Chapter NR 254

IRON AND STEEL MANUFACTURING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

NR 254.004 Calculation of pretreatment standards. **(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.

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

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

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

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

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

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

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

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

NR 254.006 Removal credits for 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.

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

Subchapter I — Cokemaking Subcategory

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

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

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

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

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

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

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

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

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

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

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

NR 254.012 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. (1) Except as provided in 40 CFR 125.30 to 125.32, any existing source subject to this subchapter shall achieve the effluent limitations set forth in sub. (2), (3), or (4) representing the degree of effluent reduction attainable by the application of BPT.

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

Table 1
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.

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

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

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

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

Table 3
Iron and Steel Byproduct Cokemaking

BAT Effluent 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 limitations in par. (d), are allowed for plants with physical chemical pretreatment systems which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

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

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

NR 254.014 New source performance standards. **(1)** The discharge of wastewater pollutants from any new source

subject to this subchapter may not exceed the NSPS in sub. (2), (3), or (4).

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

Table 7
Iron and 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 of 6.0 to 9.0

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

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

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

Table 8
Merchant Byproduct 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.

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

NR 254.015 Pretreatment standards for existing sources. (1) Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the PSES in sub. (2) or (3).

(2) 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.

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

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

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

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.

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

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

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

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% above the limitations in par. (a), are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

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

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.

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

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

Subchapter II — Sintering Subcategory

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

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

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

Table 15
Sintering

BPT 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

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

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

Table 16
Sintering

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

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

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

Table 17
Sintering

NSPS		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	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

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

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

Table 18
Sintering

PSES		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
Ammonia–N(1)	0.0150	0.00501
Cyanide(1)	0.00300	0.000150
Phenols (4AAP)(1)	0.000100	0.0000501
Lead	0.000451	0.000150
Zinc	0.000676	0.000225

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

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

NR 254.026 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.

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

Subchapter III — Ironmaking Subcategory

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

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

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

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

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

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

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

NR 254.032 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

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

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

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

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)	0.00146	
Lead	0.000263	0.0000876
Zinc	0.000394	0.000131

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

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

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

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

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

Table 24
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

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

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

Table 26
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

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

Subchapter IV — Steelmaking Subcategory

NR 254.04 Applicability; description of the steelmaking subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from steelmaking operations conducted in basic oxygen, open hearth, and electric arc furnaces.
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

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

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

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

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

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

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

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

(7) "Wet" means steelmaking air cleaning systems that primarily use water for furnace gas cleaning.
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

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

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

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

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

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

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

Table 31
Wet Suppressed Combustion Basic Oxygen Furnace Steelmaking

NSPS		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 pounds) of product	
TSS	0.0146	0.00522
Lead	0.000188	0.0000626
Zinc	0.000282	0.0000939
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
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

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

Table 33
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

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

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

Table 35
Wet Suppressed Combustion Basic Oxygen Furnace Steelmaking

PSNS		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
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

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

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

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

Subchapter V — Vacuum Degassing Subcategory

NR 254.05 Applicability; description of the vacuum degassing subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from vacuum degassing operations conducted by applying a vacuum to molten steel.

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

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

Table 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

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

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

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

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

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

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

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

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

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

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

Subchapter VI — Continuous Casting Subcategory

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

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

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

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

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

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

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

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

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

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

Table 45
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

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

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

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

Subchapter VII — Hot Forming Subcategory

NR 254.07 Applicability; description of hot forming subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from hot forming operations conducted in primary, section, flat, and pipe and tube mills.
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

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

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

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

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

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

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

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

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

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

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

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

(11) "Specialty steel" means steel products containing alloying elements, such as aluminum, chromium, cobalt, columbium, molybdenum, nickel, titanium, tungsten, vanadium, or zirconium, which are added to enhance the properties of the steel product when individual alloying elements exceed 3% or the total of all alloying elements exceeds 5%.
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

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

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 3 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

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

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

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

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

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

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

NR 254.075 Pretreatment standards for existing sources. Any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211.

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

NR 254.076 Pretreatment standards for new sources. Any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211.

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

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

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

Subchapter VIII — Salt Bath Descaling Subcategory

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

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

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

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

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

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

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

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

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

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

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

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

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	0.00542
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

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

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

Table 69
Sheet And Plate Batch Oxidizing Salt Bath Descaling

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

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

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

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

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

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

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

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

NR 254.087 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BCT:

Table 75
Sheet And Plate Batch Oxidizing Salt Bath Descaling

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

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

Subchapter IX — Acid Pickling Subcategory

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

NR 254.092 Effluent limitations representing the degree of effluent reduction attainable by the application of the best practicable control technology currently available. Except as provided in 40 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BPT:

Table 81
Rod, Wire, and Coil Sulfuric Acid Pickling

BPT Effluent Limitations		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	kg/kkg (pounds per 1,000 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

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

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

Table 97
Rod, Wire, and Coil Sulfuric Acid Pickling

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

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

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 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	0.0146	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

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

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

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

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

Table 128
Rod, Wire, 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

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

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 CFR 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by application of BCT:

Table 143
Rod, Wire, and 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
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

Subchapter X — Cold Forming Subcategory

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

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

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

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

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

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

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

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

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

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

(6) "Single stand" means recirculation or direct application cold rolling mills which include only one stand of work rolls.

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

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

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

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

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

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.

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

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

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	0.0000418
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 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

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

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

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

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

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.

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

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

Table 187
Single Stand 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

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

Subchapter XI — Alkaline Cleaning Subcategory

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

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

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

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

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

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

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

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

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

NR 254.113 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. The effluent limitations representing BAT are identical to the limitations set forth in s. NR 254.112.

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

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

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

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

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

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

NR 254.117 Effluent limitations representing the degree of effluent reduction attainable by the application of the best conventional pollutant control technology. The effluent limitations representing BCT are identical to the limitations set forth in s. NR 254.112.
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

Subchapter XII — Hot Coating Subcategory

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

(2) For zinc, the BPT limitations set forth in s. NR 254.122 and the BAT limitations set forth in s. NR 254.123 are not applicable to hot coating operations with wastewater treatment facilities achieving, during normal production, zinc discharge levels more stringent than the BPT and BAT limitations. For such operations, the BPT and BAT limitations for zinc shall be determined on a case–by–case basis based upon the existing performance of the wastewater treatment facility. The permitting authority shall evaluate effluent data from the wastewater treatment facility during periods of normal production to establish the case–by–case BPT and BAT limitations. The BPT and BAT limitations specified in ss. NR 254.122 and 254.123 may be used for calculating the total mass limitations for zinc pursuant to s. NR 254.003.
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

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

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

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

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

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

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

(6) "Wire products and fasteners" means steel wire, products manufactured from steel wire, and steel fasteners manufactured from steel wire or other steel shapes.
History: Cr. Register, May, 1989, No. 401, eff. 6–1–89.

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

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

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

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

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

BAT Effluent 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

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

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

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

NSPS		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	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

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

NR 254.125 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any

existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the standards set forth in s. NR 254.123.

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

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

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

PSNS		
	Maximum for any 1 day	Average of daily values for 30 consecutive days
Pollutant or pollutant property	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.
(2)Within the range of 6.0 to 9.0

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

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

Table 209
Strip, Sheet, and Miscellaneous Products
Galvanizing, Terne Coating, and Other Coatings

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

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

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

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