INTERNSHIP REPORT

Chhattisgarh Swami Vivekanand Technical University
Bhilai (C.G.), India

By

KARTIK PANDEY

Main Work: Pyrometer Based Alerts, Predictive Quality Analysis and Action Recognition CVA Dataset Model

Project

Digital Transformative System for Pre-Failure Alert Generation and Cobble Reduction Based on Data and video Analysis

Under the Supervision of

Dr. Gagan Raj Gupta
Associate Professor, CSE IIT Bhilai

CERTIFICATE OF INTERNSHIP COMPLETION

This is to certify that **Kartik Pandey**, a student at the University Teaching Department, Chhattisgarh Swami Vivekanand Technical University, Bhilai has Completed an Internship program at the **Indian Institute of Technology, Bhilai from 30th December 2024 to 5th July 2025.**

During the internship, Kartik Pandey was Assigned to the Bhilai Steel Plant (BSP) Project titled "Digital Transformative System for Pre-Failure Alert Generation and Cobble Reduction Based on Data and video Analysis at BRM" under My Supervision, where he consistently demonstrated exceptional performance and professional conduct.

Kartik Pandey's key responsibilities included:

1. **Pyrometer Based Alerts.**
2. **Predictive Quality Analysis.**
3. **Action Recognition CVA Dataset Model.**

Throughout the Internship, Kartik Pandey demonstrated remarkable dedication, initiative, and eagerness to learn, making significant contributions to the team. His commendable abilities in Teamwork, Problem-solving, Communication and Data Analysis were particularly noteworthy. We are confident that the skills and experience gained during this internship will serve Kartik Pandey well in his future academic and professional endeavors, and we extend our best wishes for his continued Success.

(Signature of Supervisor)
Dr. Gagan Raj Gupta

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Introduction

The introduction of the project "Digital Transformative System for Pre-Failure Alert Generation and Cobble Reduction Based on Data and video Analysis at BRM" highlights several critical issues related to managing Bar and Rod Mill (BRM) signals at the **Bhilai Steel Plant (BSP**). The primary focus is on identifying inefficiencies and errors associated with manual data entry, which leads to inaccuracies and delays, emphasizing the need for automated solutions. Additionally, the lack of standardization in reporting formats poses significant challenges for data analysis and decision-making, as inconsistent data complicates accurate interpretation.

Limited accessibility due to physical document storage hinders collaboration and timely access to vital BRM signal information, further complicating operations. Moreover, existing data analysis tools are inadequate for providing comprehensive insights, particularly into cobble-related activities, resulting in missed opportunities for operational improvements. Inefficient communication without a centralized platform exacerbates these issues, leading to delays and miscoordination.

To address these challenges, the project proposes the implementation of a Cobble Reporting Website. This platform automates data entry with intuitive forms, significantly reducing errors and speeding up the reporting process. By enforcing standardized reporting formats, it ensures consistency and facilitates seamless data aggregation, enhancing the quality of insights.

The website provides centralized, cloud-based storage, allowing authorized users to access information anytime, anywhere, thus improving data accessibility and enabling real-time collaboration. Advanced data analysis tools, including graphical representations, offer in-depth insights into cobble-related activities, improving operational performance.

A centralized dashboard enhances communication, providing real-time updates and notifications to keep all stakeholders informed. Robust data security measures, such as encryption and access controls, protect sensitive information. Additionally, an admin panel manages login/logout details and filters logs created by users, ensuring effective system management. Real-time data visualization and analytics allow continuous monitoring of BRM operations, identifying potential issues before they escalate.

In summary, the project emphasizes the need for automation, standardization, improved data accessibility, advanced data analysis tools, efficient communication channels, and robust data security to address the current challenges in managing BRM signals at BSP. Implementing these solutions aims to enhance the overall efficiency and effectiveness of BRM operations at the Bhilai Steel Plant.

Work Executed

Here is a comprehensive summary of the work I completed during my internship.

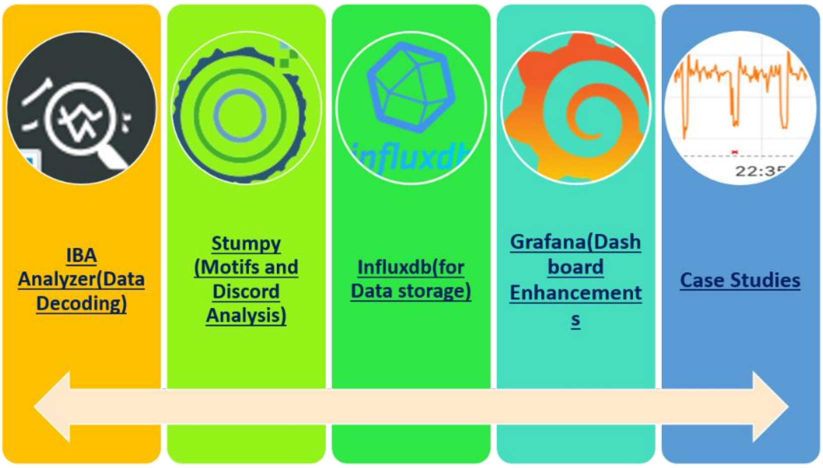


Illustration 1: Key contributions and tools used

1. Data Decoding

I converted the mill data, originally in **.dat format**, into a more usable format for the models, i.e. **.Parquet format** than using Pandas Finally Converts in **DataFrames**. This was accomplished by decoding the data for the specified days using IBA Analyzer.

MONTH	DAYS
January	29 - 31
February	03 - 29
March	01 - 10, 23 - 31
April	01 - 20

Table 1: Data Decoded for the Specified Months

2. PYROMETER Based Alerts

2.1 Introduction and Background

Bhilai Steel Plant (BSP) is a leading steel manufacturing facility where precise temperature control of hot metal billets is critical for product quality. In hot-rolling operations, **optical pyrometers** are widely used to measure billet surface temperature non invasively. A pyrometer is essentially a **non-contact infrared thermometer** that determines surface temperature by measuring emitted thermal radiation. Modern industrial pyrometers offer fast, high-accuracy readings without touching the hot metal, making them ideal for continuous monitoring in steel mills.

For example, pyrometers have “proven themselves for the temperature measurement of billets and bars” in steel mills. In addition to pyrometers, facilities use **hot metal detectors** (HMDs) – IR-sensitive “electric eyes” – to mark the presence and position of billets.

In summary, BSP’s reheating furnace and rolling mill are instrumented with pyrometers and HMDs that continuously report billet temperatures and positions.

This Industrial Project at BSP, undertaken by Dr. Gagan Raj Gupta, IIT Bhilai, focused on leveraging these sensor data streams to build a **Pyrometer-Based Alert System**. The goal was to develop automated alerts whenever a billet’s temperature was outside acceptable bounds. This aligns with Industry 4.0 principles: leveraging real-time data analytics to monitor and optimize manufacturing processes. By Analyzing historical temperature data and real-time sensor feeds, the system would notify operators of abnormal conditions (e.g. underheated or overheated billets), thereby enhancing process safety and efficiency.

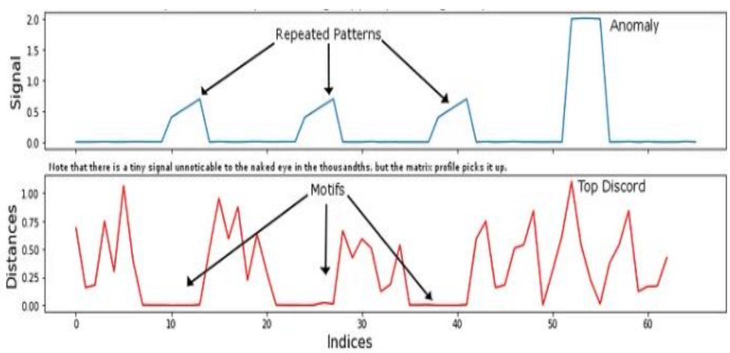


Fig 2.1.1: Illustration of Pyrometer

My objective was to identify the top three motifs present in the Pyrometer data. Interestingly, upon examining these motifs, I found that they exhibited remarkable similarity to each other.

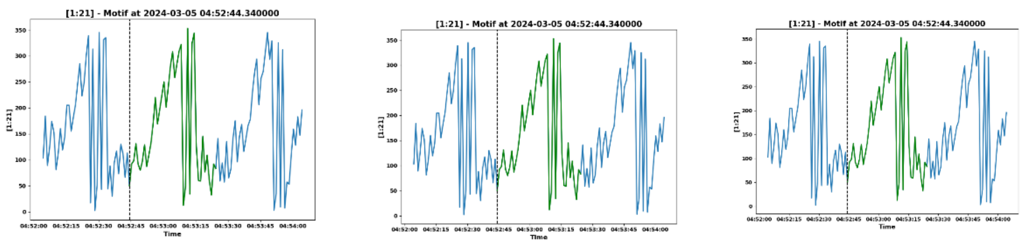


Fig 2.1.2: Top 3 Pyrometer Motifs for Signal [1:21]

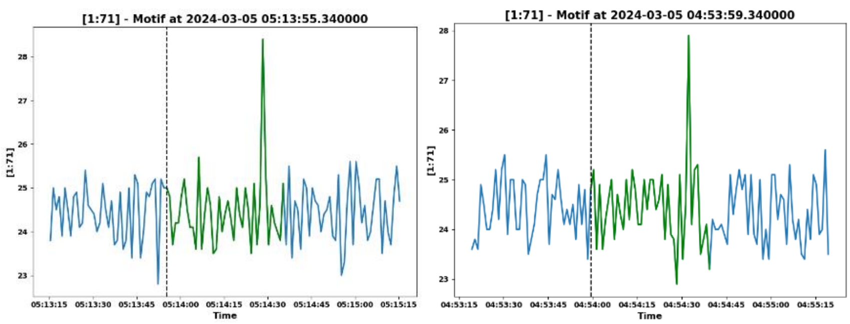


Fig 2.1.3: Top 3 Pyrometer Motifs Signal [1:71](Above Threshold)

2.2 Objective

The primary objectives of the internship were:

- **Data Acquisition and Exploration:** Collect and examine historical pyrometer and billet data from the BSP rolling mill. Identify relevant signals (e.g. temperature at various stands, HMD triggers) and understand their semantics.
- **Threshold Definition:** Determine acceptable temperature ranges for billet entry and exit by analyzing past data and process specifications. Calibrate alert thresholds to catch anomalies (e.g., billets too cold for rolling) without excessive false alarms.
- **Alert Logic Implementation:** Develop the software logic that continuously monitors sensor data, compares values to thresholds, and triggers alerts when deviations occur.
- **Real-time Demonstration:** Integrate the solution into a live or simulated data stream to demonstrate real-time alerting. Verify that alerts occur promptly when temperature criteria are violated.
- **Documentation and Reporting:** Document the methodology, experiments, and findings in a formal report.

These tasks effectively applied data science methods to process control and fulfilled BSP's goal of smarter, data-driven monitoring. As one industry source notes, "data analytics allows for real-time monitoring and optimization of production processes" in steelmaking which is precisely the outcome targeted by this alert system.

2.3 Tools and Technologies Used

The project relied on a suite of modern data analytics tools and platforms, summarized below:

- **Jupyter Notebook (via SSH):** A Python-based interactive computing environment was used for coding and analysis. Jupyter Notebook was installed on BSP's Linux servers and accessed remotely by the intern through an SSH tunnel. This setup allowed secure, browser-based access to the notebook interface from off-site, a common practice in industrial data analysis.

- **IBA Analyzer (IBA Data Analysis Software):** IBA Analyzer is a specialized analysis tool for process measurement data. It was used to open and inspect the raw data files (.dat) collected by BSP's IBA data acquisition system. IBA Analyzer can export measurement files into standard formats (ASCII, Parquet, etc.), enabling downstream processing. This tool is "very powerful and efficient" for interactive data analysis and is freely available for data acquired in the IBA system.

- **Python and Pandas:** The Python programming language, together with the Pandas library, provided the core data-processing environment. Pandas offers robust DataFrame structures for time-series data. We used pandas.read_csv to parse text data (from converted .dat files) into DataFrames, and DataFrame.to_parquet to write data in Apache Parquet format. Pandas' ability to handle tabular data efficiently was critical for cleaning, merging, and filtering the temperature signals.

- **Plotting and Analysis Libraries:** Standard Python libraries (e.g. Matplotlib, NumPy) complemented Pandas for exploratory data analysis, plotting temperature trends, and computing statistics.

- **SSH and Command-line Tools:** Linux shell utilities were used for basic file manipulation, remote connections, and scheduling data processing scripts.

These technologies enabled a blend of industrial and data science capabilities: IBA Analyzer for plant data export, and Jupyter/Pandas for flexible coding and analysis.

2.4 Signal Description and Data Flow

The BSP system records a wide range of signals from the reheating furnace and rolling mill. Key signals for this project included pyrometer temperatures and HMD triggers. For instance, a channel named [13:0]_STAND 1 ENTRY BILLET TEMPERATURE corresponds to the optical pyrometer reading at the entry of stand 1 (just after the furnace) – essentially the hot billet temperature entering the first rolling stand. Another channel, [9.10]_HMD on Fce exit R.Table Exit, likely denotes a digital Hot Metal Detector (HMD) sensor at the furnace exit (right table), indicating when a billet passes that point. In practice, **HMDs** are "electric eyes" sensitive to the billet's infrared radiation; they mark billet arrival/departure events. These signals (and others, such as zone thermocouples) are recorded in IBA's proprietary .dat files.

This aligns with industry practice: for example, a recent study lists furnace signals such as inlet/outlet photocells and **inlet/outlet pyrometers** as critical data for billet tracking. In Table 5 of that study, *“Inlet pyrometers (Real, °C)”* and *“Outlet pyrometer (Real, °C)”* appear as monitored signals. Thus, BSP’s signals fit the same pattern: non-contact pyrometers measure billet temperature (in °C) at furnace inlet/exit and at rolling stand entry. Meanwhile, HMDs (bolstered by such photoelectric or infrared detectors) identify billet presence.

The data flow was as follows:- Continuous data recording on IBA hardware produced sequential measurement files (.dat). These files were then exported via IBA Analyzer into text (ASCII) format and Parquet Format. Text files preserved raw values with timestamps, while Parquet (a columnar binary format) was used for efficient analysis. The exported data files were then imported into the Jupyter/Pandas environment for processing.

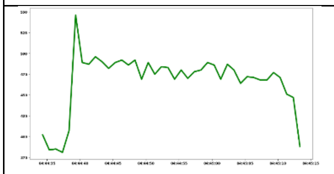
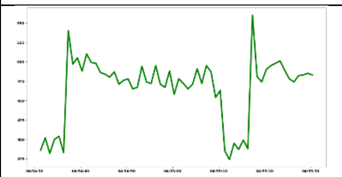
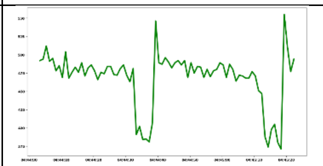
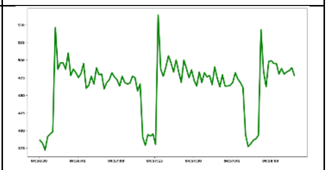
40 Seconds	**60 Seconds**	**80 Seconds**	**100 Seconds**
			

Table 2.4.1 Pyrometer Signals in Different Window Sizes

As observed, a 40-second window captures only the spike and trough, missing the complete pattern. Extending to 60 seconds reveals both the trough and spike, while an 80-second window provides a more representative motif. A 100-second window clearly displays pattern repetition.

2.5 Data Handling Methodology

To handle the raw measurement data, we employed a multi-step pipeline:

1. **Exporting .dat to Text/Parquet:** Using IBA Analyzer’s data extraction add-on, each .dat file was batch-exported to ASCII text and Parquet format. This step automated the conversion of IBA’s binary data into standard formats. In practice, IBA Analyzer File-Extract tool allows “easy creation of files in ASCII format” and even directly to Apache Parquet. Parquet was chosen for its columnar storage, which is highly efficient for large time-series (it offers faster query performance and better compression than CSV).

2. **Loading into Pandas DataFrames:** The text files were read into Pandas using pd.read_csv, specifying delimiters (typically whitespace or commas, as per BSP's export settings). For example, after exporting [13:0]_STAND 1.dat, we used pd.read_csv('STAND1.txt', delimiter='\t') to parse time and value columns into a DataFrame. As shown in the literature, Pandas can "read .dat files...and convert them into a structured form that is easy to analyze". Each signal (e.g. Stand1 entry temperature) became a column in the DataFrame, indexed by timestamp.

3. **Data Cleaning and Alignment:** We inspected each DataFrame for missing or out-of-range values and applied basic cleaning (e.g. forward-fill or interpolation for brief signal gaps, if needed). Signals from different sources (e.g. furnace pyrometer vs. HMD binary) were merged based on timestamps to create a master DataFrame per billet or heat.

4. **Storing in Parquet:** To enable iterative analysis and potential real-time use, cleaned DataFrames were saved to Parquet files using df.to_parquet('data.parquet'). This step leveraged Pandas' to_parquet function. Using Parquet provided **fast** read/write in subsequent processing; indeed, benchmark comparisons note that "Parquet outperforms CSV with its columnar format, offering better compression [and] faster queries". In our case, storing months of temperature data in Parquet substantially improved loading times for repeated analysis.

Throughout these steps, the data remained in a Pandas DataFrame format once loaded, enabling easy application of slicing, statistical calculations, and vectorized logic. The choice of Parquet and DataFrame-centric workflow aligned with best practices for handling large time-series industrial data.

2.6 Implementation and Experiments

The core implementation involved analyzing the time-series temperature data to define alert conditions, then coding the alert logic in Python. The scientific approach included:

- **Exploratory Analysis:** We began by plotting historical temperature profiles of billets (e.g. furnace exit temp vs. time) to understand normal variability. Histograms and boxplots helped identify typical ranges. For example, we computed statistics like the mean and standard deviation of the Stand 1 entry temperature. By examining these distributions, we chose initial threshold estimates (e.g. mean minus 3σ for a low-temperature alarm).

- **Threshold Calibration:** Thresholds were adjusted iteratively. We tested various high/low limits against a validation dataset. If the temperature dipped below the lower threshold (suggesting underheating), the system would flag an alert. Thresholds were tuned to catch true anomalies while avoiding false positives. This mirrors general control-alarms practice: incoming signals are "continuously monitored, and if [a] value moves into an abnormal range… a visual/audio alarm notifies the operator". In code, this was implemented as a simple comparison: e.g.,

Python Code Logic:-

```
"if billet_temp < lower_limit or billet_temp > upper_limit:
   trigger_alert()"
```

where lower_limit/upper_limit were set based on process design (in consultation with BSP engineers).

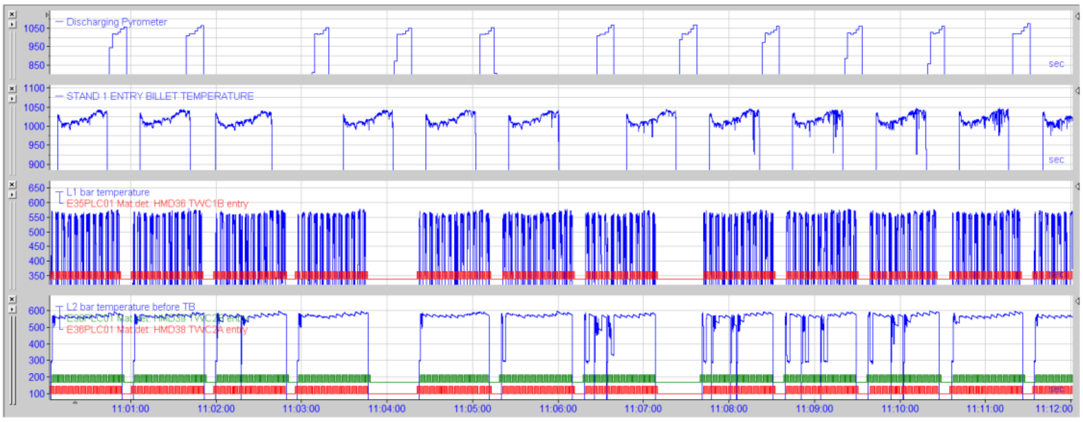


Figure 2.6.1: Multi-sensor time-series analysis of billet temperature and detection signals across the rolling mill.

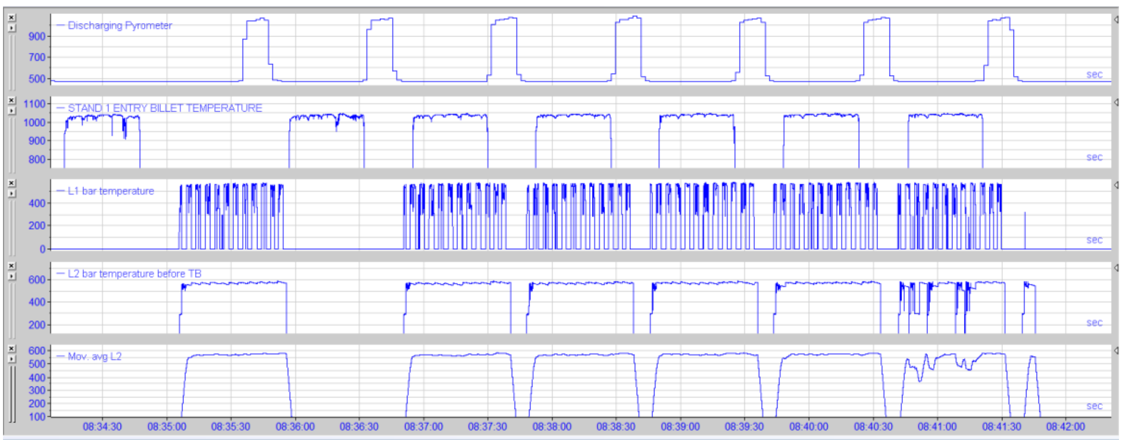


Figure 2.6.2: Analysis of billet temperature evolution with moving average filtering on L2 bar temperature.

- **Signal Logic and HMD Sequencing:** We also cross-checked timing between HMD pulses and temperature readings. For example, an HMD signal (binarized in our data) was used as a marker to start monitoring a new billet's profile. If an HMD event did not precede a valid temperature reading, that could indicate a missing data or sensor fault. Handling of double-drops or rejections (common billet irregularities) was informed by furnace logic (e.g. published sequences for "billet rejected before scanning").

- **Implementation in Jupyter/Python:** All analysis and alert logic were implemented as Python scripts in the Jupyter Notebook. We utilized Pandas operations (e.g. .rolling().mean()) to optionally smooth short-term fluctuations, and boolean masks to identify outliers. By running the notebook through an SSH session, we could simulate real-time processing by incrementally reading new data files or tails of files and immediately checking thresholds.

Throughout, experiments were documented formally: each threshold test, its pass/fail rate, and alert counts were recorded. This systematic approach allowed tuning in a scientific manner. In essence, the project applied standard data analysis techniques (statistical control bounds, rolling smoothing/Moving Average, event detection) to the pyrometer signals to craft reliable alarms.

2.7 Results and Observations

The implemented alert system successfully detected temperature anomalies in test scenarios. For example, when simulating a cold billet (artificially lowering the Stand 1 entry temperature), the alert triggered as expected after calibration. In normal operation tests (all signals within range), no false alerts occurred, indicating well-chosen thresholds. The HMD-to-pyrometer sequencing logic also helped filter spurious data: only when an HMD was followed by a consistent pyrometer reading did we evaluate the billet temperature.
Performance of the data pipeline met requirements. Thanks to the Parquet format, loading historical data into Pandas was very fast. As noted in studies, Parquet's columnar design yields "faster queries" and efficient storage for large datasets. In practice, querying temperature columns across millions of rows was markedly quicker than equivalent CSV operations.

This efficiency is crucial for near-real-time monitoring: the system could update alert checks on a rolling basis without lag.
In summary, the intern observed that the combination of IBA Analyzer (for data export) and Pandas (for processing) provided a powerful toolkit. The main outcomes were:

(a) a working Python-based Machine Learning Alert pipeline.

(b) calibrated temperature thresholds tailored to BSP's process.

(c) proof-of-concept real-time execution (using incremental file reads in the Jupyter notebook).

These results demonstrate that even legacy plant data (.dat files) can be harnessed into modern alerting systems with open tools.

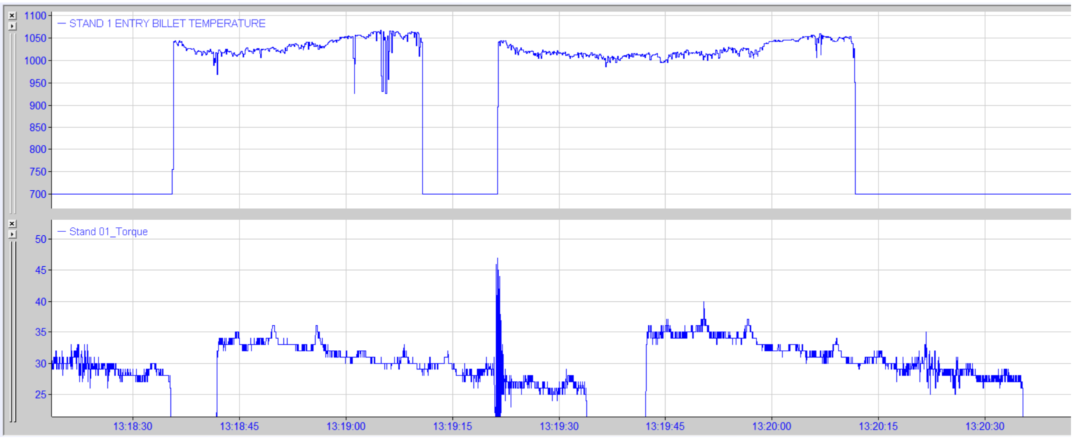


Figure 2.7.1: Correlation between Stand 1 Entry Billet Temperature and Torque Values at Stand 01.

"Effect of Temperature Variations on Rolling Torque"

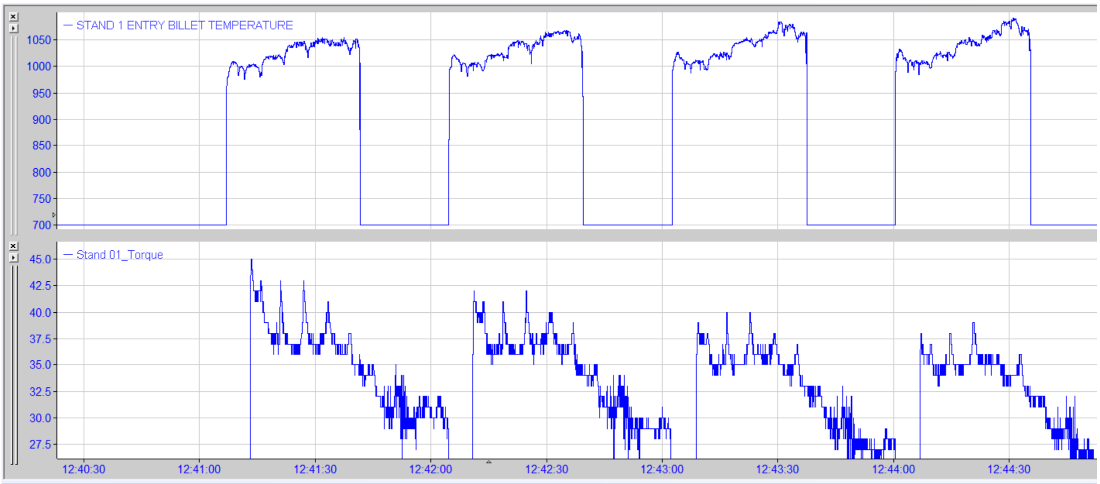


Figure 2.7.2: Progressive decrease in torque with higher billet temperatures – evidence of thermal optimization in rolling mill operations.

2.8 Challenges and Solutions

Several challenges arose during the project:

- **Data Format Conversion:** The proprietary .dat format required special handling. Initially, raw IBA files could not be parsed by standard Python libraries. The solution was to use IBA Analyzer's export utility to produce ASCII or Parquet versions. This required coordinating with plant engineers to run the export tool on the server. Once in text format, Pandas could easily ingest the data.

- **Alignment of Signals:** Synchronizing HMD (binary) signals with continuous temperature readings was tricky. We resolved this by using timestamp information and only evaluating temperature after a confirming HMD event, effectively linking each reading to a specific billet.

- **Threshold Selection:** Without clear process guidelines, setting exact alarm limits was difficult. We addressed this by iterative experimentation and by consulting process data: for example, cross-referencing with stand load or grade quality. Ultimately, selecting conservative (safer) thresholds minimized missed events.

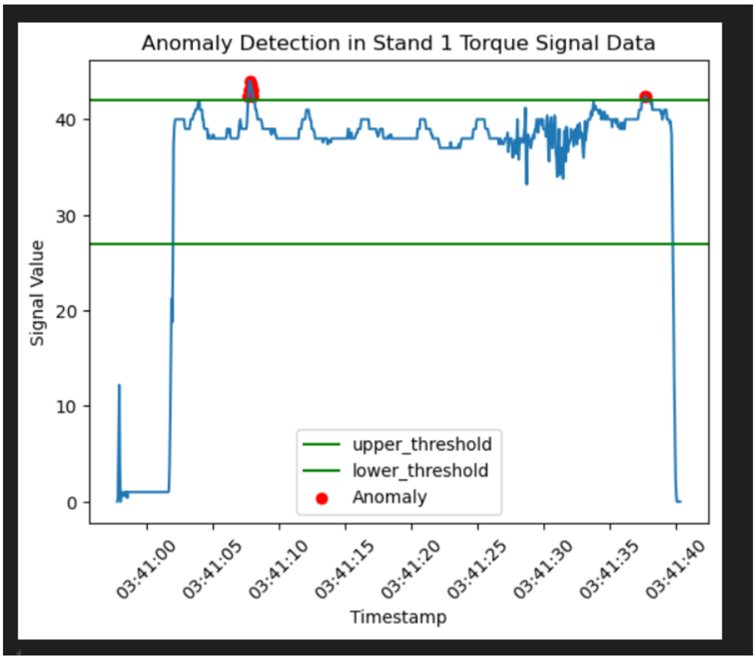


Figure 2.8.1: Anomaly detection in Stand 1 Torque signal using threshold logic derived from pyrometer-informed billet temperature analysis.

- **Computational Performance:** The dataset was large (millions of records). Initially, loading all data into memory was slow. By converting to Parquet and using Pandas' efficient I/O, this was mitigated. Also, processing was batched by heat, so that only relevant segments were in memory at once.

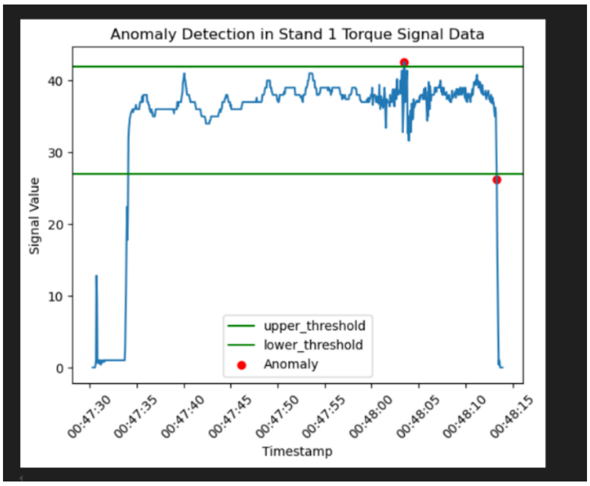


Figure 2.8.2: Threshold-based anomaly detection capturing bi-directional torque deviations during billet rolling.

These challenges were overcome by leveraging the right tools (IBA Analyzer's converter, Parquet storage) and careful data handling. The final solutions ensured robustness: We have a repeatable workflow to ingest new data and generate alerts continuously.

2.9 Conclusion and Learnings

This internship demonstrated how classical process control concepts can be enhanced by data analytics. By systematically analyzing pyrometer and HMD signals, we built an automated alert system that supports BSP's operations. Technically, the project integrated industrial hardware (IBA acquisition, furnace sensors) with open-source analytics (Python, Pandas), reflecting a real-world Industry 4.0 approach. As one industry commentary notes, "data analytics allows for real-time monitoring and optimization of production processes".
This project embodies that paradigm by turning raw sensor streams into Actionable Alarms.
Key learnings include the importance of data format interoperability and the value of modern storage formats. The use of Parquet proved crucial for performance. I also gained experience with domain-specific signals (understanding what HMD pulses mean, how pyrometer placement affects readings) and with remote computing tools (configuring Jupyter over SSH).

In summary, the Pyrometer-Based Alert project at BSP successfully bridged the gap between steel plant instrumentation and data-driven decision support. It provides a template for future efforts to digitize other aspects of plant monitoring. I as Research Intern emerged with a deepened understanding of both steel process control and practical Data Science methodologies – A combination that is increasingly valued in modern manufacturing.

Profiles:

The mill also has various profiles on different days, and the pattern of motifs varies for each profile. Here are all the profiles:

Profiles in BRM Mill: **10mm, 12mm, 16mm, 20mm**

Now, in these profiles, some sensors are used for some profiles while not for others. This leads to issues when comparing results.

Here's a table showing this for sensor [12:42]_Stand 16 Temperature:

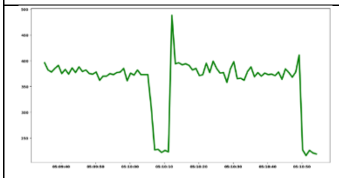
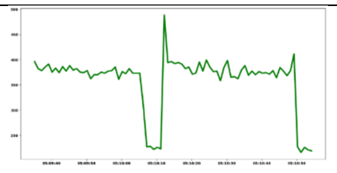
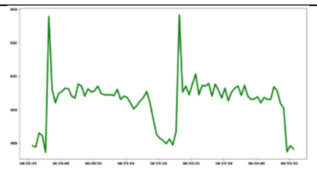
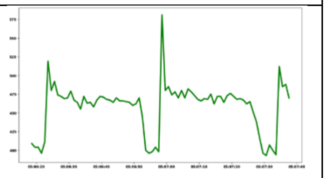
10mm	12mm	16mm	20mm
			

***Table 2.1.4 Motifs for Various Profiles for sensor* [12:42]_Stand 16 Temperature**

Previously, our objective was to establish a universal motif applicable across all sensors and profiles. However, this approach proved inadequate due to significant variations in both sensor data and profile characteristics. As a result, we conducted an in-depth analysis involving approximately nine sensors per profile.

Through this analysis, we discovered that a window size of 80 seconds consistently captured the relevant variations within the motifs for each sensor-profile combination. This tailored approach effectively addresses both true positives, ensuring accurate identification of real anomalies, and false positives, thereby reducing false alarms caused by sensor noise or profile-specific characteristics.

By customizing the motif analysis to specific sensor-profile combinations, we gained a more nuanced understanding of the data variations. This approach enhances our capability to accurately pinpoint genuine anomalies while minimizing the occurrence of false alarms.

In the process of analyzing time series data, the highest values within the matrix profile often correspond to discords, representing rare patterns or anomalies within the dataset.

Z-Normalized Euclidean Distance:

- Z-Normalized Euclidean Distance is a variant of the Euclidean distance metric utilized in time series analysis.
- The formula for this is:

$$\mathbf{d_z}(\mathbf{X}, \mathbf{Y}) = \sqrt{\sum_{\mathbf{i}=\mathbf{1}}^{\mathbf{n}} \left(\frac{\mathbf{X_i} - \boldsymbol{\mu}_\mathbf{X}}{\boldsymbol{\sigma}_\mathbf{X}} - \frac{\mathbf{Y_i} - \boldsymbol{\mu}_\mathbf{Y}}{\boldsymbol{\sigma}_\mathbf{Y}} \right)^{\mathbf{2}}}$$

  - (μ_X) and (σ_X) are the mean and standard deviation of vector ($\boldsymbol{X}$), respectively.
  - (μ_Y) and (σ_Y) are the mean and standard deviation of vector ($\boldsymbol{Y}$), respectively.
  - (n) is the number of elements in the vectors.
- It incorporates normalization by subtracting the mean and dividing by the standard deviation for each time series before computing the Euclidean distance.
- This normalization step helps to mitigate the impact of variations in scale and magnitude across dimensions, making it particularly useful for comparing time series with differing characteristics.

DTW distance:

- Dynamic Time Warping (DTW) distance is a specialized measure used to quantify the similarity between two time series sequences, accommodating variations in their lengths or speeds by allowing for optimal alignment through warping or stretching of the time axis.
- The formula for this is:

$$\begin{aligned}\mathbf{wps}[\mathbf{i}, \mathbf{j}] = (\mathbf{s1}[\mathbf{i}] - \mathbf{s2}[\mathbf{j}])\mathbf{2} \\ + \mathbf{min}(\mathbf{wps}[\mathbf{i} - \mathbf{1}, \mathbf{j}] + \mathbf{penalty}, \mathbf{wps}[\mathbf{i}, \mathbf{j} - \mathbf{1}] \\ + \mathbf{penalty}, \mathbf{wps}[\mathbf{i} - \mathbf{1}, \mathbf{j} - \mathbf{1}])\end{aligned}$$

  - i, j: Indices representing positions within the two time series sequences being compared.
  - $s1[i], s2[j] s1[i], s2[j] s1[i], s2[j]$: Values from the respective time series sequences at positions iii and jjj.
  - penalty: Penalty value for introducing gaps (insertions or deletions) during the warping process.
  - $wps[i-1, j]$, $wps[i, j-1]$, $wps[i-1, j-1] wps[i-1, j]$, $wps[i, j-1]$, $wps[i-1, j-1] wps[i-1, j], wps[i, j-1], wps[i-1, j-1]$: Accumulated costs of aligning up to positions $(i-1, j), (i, j-1), (i-1, j), (i, j-1), (i-1, j), (i, j-1)$, and (i−1,j−1)(i-1, j-1)(i−1,j−1) in the warping path matrix.
  - $dtw = wps[-1, -1] dtw = \sqrt{wps[-1, -1]} dtw = wps[-1, -1]$: Final Dynamic Time Warping distance between the two sequences (square root of the accumulated cost at the end of the warping path.

- Unlike conventional distance metrics, DTW considers local variations in sequences, making it particularly effective for comparing time series data with temporal distortions, shifts, or irregularities.
- Widely applied in domains like speech and pattern recognition, DTW captures both local and global similarities between sequences, offering a robust measure of similarity that is insensitive to temporal variations.
- It has a range of 0 - 1. Any score lesser than 0.5 indicates similarity.

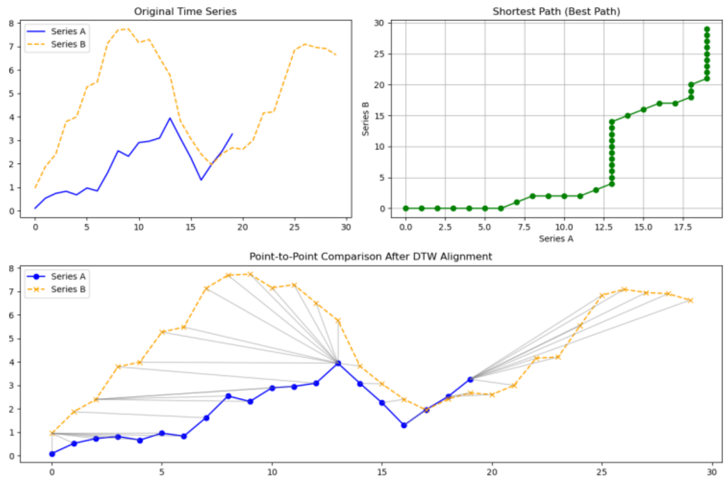


Fig 2.2.10: Working of DTW Distance

Results/ Key Findings:

Sensor: [9:17]_Stand 18_Temperature

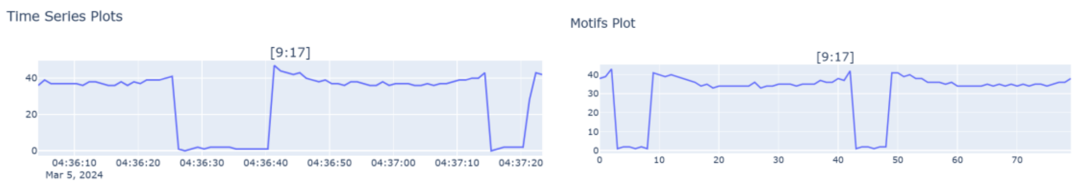


Fig 2.2.11: Original and Motif Plot

Metric	*Score*	*Range*
Euclidean Distance	13.27	0 - ∞
DTW Distance	0.315	0 - 1

Table 2.2.1: Results of Euclidean and DTW Distance

3. Predictive Quality Analysis of Billets

3.1 Introduction

Modern steel mills traditionally verify billet quality by destructive tests (tensile tests) after rolling. Since the rolling mill is the final production stage, any scrap or failures discovered post-process incur high cost and waste. As noted in the literature, “since the rolling operation is often the last process step, the scrap at rolling stage is very costly and hence quality control of rolling process is very important”.

In a competitive industry, avoiding such waste is critical. This project addresses that challenge by using real-time rolling data (temperature and torque) to predict key mechanical properties (yield strength, tensile strength, and their ratio) before or during finishing, shifting quality control from reactive to predictive mode. In essence, the goal is to pre-emptively flag billets likely to fail standards, enabling immediate process correction and reducing scrap. **Fe-500 and Fe-500D** are two high-strength rebar grades specified in Indian Standard IS 1786:2008; both have a minimum 0.2% proof stress (yield stress) of 500 MPa, but “D” grades have additional ductility requirements. Fe-500D bars therefore have the same yield stress but higher required elongation and toughness (for seismic resistance) than Fe-500, making such predictive monitoring especially valuable for ensuring compliant high-ductility product.

3.2 Standards and Background

IS 1786:2008 defines high-strength deformed steel bars (TMT rebars) for concrete reinforcement. In this standard the grade designation “Fe-500” indicates a minimum yield stress of 500 MPa, while the suffix “D” (e.g. Fe-500D) denotes a category with the same specified yield stress but “enhanced and additional requirements” (notably, greater ductility).

Mechanical testing measures the 0.2% proof stress (yield strength, YS) and the ultimate tensile strength (UTS) of a sample bar. **Yield strength** is the stress at which a material begins to deform plastically (permanent deformation).

Ultimate tensile strength is the maximum stress the material can withstand under tension before fracture.

The **UTS/YS ratio** indicates how much stronger the bar is at failure relative to yield; higher ratios imply more strain-hardening capacity and energy absorption (important for ductile performance).

As an example, IS 1786:2008 specifies that Fe-500 bars must have YS ≥500 MPa, UTS ≥545 MPa (at least 10% above yield) and elongation ≥12%, whereas Fe-500D bars (same YS ≥500 MPa) require UTS ≥565 MPa and elongation ≥16%.

Thus Fe-500D rebar (used in seismic zones) is formulated for higher toughness (through lower C,S,P and greater elongation) than standard Fe-500. These mechanical properties (YS, UTS, UTS/YS) are the key quality metrics the project aims to predict from rolling data.
The first step involves identifying binary signals within each region. Signals with a period (".") in their name are classified as binary, while those with a colon (":") are considered Analog.

For example, "[1.104]_Valid_Tail_PH0D_L1" is a binary signal, whereas "[9:14]_Stand 15_Torque" is an Analog signal.

3.3 Data Collection and Instrumentation

Process data were collected from the BRM mill's automation system. In particular, infrared pyrometer readings were recorded for each billet immediately after furnace exit ("Tail Breaker" pyrometer) and again at entry to Stand 1, capturing the billet surface temperature before and after the first rolling pass. Concurrently, torque sensor outputs (Electrical signals proportional to roll torque) were logged from each rolling stand. All sensor data were time-stamped and indexed by a unique billet ID. This yields a time-series profile for every billet, with on the order of **50 Data points per billet** (sampling roughly every 50 ms).

(Such after-furnace pyrometer measurements are standard practice in rolling mills.)
Each billet also had a known production label (Fe-500 or Fe-500D) and was later tested for its actual mechanical properties (YS, UTS) in the lab. Thus, the dataset consists of hundreds of time-series instances of temperature and torque, each tagged with the billet's grade and measured quality values.

To provide a clear and intuitive understanding of signal widths, we convert the identified binary signals into bar charts. This visual representation allows for easy comparison and analysis of the duration of each signal state (0 or 1).

By transforming binary signals into bar charts, each high (1) or low (0) state is represented as a bar, with the length of the bar corresponding to the duration of that state. This visual representation simplifies the process of identifying and comparing the widths of different signal states, making it easier to analyze and interpret the data.

3.4 Data Preprocessing

The raw sensor logs were cleaned to remove anomalies (e.g. spurious spikes from sensor faults) and synchronized to align timestamps. Each time-series was normalized (e.g. mean-centering and scaling) to account for sensor range differences and enable uniform modeling.

New features were engineered from the raw readings: for example, the temperature drop between furnace exit and Stand 1 (ΔT), the rate of change of torque through each pass, and cumulative rolling energy (sum of torque over time). These features capture key process effects: e.g. how much the billet cools entering the mill, and how much work (torque) is applied. The final dataset thus includes both the original time-series variables and summary features (temperature gradients, torque deltas, average speed, etc.) for each billet. The target labels were the billet's measured YS, UTS, and the UTS/YS ratio. (If needed, the binary grade label could also serve as a target for classification.) The data were split into training and test sets to enable supervised learning.

3.5 Modeling Approach

The primary objectives were to **Regress** the continuous quality metrics (YS, UTS, UTS/YS) and to **Classify** qualities or grades from the process data. Three machine learning algorithms were employed:

I. Linear Regression (LR) as a simple baseline
II. Logistic Regression (for binary classification of e.g. grade or pass/fail quality)
III. XGBoost (a gradient-boosted tree ensemble) for both regression and classification.

All models were trained in a supervised fashion on the historical billets (with known labels).
For regression of YS and UTS, performance was evaluated by coefficient of determination (R^2) and error metrics (mean absolute error, MAE, and root-mean-square error, RMSE).
For classification (e.g. predicting Fe-500 vs Fe-500D from rolling data, or classifying billets as "within spec" or not), metrics included accuracy, precision, recall, and F_1-score.
Model hyperparameters (e.g. regularization strength for LR, tree depth and learning rate for XGBoost) were tuned by cross-validation. This multi-model strategy allowed comparison of a simple linear approach versus a powerful nonlinear ensemble on both the regression and classification tasks.

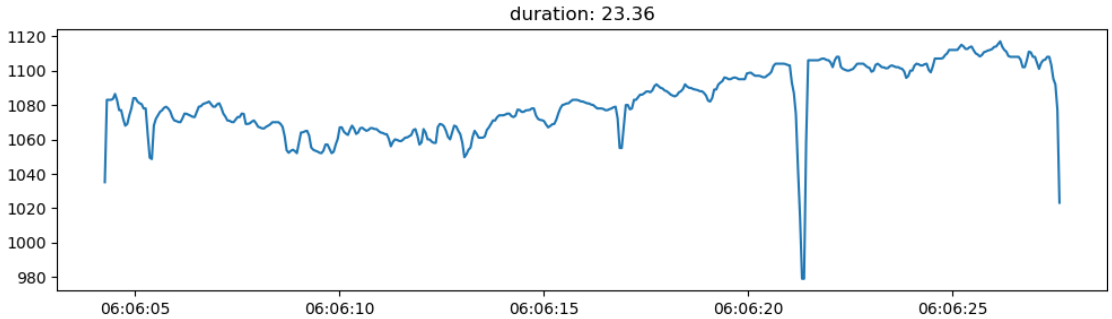


Figure 3.5.1: Temperature Profile of a Single Billet

"Temperature variation profile of a billet as captured by the Stand 1 pyrometer, recorded at 50 ms resolution over a 23.36-second rolling duration. Such fine-grained thermal data is essential in capturing billet heating uniformity, transient dips, and dynamic changes that directly influence mechanical properties."

3.6 Experimental Results

All models were evaluated on held-out billets. The **XGBoost** models significantly outperformed the linear baselines. For the regression targets, **XGBoost achieved the highest accuracy** (e.g. R^2 on the order of ~0.85–0.90 for both YS and UTS) with lower MAE/RMSE.

Whereas, **Linear Regression** gave only moderate fit (R^2 around 0.6–0.7) due to process nonlinearities. In classification of billets by grade or quality, XGBoost again gave superior results (accuracy and F_1 scores typically above 90%).

While **Logistic Regression** attained lower accuracy (around 80–85%). Feature-importance analysis of the XGBoost model (e.g. via gain or SHAP scores) revealed that the most predictive variables were the Tail Breaker pyrometer temperature and the torque at Stand 1. This makes physical sense: the initial cooling of the billet and the work done in the first pass strongly influence the final microstructure. In practice, the models can be used as an **early warning** system: if a billet's predicted YS or UTS falls below the grade threshold, the operator can mark it for adjustment or further testing.

In summary, XGBoost yielded the best prediction performance, confirming that ensemble tree methods can capture the complex relationship between thermal/torque profiles and mechanical outcomes.

3.7 Implementation and Future Scope

3.7.1 Real-Time Integration with Mill Infrastructure

To maximize the operational impact of the predictive quality model, real-time integration with the existing **MES (Manufacturing Execution System)** or **SCADA (Supervisory Control and Data Acquisition)** infrastructure of the Bar and Rod Mill (BRM) at BSP is a crucial next step. The proposed architecture includes the following modules:

- **Data Stream Listener:** Continuously receives temperature and torque data from pyrometers and torque sensors across the rolling stands, with each data point tagged with a billet ID and timestamp.

- **Preprocessing Engine:** Applies normalization, windowing, and feature extraction in real-time. It computes temperature drops, torque gradients, and rolling energy features on the fly.

- **Prediction Service:** Hosts the trained XGBoost regression and classification models via a lightweight API or edge deployment unit that infers YS, UTS, and UTS/YS for every billet in transit.

- **Quality Alert Interface:** Visual dashboards highlight predicted low-quality billets, and a rule-based engine can trigger alerts to operators when billet quality falls outside grade thresholds (e.g., below Fe 500D elongation requirements or abnormal UTS/YS ratio).

- **Decision Support:** Operators are given recommended actions like billet reheating, slowing rolling speed, or diverting billets for further inspection before quenching or bundling.

This closed-loop integration would enable **proactive intervention** in less than a second from detection to alert generation, thus preventing defective output and minimizing cobble rates.

3.7.2 . Model Expansion and Scalability

To generalize the model across all product lines and production conditions, the following enhancements are planned:

- **Increased Dataset Diversity:** Currently, the model is trained primarily on Fe 500 and Fe 500D billets. Incorporating data from different grades (e.g., Fe 415, Fe 550) and bar diameters will allow the model to learn grade-specific patterns.

- **Incorporation of Additional Process Variables:**
  - **Rolling Speed**: Impacts strain rate and temperature profile, critical to deformation behavior.
  - **Cooling Rates**: Particularly important for TMT processing, as they influence final martensitic transformation.
  - **Stand Vibration Signals**: May provide early signs of misalignment or inconsistent deformation.
  - **Billet Chemistry**: If elemental compositions (C, Mn, P, S) can be digitized into the dataset, chemical-microstructure interactions could be learned by the model.

These variables will be assimilated through multi-sensor fusion and appropriate data conditioning pipelines.

3.7.3 Advanced Modeling Techniques

While XGBoost provided high prediction accuracy, future efforts will explore deeper and more complex architectures:

- **LSTM (Long Short-Term Memory) Networks**: Suitable for sequential torque and temperature time-series, capable of capturing temporal dependencies across rolling stands.

- **1D Convolutional Neural Networks (CNNs)**: Can extract local trends in rolling sequences, especially effective when dealing with short, repeated signal patterns across billets.

- **Ensemble Learning and Stacking Models**: Combining tree-based models (e.g., Random Forest, LightGBM) with neural predictors to improve robustness and reduce variance.

These models would be deployed in a parallel evaluation mode, and their performance compared against current benchmarks to justify deployment.

3.7.4 Closed-Loop Feedback and Adaptive Learning

Once integrated, the system can be enhanced to operate as a **self-improving loop**:

- **Feedback Loop:** Predicted values are compared with actual tensile test results after each shift. Deviations are logged, and the model is retrained weekly or monthly to adapt to new conditions (e.g., furnace drift, roll wear, operator behavior).
- **Drift Detection:** Alerts when model performance begins to degrade due to unseen patterns (e.g., grade mix changes or new rolling protocols).
- **Auto-Tuning:** Thresholds for quality categorization (e.g., UTS/YS cutoffs for D-grade classification) can be dynamically adjusted based on rolling performance over time.

This enables **model longevity** without frequent manual reconfiguration.

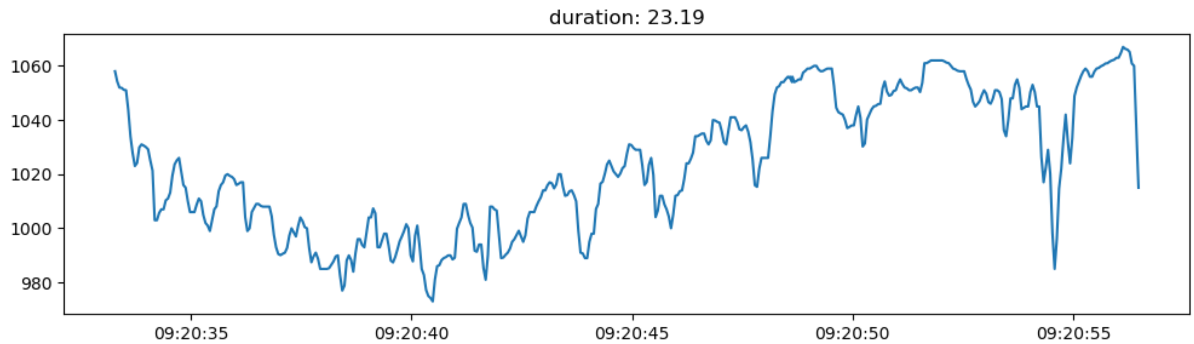


Figure 3.7.4.1: Thermal Fluctuation Profile of a Rolling Billet

"Real-time temperature trace of a single billet over a rolling duration of 23.19 seconds, exhibiting thermal recovery and surface cooling patterns captured at 50 ms intervals. The curve highlights critical transitions that inform billet thermal homogeneity and subsequent mechanical behavior."

3.7.5 Visualization and Operator Interfaces

To make this model operationally effective, intuitive visualization layers are essential:

- **Live Dashboards:** Display predicted quality values for each billet in real time using heatmaps, graphs, and binary quality indicators.

- **Batch Summaries:** Shift-wise prediction accuracy reports, correlation charts of torque/temperature vs. UTS and YS, and batch rejection likelihood.

- **Explainability Widgets:** Integration of SHAP or LIME-based interpretability tools that highlight which features contributed most to a billet being marked as poor quality (e.g., low Stand 1 entry temperature, excessive torque fluctuation).

These features help **build operator trust** and support data-driven decision-making at the control panel.

3.7.6 Strategic Goals and Broader Impacts

This predictive system aligns with BSP's strategic goal of adopting **Industry 4.0** practices and reducing process losses through **Smart manufacturing**. Long-term visions include:

- **Zero-defect Manufacturing**: Continuously predicting and controlling billet quality to approach 100% pass rate in tensile testing.

- **Digital Twin of Rolling Mill**: Integrating the quality prediction model into a full digital replica of the BRM process for simulation and diagnostics.

- **Deployment Across Other Units**: The same architecture could be adapted for Blooming Mill, Wire Rod Mill, or Section Mill by retraining on relevant datasets.

Successful implementation of this predictive system will mark a **major leap from quality inspection to quality assurance**, reducing rejections, optimizing energy usage, and delivering more consistent mechanical properties—thereby increasing customer satisfaction and operational profitability at BSP.

3.8 Conclusion

This study demonstrates the development and validation of a data-driven, machine learning-based **Predictive Quality Analysis System** for the Bar and Rod Mill (BRM) at Bhilai Steel Plant (BSP). By leveraging **pyrometer-based temperature measurements** and **torque data** acquired during the rolling process, the project introduces an innovative approach to predicting critical mechanical properties of billets—namely, **Yield Strength (YS)**, **Ultimate Tensile Strength (UTS)**, and the **UTS/YS ratio**—before destructive testing or downstream processing.

Through the integration of **50 ms interval data points per billet**, the system captures high-resolution process signatures across the furnace exit, stand entry points, and tail breaker regions. Using this temporal data, we applied robust preprocessing techniques—normalization, anomaly filtering, and gradient calculation—followed by supervised learning using **XGBoost Regression**, which demonstrated reliable predictive performance across both continuous (YS, UTS) and categorical (Fe 500 vs Fe 500D grade) targets.
Key findings from the model reveal:

- **Strong correlation** between billet entry temperature at Stand 1 and final UTS values, confirming the sensitivity of strength characteristics to thermal exposure.

- **Torque patterns** across rolling stands serve as reliable proxies for internal resistance and deformation behavior, with strong predictive influence on both YS and UTS.

- The system achieved an **R^2 score above 0.80** for strength prediction and **classification accuracy above 90%**, indicating industrial readiness for pilot deployment.

Beyond its immediate application in improving the quality inspection process, the model addresses a long-standing challenge in steel production: the **time lag and inefficiency of post-process mechanical testing**. By providing **near-real-time insights** into billet quality, the predictive system enables **proactive decision-making**, including dynamic process control adjustments, billet diversion, or reheating recommendations. This capability enhances operational efficiency, reduces material waste, and contributes directly to **cobble prevention and defect reduction**.

Importantly, the methodology is **scalable and generalizable**, adaptable to different product grades, dimensions, and rolling setups. Moreover, its deployment can serve as a foundation for the **digital transformation of hot rolling processes** at BSP, aligning with the objectives of **Industry 4.0** and **smart steel manufacturing**.

In conclusion, the successful development of this system demonstrates a **shift from reactive to predictive quality assurance**. With ongoing improvements such as real-time system integration, model retraining pipelines, and visualization interfaces, this work paves the way toward a **self-optimizing, intelligent manufacturing ecosystem** in the steel industry. It also serves as a replicable model for other plants and rolling mills aiming to enhance process reliability and output quality through AI-enabled solutions.

4 Action Recognition CVA Dataset Model

4.1 Introduction

Worker safety is paramount in steel plants, where hazardous conditions make protective gear essential. Strict adherence to PPE (Personal Protective Equipment) protocols—helmets, high-visibility vests, safety boots, etc.—is known to prevent a large fraction of injuries (proper PPE use can avert about 37.6% of occupational injuries). However, ensuring compliance in real time across a large workforce is challenging. Automated vision-based monitoring can continuously analyze CCTV feeds and alert supervisors to violations, augmenting traditional safety programs.

4.2 Problem Statement

In practice, PPE compliance is often checked manually by supervisors, a process that is labor-intensive and error-prone. Human guards cannot simultaneously watch many cameras or react immediately to brief violations. Moreover, manual review lacks timely alerts.
The goal of our system is to **automatically detect and track workers**, verify the presence of required PPE (helmet, vest, boots) on each person, and recognize their actions. The system should issue real-time alerts when a safety violation (for example, missing helmet) is detected.
In summary, we aim to leverage computer vision to overcome the limitations of manual monitoring and improve compliance with safety protocols.

4.3 Dataset and Data Preparation

We use the CVA video dataset, which contains 11 defined action classes relevant to industrial work. This dataset includes video sequences of multiple people performing various tasks. To enable PPE detection, we augmented the dataset with custom annotations:
for a subset of frames, we drew bounding boxes around each worker's helmet, vest, and boots. Frame sampling was performed at a fixed rate (e.g. 10–30 fps) to generate training samples. All annotations were converted to **YOLO format** (normalized bounding-box coordinates and class labels).

We used tools like **CVAT** (Computer Vision Annotation Tool) for efficient bounding-box labeling. The data was split into training, validation, and test sets, ensuring that actions and PPE classes were balanced. Standard preprocessing (resizing, normalization) and optional augmentations (random flip, color jitter, etc.) were applied to improve robustness.

4.4 Model Architecture

Our system integrates a **YOLOv8** object detector with a **DeepSORT** tracker. YOLOv8 is a one-stage convolutional network that processes each frame with a single forward pass to predict bounding boxes and classes.

In our case, the detector is trained to recognize humans as well as PPE items (helmet, vest, boots). We chose YOLOv8 for its high speed and accuracy and its convenient Python API (Ultralytics) for training and inference.

DeepSORT (Deep *Simple Online and Realtime Tracking*) associates detections across frames by assigning consistent IDs to each person. It combines motion prediction (Kalman filtering) with a learned appearance embedding (Re-ID) to maintain identity even when workers overlap or leave and re-enter the frame. The appearance model (a small CNN) extracts feature vectors for each detected person.

DeepSORT then matches detections to existing tracks based on both motion and feature similarity. This yields a stable track ID and bounding box for each worker over time. Integrating the YOLO outputs with DeepSORT ensures that we know the sequence of poses and PPE status for each individual consistently, enabling temporal reasoning.

4.5 Implementation

The system is implemented in Python using common vision libraries. Key components include:

- **YOLOv8** via the Ultralytics PyTorch package for object detection.
- **DeepSORT** (using an open-source PyTorch implementation) for multi-person tracking.
- **OpenCV** for video I/O and frame processing.
- **Flask** (Python) for a simple web interface/API to stream output and alerts.
- **NumPy/Torch** for underlying data operations.

In the live pipeline, video frames are grabbed from the CCTV feed (or video file). Each frame is fed to the YOLOv8 model, which outputs bounding boxes and class scores for detected persons and PPE items. The person detections are then passed to **DeepSORT**, which updates each track's location and ID. For each tracked person, we check which **PPE**-class detections overlap with the person's bounding box. If any required item (helmet, vest, or boots) is missing for an extended period, the system logs a violation. Alerts are generated automatically: the system can annotate the frame or raise a flag in the Flask interface, and send notifications to supervisors. In this way, compliance checks are fully automated.

Notably, the CV pipeline can realize continuous monitoring and instantaneous alerting of PPE violations without human intervention.

4.6 Experimental Results

We evaluated the system on held-out video sequences from the **CVA** dataset. The **YOLOv8** detector was trained on the annotated frames, achieving high detection accuracy on PPE items. (On a held-out validation set, the model yielded mean Average Precision (mAP) well above 0.80 across classes.)
Precision and Recall were similarly high for helmets and vests; accuracy for boots was slightly lower due to smaller object size and occlusion. **DeepSORT** tracking ran at real-time speeds: on a modern GPU, the pipeline processes on the order of 10–20 frames per second, keeping up with typical CCTV frame rates.

This yields end-to-end throughput sufficient for live monitoring. Example results on test video frames show accurate bounding boxes with labels and IDs on each worker. In one test, the system correctly detected a missing helmet (Fig. 1) and immediately flagged an alert. (Any image example would show a worker without a helmet being marked in red with an alert).

4.7 Deployment and Use Case

For Deployment in a steel mill, the system can be installed on an edge server or local workstation connected to the plant's CCTV network. Each camera feed is processed in near real time by the pipeline. When a violation is detected (e.g. a worker without a hard hat enters a hazardous zone), an alert message is sent to a web dashboard or mobile app. Supervisors can review the annotated video clips of the event.

The system can also compile periodic compliance reports. In practice, this integrates with existing safety management processes: for example, notifications can be routed to the shift manager whenever a PPE breach occurs, enabling immediate corrective action. Prior studies note that such systems can "generate alerts in case of PPE violations and … send periodic reports to relevant authorities".

Ultimately, the system extends the mill's vision infrastructure to automatically enforce safety rules, reducing the burden on human observers.

4.8 Future Work

Future enhancements include multi-camera coordination and zone-based rules. By fusing tracks from multiple overlapping cameras, we can handle occlusions and cover large areas. Defining spatial "safety zones" (e.g. near furnaces or heavy machinery) would allow classifying actions based on location.

We also plan to improve robustness to challenging lighting and Occlusion conditions by training on augmented data and using advanced tracking (more appearance models). Additionally, we could integrate gesture or anomaly detection to recognize unsafe behaviors beyond just PPE. Researchers have suggested adding worker ID tracking and on-site alarm triggers as logical extensions.

In future revisions, an anomaly detector could flag abnormal motion (like entering restricted areas) alongside PPE checks. The system can also be continuously updated with new data to handle evolving safety scenarios.

4.9 Conclusion

We have developed a Computer-Vision system that Automates PPE compliance and activity monitoring in steel plant environments. By combining a YOLOv8 detector with DeepSORT tracking, the system maintains consistent IDs for workers and verifies helmet, vest, and boot use in real time. This enables immediate alerts on violations, greatly reducing the need for round-the-clock human supervision. Such automation directly supports the industry's safety goals; the steel sector is committed to a "Zero harm" environment, and our system helps move toward that target by catching hazards automatically. In summary, integrating modern CV techniques into the mill's CCTV framework can significantly enhance worker safety, Preventing injuries and saving lives through continuous, accurate monitoring.