FR.PP.01.05

P.T. INTER WORLD STEEL MILLS INDONESIA
MELTING LOG SHEET FOR (MONTHLY VERSION)

E.101

DATE : **1-30 Mei 2025**

ITEM	C III ()			A I (Zae)			B II ()			TOTAL			INCLUDING OFF DAY			TARGET
BILLET TYPE				5-SP2/5-SP1						5-SP2/5-SP1						
HEAT				65						65						
PRODUCTION — Description	Yield (s)		%	YieHd (s)		%	Yield (s)		%	Yield (s)		%	Yield (s)		%	
Scrap				2.231.392						2.231.392						
LQ Metal Yield				2.058.841		92,27				2.058.841		92,27				> 90,0
Billet Yield				1.983.420		88,89				1.983.420		88,89				> 89,0
L.M. Loss				47.200		2,12				47.200		2,12				< 0,75
End Cutting				28.220		1,26				28.220		1,26				< 0,5
Reroute to EAF																
Scrap/Heat				34,33						34,33						36-37 T
Liquid/Heat				31,67						31,67						32-33 T
Billet /Heat				30,51						30,51						31-32 T
BILLET TYPE — **5 SP1 V**																
5 SP2 V																
5 SP1				992.693		50,05				992.693		50,05				
5 SP2				899.283		45,34				899.283		45,34				
3-SP																
NG - SD																
5-SP				91.444		4,61				91.444		4,61				< 5
NG - SR																
ELECTRICAL CONSUMPTION	KWH		KWH/T	KWH		KWH/T	KWH		KWH/T	KWH		KWH/T	KWH		KWH/T	KWH/T
Total Power C.	26.573			1.234.485		622,40	44.324			1.305.382		658,15	1.346.763		679,01	
EAF Power C.				1.051.515		530,15				1.051.515		530,15	1.051.515		530,15	< 460
EAF Counter				1.007.000		507,71				1.007.000		507,71	1.007.000		507,71	< 450
OCM Power C.	2.014			11.155		5,62	3.632			16.801		8,47	26.581		13,40	
AUX Power C.	1.786			13.752		6,93	4.881			20.419		10,29	30.397		15,33	
WT Power.	14.760			71.882		36,24	31.736			118.378		59,68	137.376		69,26	
Compressors.	6.148			19.445		9,80	4.498			30.090		15,17	32.101		16,18	
3.3 KV Dust Colector.	327			61.454		30,98	896			62.677		31,60	62.919		31,72	
O2 380V Power.	38			5.283		2,66	180			5.503		2,77	5.874		2,96	
TIME-PROCESS	UNIT	OK	T-MIN	AVE-MIN	UNIT	OK	T-MIN	AVE	UNIT	OK	T-MIN	AVE	UNIT	OK	T-MIN	AVE	MIN
Fetling					22	22	218	3,4					22	22	218	3,4	≤ 4
Charging					195	56	375	5,8					195	56	375	5,8	≤ 6
Melt Down					65	3	2.854	43,9					65	3	2.854	43,9	≤ 38
Refining					65	34	1.033	15,9					65	34	1033	15,9	≤ 15
Tapping					65	46	343	5,3					65	46	343	5,3	≤ 5
Break Down					9		118						9		118		
T-T							4941	76,0							4941	76,0	≤ 68

KADIV PENGENDALI | KABAG PENGENDALI | Made By

BREAK DOWN & MAINTENANCE

PROCESS — Description	Unit	Min	%	Sub Unit	Sub Min	%
E.T.T.					4941	
A.T.T-B. T-C.T				130	3887	78,67
Fettling 2,95				22	218	4,41
Charging 3,00				195	375	7,59
Melting				65	2854	57,76
Refining				65	1033	20,91
Tapping				65	343	6,94
Sub Total				412	4.823	97,61
BREAK DOWN — Mechanical				1	60	1,21
Electrical				1	9	0,18
Cooling SYM						
Air Compressor SYM						
HYD SYM						
W/T SYM						
D/C SYM						
Oxygen SYM						
O.H. CRANE						
Scrap Car						
Electrode Mast SYM						
Electrode Breakage						
Swinging SYM				1	60	1,21
Tapping CAR/SYM						
Raw Material Charging						
Steel L/D Car						
Sovel Car						
Carbon Injection						
Gunning Material						
Spectrometer						
PLN or S/S Trip						
Electric Equip. Problem				1	9	0,18
Other Delays				4	26	0,53
Sub Total				6	95	1,92
Other Delays — Charge L. Delay				2	7	0,14
Charging Delay				1	16	0,32
Clean elbow of D/C						
Clean Lock Post						
Electrode Added						
L/D Prepair						
CCM Prepair						
JET BURNER						
Sub Total				3	23	0,47
				9	118	2,39

RAW MATERIAL CONSUMPTION

Description	Unit Kg	Actual	T
Coke	18.700	*9,43*	< 35
Carbon Raiser	25.005	*12,61*	
Lime / CaO	73.850	*37,23*	< 35
Mag. Carbon Ball			< 8
Silicon Carbide	2.520	*1,27*	< 5
Ferro Vanadium			
Ferro Silicon	3.840	*1,94*	< 2.5
Silicon Manganese	*33.460*	16,87	< 15.00
LQ Oxygen	103.320	*52,09*	< 60
Graphite Electrode	4.649	*2,34*	< 3.0
Gunning Material	38.900	*19,61*	< 15
T/D Board (Heat/Set)		*65* / *23*	

REFRACTORIES

Description	Supplier	Sub Total Ch	Previous Ch	Target Ch
Roof 1				500
Roof 2				500
Roof 3				500
Roof 5				500
Roof 6	KCD	268		500
T. Spout	CHH	432		800

L/D 1	KCD	49		100
L/D 2	KCD	3		100
L/D 3	KCD	30		100
L/D 6	KCD	26		100
L/D 7	KCD	23		100
L/D 8	KCD	12		100

v Produktivitas = **34,96 T/Hour**

OFF QUALITY & OPERATION

Description	Unit	Heat No	Sub Total
Oxidise LQ. M.			
L/D Lancing	22		22
Return to EAF			
BREAK OUT — ST 1	1		1
2			
3			
4			
CU MOULD CHANGING — ST 1	1		1
2	1		1
3	1		1
4			

OFF IN COMPOSITION

C				
Si				
Mn				
P				
S				
Cu				
Ni				
Cr				
Sn				
V				
T/D BOARD HEAT/SET — A	82/23		82/23	
B				

Total produksi billet sebanyak **1,983,420,00 T** dalam **65 Heat 11 hari kerja**.
Efisiensi Mei'25, **L/S = 92.27% & B/S = 88.89%**

I . Pemakaian *CaO* 37,23 Kg/T Billet melebihi dari target sebesar 35,00 Kg/T Billet , karena Scrap banyak tercampur tanah dan kotoran (Impurities) membuat unsur Phosphor dan Sulfur Tinggi maka di butuhkan tambahan pemakaian CaO untuk mereduksi atau menurunkan ke 2 unsur tersebut ditambah lagi dengan adanya cairan buang H.2530 karena LD bocor sebanyak + 29 T.

II. Pemakaian *Gunning Material* 19,61 Kg/T Billet melebihi dari target sebesar 15,00 Kg/T Billet, karena pada area dinding dapur tipis / erosi pada saat awal star H.2478 9/5/2025 cairan tidak tapping ada breakdown electric kabel WCC rusak dan ditambah adanya cairan buang H.2530 LD bocor + 29 T sehingga harus extra konsumsi Gunning Material untuk mencegah terjadinya kebocoran dinding dapur.

III. Pemakaian *FeSiMn* 16,87 Kg/T Billet melebihi dari target sebesar 15,00 Kg/T Billet, karena adanya cairan buang H.2530 LD bocor + 29 T sehingga menambah konsumsi FeSiMn.