

	<b>VEDANTA LIMITED – VALUE ADDED BUSINESS</b>	<b>Format No.:</b>	<b>VAB/IMS/PID1/PROC ESSCONTROL/0</b>
	<b>INTEGRATED MANAGEMENT SYSTEM</b>	<b>Revision Date:</b>	<b>04.04.2023</b>
	<b>CONTROL PLAN BF1 &amp; 2</b>	<b>Revision No.:</b> <b>Page No.:</b>	<b>00</b> <b>1 of 1</b>

Sl. No.	Critical Parameters	Frequency	Source	Norm s	UOM	Target	Control plan
1	Iron Ore - 8mm fines content	Daily	Lab reports	<3	%	<3	1) Screens to be checked at stock house if chocking find needs to be cleared. 2) To reduce input of Fines need to go for dry screening at raw material. 3) Wet washing of Iron Ore to be done.
2	Top gas pressure	Daily	SAP	0.34-0.40	Kg/CM <sup>2</sup>	0.35	Top Gas pressure to be controlled with ventury regulations.2) Observing the situation of blast furnace if top gas pressure is low than one extra coke to be charged.
3	Top gas temperature	Daily	SAP	>100	Deg C	>100	If top Gas temperature is less than 100 for 4 hrs than 2000 kgs/Ore for one batch is to be reduced. 2) If Required one extra coke to be charged.
4	Hot Blast Temperature	Daily	SAP	>950	Deg C	990	If HBT is less than 990 than for every 20-50 Degree coke rate to be increased by 5 kgs/THM.
5	Number of casts/day	Daily	SAP	>11	nos	12	Furnace running on full wind if no. of cast is reduced due to the problems of clay than wind volume is to be reduced to drain out the hearth.
6	Taphole length	Daily	SAP	>800	mm	>800	If Taphole length is less than for continuous 2-3 cast than with lancing taphole length to be improved. If Still taphole length is not improved than clay lot has to be changed.
7	Hot metal Temperature	Daily	SAP	>1450	Deg C	>1450	If HMT is less for more than 2-3 cast than Extra coke to be charged.If HMT goes below 1300 Degree C than 5 extra coke to be charged and Fe/C to be reduced by 0.20
8	Tuyeres in operation	Daily	Log sheet	8	nos	8	Wind volume to be reduced by maintaing tuyere velocity in the range of 240-260
9	GCS water flow	Daily	SAP	110-150	M3/Hr	140	Pump to be changed over. Pump suction points to be cleared, if no improvement GCS tank cleaning to be taken up
10	CO in gas	Daily	SAP	21-25.5	%	21-25.5	If CO in BFG increases more than 25 than Furnace condition to be reviewed and exrta fuel to be charged & wind volume to be reduced for better utilization of Co gas.IF CO increases by 27 than 5 extra coke to be charged & Coke rate to be increased by 50 kgs/THM.
11	H2 in gas	Daily	SAP	<5	%	<5	If H2 is greater than 3.5 than water ingress in furnace through external source to be checked such as Water top spray, steam injection in Stoves & to be stopped if not required. If H2 is not coming down than furance to be shutdown and tuyere, tuyere cooler & cooling plates to be checked for any water ingress.