead	0.000526	0.000175
Zinc	0.000701	0.000234

Table 104

Pipe, Tube, and Other Products Hydrochloric Acid Pickling

	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	
Lead	0.00192	0.000638
Zinc	0.00255	0.000851

Table 105

Hydrochloric Acid Pickling Fume Scrubbers

	BAT Effluent Limitations	
	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

Table 106

Absorber Vent Scrubber Wastewater
From Hydrochloric Acid Regeneration

	BAT Effluent Limitations	
	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	0.245	0.0819
Zinc	0.327	0.109

Table 107

Rod, Wire, and Coil Combination Acid Pickling

	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	0.00213	0.000852
Nickel	0.00192	0.000638

Table 108

Bar, Billet, and Bloom Combination Acid Pickling

	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	0.000960	0.000384
Nickel	0.000864	0.000288

Table 109

Strip, Sheet, and Plate Continuous Combination Acid Pickling

	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	0.00626	0.00250
Nickel	0.00563	0.00188

Table 110

Strip, Sheet, and Plate Batch Combination Acid Pickling

	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	0.00192	0.000768
Nickel	0.00173	0.000576

Table 111

Pipe, Tube, and Other Products Combination Acid Pickling

	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	0.00322	0.00129
Nickel	0.00289	0.000964

Table 112

Combination Acid Pickling Fume Scrubbers

	BAT Effluent Limitations	
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg per day for each fume scrubber	
Chromium	0.0819	0.0327
Nickel	0.0735	0.0245

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:

Table 113

Rod, Wire, and Coil Sulfuric Acid 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) of product	
TSS	0.0146	0.00626
O&G(1)	0.00626	0.00209
Lead	0.0000939	0.0000313
Zinc	0.000125	0.0000417
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 114

Bar, Billet, and Bloom Sulfuric Acid 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) of product	
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)

(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 115

Strip, Sheet, and Plate Sulfuric Acid 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) of product	
TSS	0.0117	0.00501
O&G(1)	0.00501	0.00167
Lead	0.0000751	0.0000250
Zinc	0.000100	0.0000334
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 116

Pipe, Tube, and Other Products Sulfuric Acid 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) of product	
TSS	0.0204	0.00876
O&G(1)	0.00876	0.00292
Lead	0.000131	0.0000438
Zinc	0.000175	0.0000584
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 117

Sulfuric Acid Pickling Fume Scrubbers

	NSPS	
	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	5.72	2.45
O&G(1)	2.45	0.819
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
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 118

Rod, Wire, and Coil Hydrochloric Acid 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) of product	
TSS	0.0175	0.00751
O&G(1)	0.00751	0.00250
Lead	0.000113	0.0000376
Zinc	0.000150	0.0000501
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 119

Strip, Sheet, and Plate Hydrochloric Acid 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) of product	
TSS	0.0117	0.00501
O&G(1)	0.00501	0.00167
Lead	0.0000751	0.0000250
Zinc	0.000100	0.0000334
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 120

Pipe, Tube, and Other Products Hydrochloric Acid 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) of product	
TSS	0.0321	0.0138
O&G(1)	0.0138	0.00459
Lead	0.000206	0.0000688
Zinc	0.000275	0.0000918
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 121

Hydrochloric Acid Pickling Fume Scrubbers

	NSPS	
	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	5.72	2.45
O&G(1)	2.45	0.819
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
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 122

Rod, Wire, and Coil Combination Acid 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) of product	
TSS	0.0204	0.00876
O&G(1)	0.00876	0.00292
Chromium	0.000292	0.000117
Nickel	0.000263	0.0000876
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 123

Bar, Billet, and Bloom Combination Acid 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) of product	
TSS	0.0117	0.00501
O&G(1)	0.00501	0.00167
Chromium	0.000167	0.0000667
Nickel	0.000150	0.0000501
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 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 per 1,000 pounds) of product	
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

Table 125

Strip, Sheet, and Plate Batch Combination Acid 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) of product	
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	
	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	0.0292	0.0125
O&G(1)	0.0125	0.00418
Chromium	0.000418	0.000167
Nickel	0.000376	0.000125
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 127

Combination Acid Pickling Fume Scrubbers

	NSPS	
	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	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

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.

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, and Coil Sulfuric Acid Pickling

	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	0.0000939	0.0000313
Zinc	0.000125	0.0000417

Table 129

Bar, Billet, and Bloom Sulfuric Acid Pickling

	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	0.0000563	0.0000188
Zinc	0.0000751	0.0000250

Table 130

Strip, Sheet, and Plate Sulfuric Acid Pickling

	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	0.0000751	0.0000250
Zinc	0.000100	0.0000334

Table 131

Pipe, Tube, and Other Products Sulfuric Acid Pickling

	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	0.000131	0.0000438
Zinc	0.000175	0.0000584

Table 132

Sulfuric Acid 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 each fume scrubber	
Lead	0.0368	0.0123
Zinc	0.0491	0.0164

Table 133

Rod, Wire, and Coil Hydrochloric Acid Pickling

	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	0.000113	0.0000376
Zinc	0.000150	0.0000501

Table 134

Strip, Sheet, and Plate Hydrochloric Acid Pickling

	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	0.0000751	0.0000250
Zinc	0.000100	0.0000334

Table 135

Pipe, Tube, and Other Products Hydrochloric Acid Pickling

	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	0.000206	0.0000688
Zinc	0.000275	0.0000918

Table 136

Hydrochloric Acid 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 each fume scrubber	
Lead	0.0368	0.0123
Zinc	0.0491	0.0164

Table 137

Rod, Wire, and Coil Combination Acid Pickling

	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	0.000292	0.000117
Nickel	0.000263	0.0000876

Table 138

Bar, Billet, and Bloom Combination Acid Pickling

	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	0.000167	0.0000667
Nickel	0.000150	0.0000501

Table 139

Strip, Sheet, and Plate Continuous Combination Acid Pickling

	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	0.000710	0.000284
Nickel	0.000638	0.000213

Table 140

Strip, Sheet, and Plate Batch Combination Acid Pickling

	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	0.000250	0.000100
Nickel	0.000225	0.0000751

Table 141

Pipe, Tube, and Other Products Combination Acid Pickling

	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	0.000418	0.000167
Nickel	0.000376	0.000125

Table 142

Combination Acid 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 each fume scrubber	
Chromium	0.0819	0.0327
Nickel	0.0735	0.0245

NR 254.097 EFFLUENT LIMITATIONS REPRESENTING THE DEGREE OF EFFLUENT REDUCTION ATTAINABLE BY THE APPLICATION OF THE BEST CONVENTIONAL POLLUTANT CONTROL TECHNOLOGY. Except as provided in 40 C.F.R. ss. 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 Coil Sulfuric Acid Pickling

	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	0.0819	0.0350
O&G(1)	0.0350	0.0117
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 144

Bar, Billet, and Bloom Sulfuric Acid Pickling

	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	0.0263	0.0113
O&G(1)	0.0113	0.00376
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 145

Strip, Sheet, and Plate Sulfuric Acid Pickling

	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	0.0526	0.0225
O&G(1)	0.0225	0.00751
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 146

Pipe, Tube, and Other Products Sulfuric Acid Pickling

	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	0.146	0.0626
O&G(1)	0.0626	0.0209
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 147

Sulfuric 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 each fume scrubber	
TSS	5.72	2.45
O&G(1)	2.45	0.819
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 148

Rod, Wire, and Coil Hydrochloric Acid Pickling

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	0.143	0.0613
O&G(1)	0.0613	0.0204
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 149

Strip, Sheet, and Plate Hydrochloric Acid Pickling

	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	0.0819	0.0350
O&G(1)	0.0350	0.0117
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 150

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	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.298	0.128
O&G(1)	0.128	0.0426
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 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 each fume scrubber	
TSS	5.72	2.45
O&G(1)	2.45	0.819
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 152

Absorber Vent Scrubber Wastewater
From Hydrochloric Acid Regeneration

	BCT Effluent Limitations	
	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	38.2	16.3
O&G(1)	16.3	5.45
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 153

Rod, Wire, and Coil Combination Acid Pickling

	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	0.149	0.0638
O&G(1)	0.0638	0.0213
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 154

Bar, Billet, and Bloom Combination Acid Pickling

	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	0.0672	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 Combination Acid Pickling

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	0.438	0.188
O&G(1)	0.188	0.0626
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 156

Strip, Sheet, and Plate Batch Combination Acid Pickling

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	0.134	0.0576
O&G(1)	0.0576	0.0192
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 157

Pipe, Tube, and Other Products Combination Acid Pickling

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	0.225	0.00964
O&G(1)	0.0964	0.0321
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 158

Combination 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 each fume scrubber	
TSS	5.72	2.45
O&G(1)	2.45	0.819
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

SUBCHAPTER X - THE COLD FORMING SUBCATEGORY

NR 254.100 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.

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.

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 C.F.R. ss. 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 159

Single Stand Recirculation Cold Rolling Mills

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	0.00125	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)

(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 160

Multiple Stand Recirculation Cold Rolling Mills

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	0.00626	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 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 161

Combination Cold Rolling Mills

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	0.0751	0.0376
O&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 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 162

Single Stand Direct Application Cold Rolling Mills

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	0.0225	0.0113
O&G	0.00939	0.00376
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	
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 163

Multiple Stand Direct Application Cold Rolling Mills

	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	0.100	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)

(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 164

Cold Worked Pipe and Tube Using Water

	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	0.00125	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
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 165

Cold Worked Pipe and Tube Using Oil Solutions

	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	0.00125	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)

(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

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 C.F.R. ss. 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 166

Single Stand Recirculation 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)	0.0000209	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.

Table 167

Multiple Stand Recirculation 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)	0.000104	0.0000418
Lead	0.0000469	0.0000156
Nickel(1)	0.0000939	0.0000313
Zinc	0.0000313	0.0000104
Naphthalene	0.0000104	
Tetrachloroethylene	0.0000156	

(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.

Table 168

Combination 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)	0.00125	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 combination 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 combination 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	kg/kkg (pounds per 1,000 pounds) of product	
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 combination 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 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

(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.

Table 172

Cold Worked Pipe and Tube Using Oil Solutions

	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)	0.0000209	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.

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:

Table 173

Single Stand Recirculation Cold Rolling Mills

	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	0.00125	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)

(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 174

Multiple Stand Recirculation Cold Rolling Mills

	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	0.00250	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	kg/kkg (pounds per 1,000 pounds) of product	
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

Table 176

Single Stand Direct Application Cold Rolling Mills

	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	0.00626	0.00313
O&G	0.00261	0.00104
Chromium(1)	0.000104	0.000041[8]
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 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 177

Multiple Stand Direct Application Cold Rolling Mills

	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	0.0726	0.0363
O&G	0.0302	0.0121
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	
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 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	kg/kkg (pounds per 1,000 pounds) 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
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 179

Cold Worked Pipe and Tube Using Oil Solutions

	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	0.00125	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)

(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

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.

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:

Table 180

Single Stand Recirculation Cold Rolling Mills

	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.

Table 181

Multiple Stand Recirculation Cold Rolling Mills

	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)	0.0000418	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 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.

Table 182

Combination Cold Rolling Mills

	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)	0.000543	0.000217
Lead	0.000244	0.0000814
Nickel(1)	0.000488	0.000163
Zinc	0.000163	0.0000542
Naphthalene	0.0000542	
Tetrachloroethylene	0.0000813	

(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.

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	kg/kkg (pounds per 1,000 pounds) of product	
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	

(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.

Table 184

Multiple Stand Direct Application Cold Rolling Mills

	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)	0.00121	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 combination acid pickling wastewaters.

Table 185

Cold Worked Pipe and Tube Using Water

	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

(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.

Table 186

Cold Worked Pipe and Tube Using Oil 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.

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 C.F.R. ss. 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 Recirculation Cold Rolling Mills

	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	0.00125	0.000626
O&G	0.000522	0.000209
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 188

Multiple Stand Recirculation Cold Rolling Mills

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	0.00626	0.00313
O&G	0.00261	0.00104
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 189

Combination Cold Rolling Mills

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	0.0751	0.0376
O&G	0.0313	0.0125
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 190

Single Stand Direct Application Cold Rolling Mills

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	0.0225	0.0113
O&G	0.00939	0.00376
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 191

Multiple Stand Direct Application Cold Rolling Mills

	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	0.100	0.0501
O&G	0.0417	0.0167
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 192

Cold Worked Pipe and Tube Using Water

	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	0.00125	0.000626
O&G	0.000522	0.000209
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 193

Cold Worked Pipe and Tube Using Oil Solutions

	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	0.00125	0.000626
O&G	0.000522	0.000209
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

SUBCHAPTER XI - THE ALKALINE CLEANING SUBCATEGORY

NR 254.110 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.

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.

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 C.F.R. ss. 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 194

Batch 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	0.0730	0.0313
O&G	0.0313	0.0104
pH	(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

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.

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:

Table 196

Batch and Continuous Alkaline Cleaning

	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	0.00626
O&G	0.00626	0.00209
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

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.

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.

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.

SUBCHAPTER XII - THE HOT COATING SUBCATEGORY

NR 254.120 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 that 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.

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.

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 C.F.R. ss. 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		
	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
Lead	0.00113	0.000376
Zinc	0.00150	0.000500
Hexavalent chromium(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

Table 198

Wire Products and Fasteners
Galvanizing and Other Coatings

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	0.701	0.300
O&G	0.300	0.100
Lead	0.00451	0.00150
Zinc	0.00601	0.00200
Hexavalent chromium(1)	0.000600	0.000200
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

Table 199

Fume Scrubbers

BPT Effluent Limitations		
	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
Lead	0.245	0.0819
Zinc	0.327	0.109
Hexavalent chromium(1)	0.0327	0.0109
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

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 C.F.R. ss. 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 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	0.00113	0.000376
Zinc	0.00150	0.000500
Hexavalent chromium(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 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	0.00451	0.00150
Zinc	0.00601	0.00200
Hexavalent chromium(1)	0.000601	0.000200

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

Table 202

Fume Scrubbers

BAT Effluent Limitations		
	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 chromium(1)	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

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	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.0438	0.0188
O&G	0.0188	0.00626
Lead	0.000282	0.0000939
Zinc	0.000376	0.000125
Hexavalent chromium(1)	0.0000376	0.0000125
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

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	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.175	0.0751
O&G	0.0751	0.0250
Lead	0.00113	0.000376
Zinc	0.00150	0.000500
Hexavalent chromium(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

Table 205

Fume Scrubbers

	NSPS	
	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	5.72	2.45
O&G	2.45	0.819
Lead	0.0368	0.0123
Zinc	0.0491	0.0164
Hexavalent chromium(1)	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

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.

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	kg/kkg (pounds per 1,000 pounds) of product	
Lead	0.000282	0.0000939
Zinc	0.000376	0.000125
Hexavalent chromium(1)	0.0000376	0.0000125

(1) 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 chromium(1)	0.000150	0.0000501

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

Table 208

Fume Scrubbers

	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 chromium(1)	0.00490	0.00163

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

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 C.F.R. ss. 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
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 210

Wire Products and Fasteners
Galvanizing 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	0.701	0.300
O&G	0.300	0.100
pH	(1)	(1)

(1) Within the range of 6.0 to 9.0

Table 211

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 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

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 C.F.R. s. 401.11
s. NR 205.04	40 C.F.R. s. 401.11
ch. NR 211	40 C.F.R. Part 403
s. NR 211.03	40 C.F.R. s. 403.3
s. NR 211.13	40 C.F.R. s. 403.7
s. NR 211.14	40 C.F.R. s. 403.13
s. NR 211.15	40 C.F.R. s. 403.12
ch. NR 219	40 C.F.R. Part 136
ch. NR 254	40 C.F.R. Part 420

The foregoing rules were approved and adopted by the State of Wisconsin Natural Resources Board on December 15, 1988.

The rules shall take effect the first day of the month following publication in the Wisconsin administrative register, as provided in s. 227.22(2) (intro.), Stats.

Dated at Madison, Wisconsin, February 13, 1989.

STATE OF WISCONSIN DEPARTMENT OF NATURAL RESOURCES

SEAL

By Carroll D Besadny.
Carroll D. Besadny, Secretary

State of Wisconsin \ DEPARTMENT OF NATURAL RESOURCES

Carroll D. Besadny
Secretary

BOX 7921
MADISON, WISCONSIN 53707

February 13, 1989

1020

RECEIVED
FEB 20 1989
Revisor of Statutes
Bureau

Mr. Orlan L. Prestegard
Revisor of Statutes
Suite 702
30 W. Mifflin Street

Dear Mr. Prestegard:

Enclosed are two copies, including one certified copy, of State of Wisconsin Natural Resources Board Order No. WW-36-88. These rules were reviewed by the Assembly Committee on Natural Resources and the Senate Committee on Urban Affairs, Environmental Resources, Utilities and Elections pursuant to s. 227.19, Stats. A summary of the final regulatory flexibility analysis and comments of the legislative review committees is also enclosed.

You will note that this order takes effect following publication. Kindly publish it in the Administrative Code accordingly.

Sincerely,

C. D. Besadny
Secretary

Enc.