

## Chapter NR 254

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**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.

**c1d** XAmmonia-NY 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.

**c2d** XBenzeneY means the value obtained by the standard method 602 as set forth in 44 FR 69464 to 69570 cDecember 3, 1979d.

**c3d** XBenzo(a)pyreneY means the value obtained by the standard method 610 as set forth in 44 FR 69464 to 69570 cDecember 3, 1979d.

**c4d** XChromiumY means total chromium as determined by the method set forth in ch. NR 219, table B, for parameter 19.

**c5d** XCopperY means total copper as determined by the method set forth in ch. NR 219, table B, for parameter 22.

**c6d** XCyanideY means total cyanide as determined by the method set forth in ch. NR 219, table B, for parameter 23.

**c7d** XExisting sourceY means any point source, except a new source as defined in sub. c11d, from which pollutants may be discharged either into the waters of the state or into a publicly owned treatment works.

**c8d** XHexavalent chromiumY means the value obtained by the method set forth in ch. NR 219, table B, for parameter 18.

**c9d** XLeadY means total lead as determined by the method set forth in ch. NR 219, table B, for parameter 32.

**c10d** XNaphthaleneY means the value obtained by standard method 610 as set forth in 44 FR 69464 to 69571 cDecember 3, 1979d.

**c11d** XNew sourceY, 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.

**c12d** XNickelY means total nickel as determined by the method set forth in ch. NR 219, table B, for parameter 37.

**c13d** XO&GY means the value for oil and grease obtained by the method set forth in ch. NR 219, table B, for parameter 41.

**c14d** XpHY means the value obtained by the method set forth in ch. NR 219, table B, for parameter 28.

**c15d** XPhenols c4AAPdY means the value obtained by the method set forth in ch. NR 219, table B, for parameter 48.

**c16d** XTetrachloroethyleneY means the value obtained by standard method 610 as set forth in 44 FR 69464 to 69571 cDecember 3, 1979d.

**c17d** XTRCY 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.

**c18d** XTSSY means the value obtained for total suspended solids by the method set forth in ch. NR 219, table B, for parameter 55.

**c19d** XZincY 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.** **c1d** Except as provided in subs. c4d and c5d, 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.

**c2d** 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.

**c3d** 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.

**c4d** If the application of alternative effluent limitations results in a violation of any applicable water quality standard, alternative effluent limitations are not permitted.

**c5d** 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.** **c1d** 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.

**c2d** 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.

**c3d** 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.** **c1d** Any existing source subject to this chapter which discharges to waters of the state shall achieve:

cad the effluent limitations representing BPT by July 1, 1977; and

cbd the effluent limitations representing BAT by July 1, 1984.

**c2d** Any new source subject to this chapter which discharges to waters of the state shall achieve NSPS at the commencement of discharge.

**c3d** Any existing source subject to this chapter which introduces process wastewater pollutants into a POTW shall achieve PSES by July 10, 1985.

**c4d** 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 c4AAPd.** Removal allowances pursuant to s. NR 211.13 may be granted for phenols c4AAPd limited by this chapter when phenols c4AAPd 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:

**c1d** XBeehive cokemakingY 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.

**c2d** XByproduct cokemakingY 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.

**c3d** XMerchant byproduct cokemakingY 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.

**c4d** XIron and steel byproduct cokemakingY means byproduct cokemaking operations other than merchant cokemaking operations.

**c5d** XWet desulfurization systemY means systems which remove sulfur compounds from coke oven gases and produce contaminated process wastewater.

**c6d** XIndirect ammonia recovery systemY means systems

which recover ammonium hydroxide as a byproduct from coke oven gases and waste ammonia liquors.

**c7d** XPhysical chemical treatment systemY 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.** **c1d** 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. c2d, c3d, or c4d representing the degree of effluent reduction attainable by the application of BPT.

**c2d** IRON AND STEEL BYPRODUCT COKEMAKING. cad The following BPT effluent limitations apply:

| Pollutant or pollutant property | Maximum for | Average of daily               |
|---------------------------------|-------------|--------------------------------|
|                                 | any 1 day   | values for 30 consecutive days |
| TSS                             | 0.253       | 0.131                          |
| O&G                             | 0.0327      | 0.0109                         |
| Ammonia-N                       | 0.274       | 0.0912                         |
| Cyanide                         | 0.0657      | 0.0219                         |
| Phenols c4AAPd                  | 0.00451     | 0.00150                        |
| pH                              | c1d         | c1d                            |

c1d Within the range of 6.0 to 9.0

cbd Increased loadings, not to exceed 11% above the limitations in par. cad, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

ccd Increased loadings, not to exceed 27% above the limitations in par. cad, are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

**c3d** MERCHANT BYPRODUCT COKEMAKING. cad The following BPT effluent limitations apply:

| Pollutant or pollutant property | Maximum for | Average of daily               |
|---------------------------------|-------------|--------------------------------|
|                                 | any 1 day   | values for 30 consecutive days |
| TSS                             | 0.270       | 0.140                          |
| O&G                             | 0.0349      | 0.0116                         |
| Ammonia-N                       | 0.292       | 0.0973                         |
| Cyanide                         | 0.0701      | 0.0234                         |
| Phenols c4AAPd                  | 0.00481     | 0.00160                        |
| pH                              | c1d         | c1d                            |

c1d Within the range of 6.0 to 9.0

cbd Increased loadings, not to exceed 10% above the limitations in par. cad, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

ccd Increased loadings, not to exceed 25% above the limitations in par. cad, are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

**c4d** BEEHIVE COKE MAKING. 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.** **c1d** 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. **c2d**, **c3d**, or **c4d** representing the degree of effluent reduction attainable by the application of BAT.

**c2d** IRON AND STEEL BYPRODUCT COKE MAKING. **cad** The following BAT effluent limitations apply:

Table 3  
Iron and Steel Byproduct Cokemaking  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Ammonia-N                       | 0.0543   | 0.0160  |
| Cyanide                         | 0.00638  | 0.00351   |
| Phenols c4AAPd                  | 0.0000638  | 0.0000319                                       |
| Benzene                         | 0.0000319  |   |
| Naphthalene                     | 0.0000319  |   |
| Benzocadpyrene                  | 0.0000319  |   |

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

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

**cdd** 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Ammonia-N                       | 0.0645   | 0.0322  |
| Phenols c4AAPd                  | 0.0000859  | 0.0000430                                       |
| Benzene                         | 0.0000215  |   |
| Naphthalene                     | 0.0000215  |   |
| Benzocadpyrene                  | 0.0000215  |   |

**ced** Increased loadings, not to exceed 24% above the limitations in par. **cdd**, 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.

**c3d** MERCHANT BYPRODUCT COKE MAKING. **cad** The following BAT effluent limitations apply:

Table 5  
Merchant Byproduct Cokemaking  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Ammonia-N                       | 0.0603   | 0.0177  |
| Cyanide                         | 0.00709  | 0.00390   |
| Phenols c4AAPd                  | 0.0000709  | 0.0000355                                       |
| Benzene                         | 0.0000355  |   |
| Naphthalene                     | 0.0000355  |   |
| Benzocadpyrene                  | 0.0000355  |   |

**cbd** Increased loadings, not to exceed 15% above the limitations in par. **cad**, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

**ccd** Increased loadings, not to exceed 35% of the limitations in par. **cad**, are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

**cdd** 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Ammonia-N                       | 0.0751   | 0.0375  |
| Phenols c4AAPd                  | 0.000100   | 0.0000501                                       |
| Benzene                         | 0.0000250  |   |
| Naphthalene                     | 0.0000250  |   |
| Benzocadpyrene                  | 0.0000250  |   |

**ced** Increased loadings, not to exceed 21% above the limitations in par. **cdd**, 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.

**c4d** BEEHIVE COKE MAKING. 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.**  
**c1d** The discharge of wastewater pollutants from any new source subject to this subchapter may not exceed the NSPS in sub. **c2d**, **c3d**, or **c4d**.

**c2d** IRON AND STEEL BYPRODUCT COKEMAKING. **cad** The following NSPS apply:

Table 7  
Iron and Steel Byproduct Cokemaking  
NSPS

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>kg{kkc pounds per 1,000 poundsd of product |
|---------------------------------|---|---|
| TSS                             | 0.172   | 0.0894  |
| O&G                             | 0.00638   |   |
| Ammonia-N                       | 0.0543  | 0.0160  |
| Cyanide                         | 0.00638   | 0.00351   |
| Phenols c4AAPd                  | 0.0000638   | 0.0000319   |
| Benzene                         | 0.0000319   |   |
| Naphthalene                     | 0.0000319   |   |
| Benzocadpyrene                  | 0.0000319   |   |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

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

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

**c3d** MERCHANT BYPRODUCT COKEMAKING. **cad** The following NSPS apply:

Table 8  
Merchant Byproduct Cokemaking  
NSPS

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>kg{kkc pounds per 1,000 poundsd of product |
|---------------------------------|---|---|
| TSS                             | 0.192   | 0.0993  |
| O&G                             | 0.00709   |   |
| Ammonia-N                       | 0.0603  | 0.0177  |
| Cyanide                         | 0.00709   | 0.00390   |
| Phenols c4AAPd                  | 0.0000709   | 0.0000355   |
| Benzene                         | 0.0000355   |   |
| Naphthalene                     | 0.0000355   |   |
| Benzocadpyrene                  | 0.0000355   |   |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

**cbd** Increased loadings, not to exceed 15% above the limitations in par. **cad**, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

**ccd** Increased loadings, not to exceed 35% above the limitations in par. **cad**, are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

**c4d** 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.** **c1d** 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. **c2d** or **c3d**.

**c2d** IRON AND STEEL BYPRODUCT COKEMAKING. **cad** The following PSES apply:

Table 9  
Iron and Steel Byproduct Cokemaking  
PSES

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>kg{kkc pounds per 1,000 poundsd of product |
|---------------------------------|---|---|
| Ammonia-N                       | 0.0645  | 0.0322  |
| Cyanide                         | 0.0172  | 0.00859   |
| Phenols c4AAPd                  | 0.0430  | 0.0215  |

**cbd** Increased loadings, not to exceed 24% above the limitations in par. **cad**, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

**ccd** Increased loadings, not to exceed 58% above the limitations in par. **cad**, are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

**c3d** MERCHANT BYPRODUCT COKEMAKING. **cad** The following PSES apply:

Table 10  
Merchant Byproduct Cokemaking  
PSES

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>kg{kkc pounds per 1,000 poundsd of product |
|---------------------------------|---|---|
| Ammonia-N                       | 0.0751  | 0.0375  |
| Cyanide                         | 0.0200  | 0.0100  |
| Phenols c4AAPd                  | 0.0501  | 0.0250  |

**cbd** Increased loadings, not to exceed 21% above the limitations in par. **cad**, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

**ccd** Increased loadings, not to exceed 50% above the limitations in par. **cad**, 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.** **c1d** 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. **c2d** or **c3d**.

**c2d** IRON AND STEEL BYPRODUCT COKEMAKING. **cad** The following PSNS apply:

Table 11  
Iron and Steel Byproduct Cokemaking

| PSNS  |                       |                                |
|---|-----------------------|--------------------------------|
| Pollutant or pollutant property             | Maximum for any 1 day | Average of daily               |
|   |                       | values for 30 consecutive days |
| kg{kkg cpounds per 1,000 poundsd of product |                       |                                |
| Ammonia-N                                   | 0.0645                | 0.0322                         |
| Cyanide                                     | 0.0172                | 0.00859                        |
| Phenols c4AAPd                              | 0.0430                | 0.0215                         |

cbd Increased loadings, not to exceed 24% above the limitations in par. cad, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

ccd Increased loadings, not to exceed 58% above the limitations in par. cad, are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

c3d MERCHANT BYPRODUCT COKEMAKING. cad The following PSNS apply:

Table 12  
Merchant Byproduct Cokemaking

| PSNS  |                       |                                |
|---|-----------------------|--------------------------------|
| Pollutant or pollutant property             | Maximum for any 1 day | Average of daily               |
|   |                       | values for 30 consecutive days |
| kg{kkg cpounds per 1,000 poundsd of product |                       |                                |
| Ammonia-N                                   | 0.0751                | 0.0375                         |
| Cyanide                                     | 0.0200                | 0.0100                         |
| Phenols c4AAPd                              | 0.0501                | 0.0250                         |

cbd Increased loadings, not to exceed 21% above the limitations in par. cad, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

ccd Increased loadings, not to exceed 50% above the limitations in par. cad, 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.** c1d 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. c2d, c3d, or c4d representing the degree of effluent reduction attainable by the application of BCT.

c2d IRON AND STEEL BYPRODUCT COKEMAKING. cad The following BCT effluent limitations apply:

Table 13  
Iron And Steel Byproduct Cokemaking

| BCT Effluent Limitations                    |                       |                                |
|---|-----------------------|--------------------------------|
| Pollutant or pollutant property             | Maximum for any 1 day | Average of daily               |
|   |                       | values for 30 consecutive days |
| kg{kkg cpounds per 1,000 poundsd of product |                       |                                |
| TSS   | 0.253                 | 0.131                          |
| O&G   | 0.0327                | 0.0109                         |
| pH  | c1d                   | c1d                            |

c1d Within the range of 6.0 to 9.0

cbd Increased loadings, not to exceed 11% above the limitations in par. cad, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

ccd Increased loadings, not to exceed 27% above the limitations in par. cad, are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

c3d MERCHANT BYPRODUCT COKEMAKING. cad The following BCT effluent limitations apply:

Table 14  
Merchant Byproduct Cokemaking

| BCT Effluent Limitations                    |                       |                                |
|---|-----------------------|--------------------------------|
| Pollutant or pollutant property             | Maximum for any 1 day | Average of daily               |
|   |                       | values for 30 consecutive days |
| kg{kkg cpounds per 1,000 poundsd of product |                       |                                |
| TSS   | 0.270                 | 0.140                          |
| O&G   | 0.0348                | 0.0116                         |
| pH  | c1d                   | c1d                            |

c1d Within the range of 6.0 to 9.0

cbd Increased loadings, not to exceed 10% above the limitations in par. cad, are allowed for plants which have wet desulfurization systems but only to the extent that such systems generate an increased effluent volume.

ccd Increased loadings, not to exceed 25% above the limitations in par. cad, are allowed for plants which include indirect ammonia recovery systems but only to the extent that such systems generate an increased effluent volume.

c4d 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                    |                       |                                |
|---|-----------------------|--------------------------------|
| Pollutant or pollutant property             | Maximum for any 1 day | Average of daily               |
|   |                       | values for 30 consecutive days |
| kg{kkg cpounds per 1,000 poundsd of product |                       |                                |
| TSS   | 0.0751                | 0.0250                         |
| O&G   | 0.0150                | 0.00501                        |
| pH  | c1d                   | c1d                            |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| Ammonia-Nc1d                    | 0.0150  | 0.00501   |
| Cyanidec1d                      | 0.00300   | 0.00150   |
| Phenols c4AAPdc1d               | 0.0001000   | 0.0000501                                       |
| TRCc1d                          | 0.000250  |   |
| Lead                            | 0.000451  | 0.000150  |
| Zinc                            | 0.000676  | 0.000225  |

c1d The limitations for ammonia-N, cyanide, and phenols c4AAPd 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| TSS                             | 0.0200  | 0.00751   |
| O&G                             | 0.00501   |   |
| Ammonia-Nc1d                    | 0.0150  | 0.00501   |
| Cyanidec1d                      | 0.00100   | 0.000501  |
| Phenols c4AAPdc1d               | 0.000100  | 0.0000501                                       |
| TRCc1d                          | 0.000250  |   |
| Lead                            | 0.000451  | 0.000150  |
| Zinc                            | 0.000676  | 0.000225  |
| pH                              | c2d   | c2d   |

c1d The limitations for ammonia-N, cyanide, phenols c4AAPd, and TRC shall be applicable only when sintering wastewaters are treated with ironmaking wastewaters.

c2d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| Ammonia-Nc1d                    | 0.0150  | 0.00501   |
| Cyanidec1d                      | 0.00300   | 0.000150  |
| Phenols c4AAPdc1d               | 0.000100  | 0.0000501                                       |
| Lead                            | 0.000451  | 0.000150  |
| Zinc                            | 0.000676  | 0.000225  |

c1d The limitations for ammonia-N, cyanide and phenols c4AAPd 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| Ammonia-Nc1d                    | 0.0150  | 0.00501   |
| Cyanidec1d                      | 0.00100   | 0.000501  |
| Phenols c4AAPdc1d               | 0.000100  | 0.0000501                                       |
| Lead                            | 0.000451  | 0.000150  |
| Zinc                            | 0.000676  | 0.000225  |

c1d The limitations for ammonia-N, cyanide and phenols c4AAPd 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 iron-making 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:

**c1d** XExisting indirect dischargersY means only the 2 iron blast furnace operations with discharges to POTWs prior to May 27, 1982.

**c2d** XFerromanganese blast furnaceY means those blast furnaces which produce molten iron containing more than 50% manganese.

**c3d** XIron blast furnaceY 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c1d |
|---------------------------------|--|--|
| TSS                             | 0.0782   | 0.0260   |
| Ammonia-N                       | 0.161  | 0.0537   |
| Cyanide                         | 0.0234   | 0.00782  |
| Phenols c4AAPd                  | 0.00626  | 0.00210  |
| pH                              | c1d  | c1d  |

c1d Within the range of 6.0 to 9.0

Table 21  
Ferromanganese Blast Furnace  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c1d |
|---------------------------------|--|--|
| TSS                             | 0.313  | 0.104  |
| Ammonia-N                       | 1.29   | 0.429  |
| Cyanide                         | 0.469  | 0.156  |
| Phenols c4AAPd                  | 0.0624   | 0.0208   |
| pH                              | c1d  | c1d  |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c1d |
|---------------------------------|--|--|
| Ammonia-N                       | 0.00876  | 0.00292  |
| Cyanide                         | 0.00175  | 0.000876   |
| Phenols c4AAPd                  | 0.0000584  | 0.0000292  |
| TRCc1d                          | 0.00146  |  |
| Lead                            | 0.000263   | 0.0000876  |
| Zinc                            | 0.000394   | 0.000131   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.0117   | 0.00438  |
| O&G                             | 0.00292  |  |
| Ammonia-N                       | 0.00876  | 0.00292  |
| Cyanide                         | 0.000584   | 0.000292   |
| Phenols c4AAPd                  | 0.0000584  | 0.0000292  |
| TRCc1d                          | 0.000146   |  |
| Lead                            | 0.000263   | 0.0000876  |
| Zinc                            | 0.000394   | 0.000131   |
| pH                              | c2d  | c2d  |

c1d The limitations for TRC shall be applicable only when iron making wastewater is chlorinated.

c2d 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                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| Ammonia-N                       | 0.00876                                     | 0.00292   |
| Cyanide                         | 0.00175                                     | 0.000876  |
| Phenols c4AAPd                  | 0.0000584                                   | 0.0000292                                       |
| Lead                            | 0.000263                                    | 0.0000876                                       |
| Zinc                            | 0.000394                                    | 0.000131  |

Table 25  
Existing Indirect Dischargers

| PSES                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| Ammonia-N                       | 0.0350                                      | 0.0175  |
| Cyanide                         | 0.00175                                     | 0.000876  |
| Phenols c4AAPd                  | 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                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| Ammonia-N                       | 0.00876                                     | 0.00292   |
| Cyanide                         | 0.000584                                    | 0.000292  |
| Phenols c4AAPd                  | 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 steel-making 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:

**c1d** XBasic oxygen furnace steelmakingY means the production of steel from any combination of molten iron, steel scrap, and fluxes in refractory lined furnaces by adding oxygen.

**c2d** XElectric arc furnace steelmakingY 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.

**c3d** XOpen combustionY 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.

**c4d** XOpen hearth furnace steelmakingY 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.

**c5d** XSemi-wetY 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.

**c6d** XSuppressed combustionY 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.

**c7d** XWetY 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

| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0312                                      | 0.0104  |
| pH                              | c1d   | c1d   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0687                                      | 0.0229  |
| pH                              | c1d   | c1d   |

c1d 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

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

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

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.0146                | 0.00522   |
| Lead                            | 0.000188              | 0.0000626                                       |
| Zinc                            | 0.000282              | 0.0000939                                       |
| pH                              | c1d                   | c1d   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.0321                | 0.0115  |
| Lead                            | 0.000413              | 0.000138  |
| Zinc                            | 0.000620              | 0.000207  |
| pH                              | c1d                   | c1d   |

c1d 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

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

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

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

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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>cld |
|---------------------------------|--|--|
| TSS                             | 0.0156   | 0.00521  |
| pH                              | cld  | cld  |

cld 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>cld |
|---------------------------------|--|--|
| 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>cld |
|---------------------------------|--|--|
| TSS                             | 0.00730  | 0.00261  |
| Lead                            | 0.0000939  | 0.0000313  |
| Zinc                            | 0.000141   | 0.0000469  |
| pH                              | cld  | cld  |

cld 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>cld |
|---------------------------------|--|--|
| 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>cld |
|---------------------------------|--|--|
| 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>cld |
|---------------------------------|--|--|
| TSS                             | 0.0780   | 0.0260   |
| O&G                             | 0.0234   | 0.0078   |
| pH                              | cld  | cld  |

cld 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0000313<br>0.0000141<br>0.0000469 |
|---------------------------------|--|--|
| 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.00261<br>0.00104<br>0.0000313<br>0.0000469<br>c1d |
|---------------------------------|--|--|
| TSS                             | 0.00730  | 0.00261  |
| O&G                             | 0.00313  | 0.00104  |
| Lead                            | 0.0000939  | 0.0000313  |
| Zinc                            | 0.000141   | 0.0000469  |
| pH                              | c1d  | c1d  |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0000313<br>0.0000469 |
|---------------------------------|--|---|
| 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0000313<br>0.0000469 |
|---------------------------------|--|---|
| 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:

**c1d** XCarbon hot forming operationY means hot forming operations which produce a majority, on a tonnage basis, of carbon steel products.

**c2d** XCarbon steely means steel products other than specialty steel products.

**c3d** XHot formingY means steel operations in which solidified heated steel is shaped by rolls.

**c4d** XHot strip and sheet millY means steel hot forming operations that produce flat hot-rolled products other than plates.

**c5d** XPipe and tube millY means steel hot forming operations that produce butt welded or seamless tubular products.

**c6d** XPlate millY 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.

**c7d** XPrimary millY 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.

**c8d** XScarfingY 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.

**c9d** XSection millY 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.

**c10d** XSpecialty hot forming operationY means all hot forming operations other than carbon hot forming operations.

**c11d** XSpecialty steely 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0561<br>c1d |
|---------------------------------|--|--|
| TSS                             | 0.150  | 0.0561   |
| O&G                             | 0.0374   |  |
| pH                              | c1d  | c1d  |

c1d Within the range of 6.0 to 9.0



Table 48  
Carbon and Specialty Primary Mills With Scarfing  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.221  | 0.0830  |
| O&G                             | 0.0553   |   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 49  
Carbon Section Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 3 consecutive days |
|---------------------------------|--|--|
| TSS                             | 0.357  | 0.134  |
| O&G                             | 0.0894   |  |
| pH                              | c1d  | c1d  |

c1d Within the range of 6.0 to 9.0

Table 50  
Specialty Section Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.224  | 0.0841  |
| O&G                             | 0.0561   |   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 51  
Carbon and Specialty Hot Strip and Sheet Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.427  | 0.160   |
| O&G                             | 0.107  |   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 52  
Carbon Plate Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.227  | 0.0851  |
| O&G                             | 0.0568   |   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 53  
Specialty Plate Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.100  | 0.0376  |
| O&G                             | 0.0250   |   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 54  
Carbon and Specialty Pipe and Tube Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.212  | 0.0795  |
| O&G                             | 0.0530   |   |
| pH                              | c1d  | c1d   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.0150   | 0.00563   |
| O&G                             | 0.00373  |   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 56  
Carbon and Specialty Primary Mills With Scarfing  
NSPS

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.0234   | 0.00876   |
| O&G                             | 0.00584  |   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 57  
Carbon Section Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0334                                      | 0.0125  |
| O&G                             | 0.00834                                     |   |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

Table 58  
Specialty Section Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0217                                      | 0.00813   |
| O&G                             | 0.00542                                     |   |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

Table 59  
Carbon and Specialty Hot Strip and Sheet Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0435                                      | 0.0163  |
| O&G                             | 0.0109                                      |   |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

Table 60  
Carbon Plate Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0234                                      | 0.00876   |
| O&G                             | 0.00584                                     |   |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

Table 61  
Specialty Plate Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0100                                      | 0.00375   |
| O&G                             | 0.00250                                     |   |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

Table 62  
Carbon and Specialty Pipe and Tube Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0369                                      | 0.0138  |
| O&G                             | 0.00917                                     |   |
| pH                              | c1d   | c1d   |

c1d 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:

**c1d** XBatchY means descaling operations in which the products are processed in discrete batches.

**c2d** XContinuousY means descaling operations that remove surface scale from sheet or wire products in continuous processes.

**c3d** XOxidizing salt bath descalingY means the removal of scale from semi-finished steel products by the action of molten salt baths other than those containing sodium hydride.

**c4d** XPipe and tube batchY means descaling operations that remove surface scale from pipe and tube products in batch processes.

**c5d** XReducing salt bath descalingY means the removal of scale from semi-finished steel products by the action of molten salt baths containing sodium hydride.

**c6d** XRod and wire batchY means descaling operations that remove surface scale from rod and wire products in batch processes.

**c7d** XSheet and plate batchY 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0876 |
|---------------------------------|---|---|
| TSS                             | 0.204   | 0.0876  |
| Chromium                        | 0.00292   | 0.00117   |
| Nickel                          | 0.00263   | 0.000876  |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

Table 64  
Rod And Wire Batch Oxidizing Salt Bath Descaling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.00701 |
|---------------------------------|---|--|
| TSS                             | 0.123   | 0.0526   |
| Chromium                        | 0.00175   | 0.000701   |
| Nickel                          | 0.00158   | 0.000526   |
| pH                              | c1d   | c1d  |

c1d Within the range of 6.0 to 9.0

Table 65  
Pipe And Tube Batch Oxidizing Salt Bath Descaling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.00213 |
|---------------------------------|---|--|
| TSS                             | 0.496   | 0.213  |
| Chromium                        | 0.00709   | 0.00284  |
| Nickel                          | 0.00638   | 0.00213  |
| pH                              | c1d   | c1d  |

c1d Within the range of 6.0 to 9.0

Table 66  
Continuous Oxidizing Salt Bath Descaling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.000413 |
|---------------------------------|---|---|
| TSS                             | 0.0964  | 0.0413  |
| Chromium                        | 0.00138   | 0.000551  |
| Nickel                          | 0.00124   | 0.000413  |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

Table 67  
Batch Reducing Salt Bath Descaling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.000407 |
|---------------------------------|---|---|
| TSS                             | 0.0949  | 0.0407  |
| Cyanide                         | 0.00102   | 0.000339  |
| Chromium                        | 0.00136   | 0.00542   |
| Nickel                          | 0.00122   | 0.000407  |
| pH                              | c1d   | c1d   |

c1d Within the range of 6.0 to 9.0

Table 68  
Continuous Reducing Salt Bath Descaling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.00190 |
|---------------------------------|---|--|
| TSS                             | 0.532   | 0.228  |
| Cyanide                         | 0.00569   | 0.00190  |
| Chromium                        | 0.00759   | 0.00304  |
| Nickel                          | 0.00683   | 0.00228  |
| pH                              | c1d   | c1d  |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.00117 |
|---------------------------------|---|--|
| Chromium                        | 0.00292   | 0.00117  |
| Nickel                          | 0.00263   | 0.000876   |

Table 70  
Rod And Wire Batch Oxidizing Salt Bath Descaling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.000526 |
|---------------------------------|---|---|
| Chromium                        | 0.00175   | 0.000701  |
| Nickel                          | 0.00158   | 0.000526  |

Table 71  
Pipe And Tube Batch Oxidizing Salt Bath Descaling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromium                        | 0.00709  | 0.00284   |
| Nickel                          | 0.00638  | 0.00213   |

Table 72  
Continuous Oxidizing Salt Bath Descaling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromium                        | 0.00138  | 0.000551  |
| Nickel                          | 0.00124  | 0.000413  |

Table 73  
Batch Reducing Salt Bath Descaling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.204  | 0.0876  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 76  
Rod And Wire Batch Oxidizing Salt Bath Descaling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.123  | 0.0526  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 77  
Pipe And Tube Batch Oxidizing Salt Bath Descaling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.496  | 0.213   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 78  
Continuous Oxidizing Salt Bath Descaling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.0964   | 0.0413  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 79  
Batch Reducing Salt Bath Descaling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.0949   | 0.0407  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0



Table 80  
Continuous Reducing Salt Bath Descaling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.532                 | 0.228   |
| pH                              | c1d                   | c1d   |

c1d 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:

**c1d XAcid recoveryY** means sulfuric acid pickling operations that include processes for recovering the unreacted acid from spent pickling solutions.

**c2d XAcid regenerationY** means hydrochloric acid pickling operations that include processes for regenerating acid from spent pickling solutions.

**c3d XBar, billet, and bloomY** means acid pickling operations that pickle bar, billet, or bloom products.

**c4d XBatchY** means pickling operations which process steel products such as coiled wire, rods, and tubes in discrete batches or bundles.

**c5d XCombination acid picklingY** 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.

**c6d XContinuousY** means pickling operations other than batch operations.

**c7d XFume scrubberY** means pollution control devices used to remove and clean fumes originating in the pickling operations.

**c8d XHydrochloric acid picklingY** means operations in which steel products are immersed in hydrochloric acid solutions to chemically remove oxides and scale and the associated rinsing operations.

**c9d XNeutralizationY** means acid pickling operations that do not include acid recovery or acid regeneration.

**c10d XPipe, tube, and otherY** 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.

**c11d XRod, wire, and coilY** means acid pickling operations that pickle rod, wire, or coiled rod and wire products.

**c12d XSpent acid solutionY** means solutions of steel pickling acids which have been used in the pickling process and are discharged or removed.

**c13d XStrip, sheet, and plateY** means acid pickling operations that pickle strip, sheet, or plate products.

**c14d XSulfuric acid picklingY** 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

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.0818                | 0.0350  |
| O&Gc1d                          | 0.0350                | 0.0117  |
| Lead                            | 0.000526              | 0.000175  |
| Zinc                            | 0.000701              | 0.000234  |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 82  
Bar, Billet, and Bloom Sulfuric Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.0263                | 0.0113  |
| O&Gc1d                          | 0.0113                | 0.0375  |
| Lead                            | 0.000169              | 0.0000563                                       |
| Zinc                            | 0.000225              | 0.0000751                                       |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 83  
Strip, Sheet, and Plate Sulfuric Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.0526                | 0.0225  |
| O&Gc1d                          | 0.0225                | 0.00751   |
| Lead                            | 0.000338              | 0.000113  |
| Zinc                            | 0.000451              | 0.000150  |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 84  
Pipe, Tube, and Other Products Sulfuric Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0626 |
|---------------------------------|---|---|
| TSS                             | 0.146   | 0.0626  |
| O&Gc1d                          | 0.0626  | 0.0209  |
| Lead                            | 0.000939  | 0.000313  |
| Zinc                            | 0.00125   | 0.000417  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 85  
Sulfuric Acid Pickling Fume Scrubbers  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days<br>2.45 |
|---------------------------------|--|---|
| TSS                             | 5.72   | 2.45  |
| O&Gc1d                          | 2.45   | 0.819   |
| Lead                            | 0.0368   | 0.0123  |
| Zinc                            | 0.0491   | 0.0164  |
| pH                              | c2d  | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 86  
Rod, Wire, and Coil Hydrochloric Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0613 |
|---------------------------------|---|---|
| TSS                             | 0.143   | 0.0613  |
| O&Gc1d                          | 0.0613  | 0.0204  |
| Lead                            | 0.000920  | 0.000307  |
| Zinc                            | 0.00123   | 0.000409  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 87  
Strip, Sheet, and Plate Hydrochloric Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0350 |
|---------------------------------|---|---|
| TSS                             | 0.0818  | 0.0350  |
| O&Gc1d                          | 0.0350  | 0.0117  |
| Lead                            | 0.000526  | 0.000175  |
| Zinc                            | 0.000701  | 0.000234  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 88  
Pipe, Tube, and Other Products Hydrochloric Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.128 |
|---------------------------------|---|--|
| TSS                             | 0.298   | 0.128  |
| O&Gc1d                          | 0.128   | 0.0426   |
| Lead                            | 0.00192   | 0.000638   |
| Zinc                            | 0.00255   | 0.000851   |
| pH                              | c2d   | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 89  
Hydrochloric Acid Pickling Fume Scrubbers  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days<br>2.45 |
|---------------------------------|--|---|
| TSS                             | 5.72   | 2.45  |
| O&Gc1d                          | 2.45   | 0.819   |
| Lead                            | 0.0368   | 0.0123  |
| Zinc                            | 0.0491   | 0.0164  |
| pH                              | c2d  | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 90  
Absorber Vent Scrubber Wastewater  
From Hydrochloric Acid Regeneration  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days<br>16.3 |
|---------------------------------|--|---|
| TSS                             | 38.2   | 16.3  |
| O&Gc1d                          | 16.3   | 5.45  |
| Lead                            | 0.245  | 0.0819  |
| Zinc                            | 0.327  | 0.109   |
| pH                              | c2d  | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 91  
Rod, Wire, and Coil Combination Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>0.0638 |
|---------------------------------|---|---|
| TSS                             | 0.149   | 0.0638  |
| O&Gc1d                          | 0.0638  | 0.0213  |
| Chromium                        | 0.00213   | 0.000852  |
| Nickel                          | 0.00192   | 0.000638  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 92  
Bar, Billet, and Bloom Combination Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.0672                | 0.0288  |
| O&Gc1d                          | 0.0288                | 0.00960   |
| Chromium                        | 0.000960              | 0.000384  |
| Nickel                          | 0.000864              | 0.000288  |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 93  
Strip, Sheet, and Plate Continuous  
Combination Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.438                 | 0.188   |
| O&Gc1d                          | 0.188                 | 0.0626  |
| Chromium                        | 0.00626               | 0.00250   |
| Nickel                          | 0.00563               | 0.00188   |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 94  
Strip, Sheet, and Plate Batch Combination Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.134                 | 0.0576  |
| O&Gc1d                          | 0.0576                | 0.0192  |
| Chromium                        | 0.00192               | 0.000768  |
| Nickel                          | 0.00173               | 0.000576  |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 95  
Pipe, Tube, and Other Products Combination Acid Pickling  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.225                 | 0.0964  |
| O&Gc1d                          | 0.0964                | 0.0322  |
| Chromium                        | 0.00322               | 0.00129   |
| Nickel                          | 0.00289               | 0.000964  |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 96  
Combination Acid Pickling Fume Scrubbers  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 5.72                  | 2.45  |
| O&Gc1d                          | 2.45                  | 0.819   |
| Chromium                        | 0.0819                | 0.0327  |
| Nickel                          | 0.0735                | 0.0245  |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d 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

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| Lead                            | 0.000526              | 0.000175  |
| Zinc                            | 0.000701              | 0.000234  |

Table 98  
Bar, Billet, and Bloom Sulfuric Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| Lead                            | 0.000169              | 0.0000563                                       |
| Zinc                            | 0.000225              | 0.0000751                                       |

Table 99  
Strip, Sheet, and Plate Sulfuric Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| Lead                            | 0.000338              | 0.000113  |
| Zinc                            | 0.000451              | 0.000150  |

Table 100  
Pipe, Tube, and Other Products Sulfuric Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| Lead                            | 0.000939              | 0.000313  |
| Zinc                            | 0.00125               | 0.000417  |

Table 101  
Sulfuric Acid Pickling Fume Scrubbers  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Lead                            | 0.0368   | 0.0123  |
| Zinc                            | 0.0491   | 0.0164  |

Table 102  
Rod, Wire, and Coil Hydrochloric Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Lead                            | 0.000920   | 0.000307  |
| Zinc                            | 0.00123  | 0.000409  |

Table 103  
Strip, Sheet, and Plate Hydrochloric Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Lead                            | 0.000526   | 0.000175  |
| Zinc                            | 0.000701   | 0.000234  |

Table 104  
Pipe, Tube, and Other Products Hydrochloric Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Lead                            | 0.00192  | 0.000638  |
| Zinc                            | 0.00255  | 0.000851  |

Table 105  
Hydrochloric Acid Pickling Fume Scrubbers  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Lead                            | 0.0368   | 0.0123  |
| Zinc                            | 0.0491   | 0.0164  |

Table 106  
Absorber Vent Scrubber Wastewater From Hydrochloric Acid Regeneration  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Lead                            | 0.245  | 0.0819  |
| Zinc                            | 0.327  | 0.109   |

Table 107  
Rod, Wire, and Coil Combination Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromium                        | 0.00213  | 0.000852  |
| Nickel                          | 0.00192  | 0.000638  |

Table 108  
Bar, Billet, and Bloom Combination Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromium                        | 0.000960   | 0.000384  |
| Nickel                          | 0.000864   | 0.000288  |

Table 109  
Strip, Sheet, and Plate Continuous Combination Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromium                        | 0.00626  | 0.00250   |
| Nickel                          | 0.00563  | 0.00188   |

Table 110  
Strip, Sheet, and Plate Batch Combination Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromium                        | 0.00192  | 0.000768  |
| Nickel                          | 0.00173  | 0.000576  |

Table 111  
Pipe, Tube, and Other Products Combination Acid Pickling  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromium                        | 0.00322  | 0.00129   |
| Nickel                          | 0.00289  | 0.000964  |

Table 112  
Combination Acid Pickling Fume Scrubbers  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| 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                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0146                                      | 0.00626   |
| O&Gc1d                          | 0.00626                                     | 0.00209   |
| Lead                            | 0.0000939                                   | 0.0000313                                       |
| Zinc                            | 0.000125                                    | 0.0000417                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 114  
Bar, Billet, and Bloom Sulfuric Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.00876                                     | 0.00376   |
| O&Gc1d                          | 0.00376                                     | 0.00125   |
| Lead                            | 0.0000563                                   | 0.0000188                                       |
| Zinc                            | 0.0000751                                   | 0.0000250                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 115  
Strip, Sheet, and Plate Sulfuric Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0117                                      | 0.00501   |
| O&Gc1d                          | 0.00501                                     | 0.00167   |
| Lead                            | 0.0000751                                   | 0.0000250                                       |
| Zinc                            | 0.000100                                    | 0.0000334                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 116  
Pipe, Tube, and Other Products Sulfuric Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0204                                      | 0.00876   |
| O&Gc1d                          | 0.00876                                     | 0.00292   |
| Lead                            | 0.000131                                    | 0.0000438                                       |
| Zinc                            | 0.000175                                    | 0.0000584                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 117  
Sulfuric Acid Pickling Fume Scrubbers

| NSPS                            |                                   |   |
|---------------------------------|-----------------------------------|---|
| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|                                 | kg per day for each fume scrubber |   |
| TSS                             | 5.72                              | 2.45  |
| O&Gc1d                          | 2.45                              | 0.819   |
| Lead                            | 0.0368                            | 0.0123  |
| Zinc                            | 0.0491                            | 0.0164  |
| pH                              | c2d                               | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 118  
Rod, Wire, and Coil Hydrochloric Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0175                                      | 0.00751   |
| O&Gc1d                          | 0.00751                                     | 0.00250   |
| Lead                            | 0.000113                                    | 0.0000376                                       |
| Zinc                            | 0.000150                                    | 0.0000501                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 119  
Strip, Sheet, and Plate Hydrochloric Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0117                                      | 0.00501   |
| O&Gc1d                          | 0.00501                                     | 0.00167   |
| Lead                            | 0.0000751                                   | 0.0000250                                       |
| Zinc                            | 0.000100                                    | 0.0000334                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 120  
Pipe, Tube, and Other Products Hydrochloric Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0321                                      | 0.0138  |
| O&Gc1d                          | 0.0138                                      | 0.00459   |
| Lead                            | 0.000206                                    | 0.0000688                                       |
| Zinc                            | 0.000275                                    | 0.0000918                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 121  
Hydrochloric Acid Pickling Fume Scrubbers

| NSPS                            |                                   |   |
|---------------------------------|-----------------------------------|---|
| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|                                 | kg per day for each fume scrubber |   |
| TSS                             | 5.72                              | 2.45  |
| O&Gc1d                          | 2.45                              | 0.819   |
| Lead                            | 0.0368                            | 0.0123  |
| Zinc                            | 0.0491                            | 0.0164  |
| pH                              | c2d                               | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 122  
Rod, Wire, and Coil Combination Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0204                                      | 0.00876   |
| O&Gc1d                          | 0.00876                                     | 0.00292   |
| Chromium                        | 0.000292                                    | 0.000117  |
| Nickel                          | 0.000263                                    | 0.0000876                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 123  
Bar, Billet, and Bloom Combination Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0117                                      | 0.00501   |
| O&Gc1d                          | 0.00501                                     | 0.00167   |
| Chromium                        | 0.000167                                    | 0.0000667                                       |
| Nickel                          | 0.000150                                    | 0.0000501                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 124  
Strip, Sheet, and Plate Continuous Combination Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0496                                      | 0.0213  |
| O&Gc1d                          | 0.0213                                      | 0.00710   |
| Chromium                        | 0.000710                                    | 0.000284  |
| Nickel                          | 0.000638                                    | 0.000213  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 125  
Strip, Sheet, and Plate Batch Combination Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0175                                      | 0.00751   |
| O&Gc1d                          | 0.00751                                     | 0.00250   |
| Chromium                        | 0.000250                                    | 0.000100  |
| Nickel                          | 0.000225                                    | 0.0000751                                       |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 126  
Pipe, Tube, and Other Products Combination Acid Pickling

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0292                                      | 0.0125  |
| O&Gc1d                          | 0.0125                                      | 0.00418   |
| Chromium                        | 0.000418                                    | 0.000167  |
| Nickel                          | 0.000376                                    | 0.000125  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 127  
Combination Acid Pickling Fume Scrubbers

| NSPS                            |                                   |   |
|---------------------------------|-----------------------------------|---|
| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|                                 | kg per day for each fume scrubber |   |
| TSS                             | 5.72                              | 2.45  |
| O&Gc1d                          | 2.45                              | 0.819   |
| Chromium                        | 0.0819                            | 0.0327  |
| Nickel                          | 0.0735                            | 0.0245  |
| pH                              | c2d                               | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d 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                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Lead                            | 0.0000939                                  | 0.0000313                                       |
| Zinc                            | 0.000125                                   | 0.0000417                                       |

Table 129  
Bar, Billet, and Bloom Sulfuric Acid Pickling

| PSNS                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Lead                            | 0.0000563                                  | 0.0000188                                       |
| Zinc                            | 0.0000751                                  | 0.0000250                                       |

Table 130  
Strip, Sheet, and Plate Sulfuric Acid Pickling

| PSNS                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Lead                            | 0.0000751                                  | 0.0000250                                       |
| Zinc                            | 0.000100                                   | 0.0000334                                       |

Table 131  
Pipe, Tube, and Other Products Sulfuric Acid Pickling

| PSNS                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Lead                            | 0.000131                                   | 0.0000438                                       |
| Zinc                            | 0.000175                                   | 0.0000584                                       |

Table 132  
Sulfuric Acid Pickling Fume Scrubbers

| PSNS                            |                                   |   |
|---------------------------------|-----------------------------------|---|
| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|                                 | 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                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Lead                            | 0.000113                                   | 0.0000376                                       |
| Zinc                            | 0.000150                                   | 0.0000501                                       |

Table 134  
Strip, Sheet, and Plate Hydrochloric Acid Pickling

| PSNS                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Lead                            | 0.0000751                                  | 0.0000250                                       |
| Zinc                            | 0.000100                                   | 0.0000334                                       |

Table 135  
Pipe, Tube, and Other Products Hydrochloric Acid Pickling

| PSNS                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Lead                            | 0.000206                                   | 0.0000688                                       |
| Zinc                            | 0.000275                                   | 0.0000918                                       |

Table 136  
Hydrochloric Acid Pickling Fume Scrubbers

| PSNS                            |                                   |   |
|---------------------------------|-----------------------------------|---|
| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|                                 | 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                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Chromium                        | 0.000292                                   | 0.000117  |
| Nickel                          | 0.000263                                   | 0.0000876                                       |

Table 138  
Bar, Billet, and Bloom Combination Acid Pickling

| PSNS                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Chromium                        | 0.000167                                   | 0.0000667                                       |
| Nickel                          | 0.000150                                   | 0.0000501                                       |

Table 139  
Strip, Sheet, and Plate Continuous Combination Acid Pickling

| PSNS                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Chromium                        | 0.000710                                   | 0.000284  |
| Nickel                          | 0.000638                                   | 0.000213  |

Table 140  
Strip, Sheet, and Plate Batch Combination Acid Pickling  
PSNS

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| Chromium                        | 0.000250  | 0.000100  |
| Nickel                          | 0.000225  | 0.0000751                                       |

Table 141  
Pipe, Tube, and Other Products Combination Acid Pickling  
PSNS

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| Chromium                        | 0.000418  | 0.000167  |
| Nickel                          | 0.000376  | 0.000125  |

Table 142  
Combination Acid Pickling Fume Scrubbers  
PSNS

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| TSS                             | 0.0819  | 0.0350  |
| O&Gc1d                          | 0.0350  | 0.0117  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 144  
Bar, Billet, and Bloom Sulfuric Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| TSS                             | 0.0263  | 0.0113  |
| O&Gc1d                          | 0.0113  | 0.00376   |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 145  
Strip, Sheet, and Plate Sulfuric Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| TSS                             | 0.0526  | 0.0225  |
| O&Gc1d                          | 0.0225  | 0.00751   |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 146  
Pipe, Tube, and Other Products Sulfuric Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| TSS                             | 0.146   | 0.0626  |
| O&Gc1d                          | 0.0626  | 0.0209  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 147  
Sulfuric Acid Pickling Fume Scrubbers  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 5.72   | 2.45  |
| O&Gc1d                          | 2.45   | 0.819   |
| pH                              | c2d  | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 148  
Rod, Wire, and Coil Hydrochloric Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|---|---|
| TSS                             | 0.143   | 0.0613  |
| O&Gc1d                          | 0.0613  | 0.0204  |
| pH                              | c2d   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 149  
Strip, Sheet, and Plate Hydrochloric Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.0819   | 0.0350   |
| O&Gc1d                          | 0.0350   | 0.0117   |
| pH                              | c2d  | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 150  
Pipe, Tube, and Other Products Hydrochloric Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.298  | 0.128  |
| O&Gc1d                          | 0.128  | 0.0426   |
| pH                              | c2d  | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 151  
Hydrochloric Acid Pickling Fume Scrubbers  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 5.72   | 2.45   |
| O&Gc1d                          | 2.45   | 0.819  |
| pH                              | c2d  | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 152  
Absorber Vent Scrubber Wastewater  
From Hydrochloric Acid Regeneration  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 38.2   | 16.3   |
| O&Gc1d                          | 16.3   | 5.45   |
| pH                              | c2d  | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 153  
Rod, Wire, and Coil Combination Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.149  | 0.0638   |
| O&Gc1d                          | 0.0638   | 0.0213   |
| pH                              | c2d  | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 154  
Bar, Billet, and Bloom Combination Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.0672   | 0.0288   |
| O&Gc1d                          | 0.0288   | 0.00960  |
| pH                              | c2d  | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 155  
Strip, Sheet, and Plate Continuous Combination  
Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.438  | 0.188  |
| O&Gc1d                          | 0.188  | 0.0626   |
| pH                              | c2d  | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0

Table 156  
Strip, Sheet, and Plate Batch Combination Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.134  | 0.0576   |
| O&Gc1d                          | 0.0576   | 0.0192   |
| pH                              | c2d  | c2d  |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.

c2d Within the range of 6.0 to 9.0



Table 157  
Pipe, Tube, and Other Products Combination Acid Pickling  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.225                 | 0.00964   |
| O&Gc1d                          | 0.0964                | 0.0321  |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d Within the range of 6.0 to 9.0

Table 158  
Combination Acid Pickling Fume Scrubbers  
BCT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 5.72                  | 2.45  |
| O&Gc1d                          | 2.45                  | 0.819   |
| pH                              | c2d                   | c2d   |

c1d The limitation for O&G is applicable when acid pickling wastewaters are treated with cold rolling wastewaters.  
c2d 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.** c1d 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.

c2d 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:

c1d XCold worked pipe and tubeY means cold forming operations which process unheated pipe and tube products using either water or oil solutions for cooling and lubrication.

c2d XCombinationY 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.

c3d XDirect applicationY means cold rolling operations which include once through use of rolling solutions at mill stands.

c4d XMultiple standY means recirculation or direct application cold rolling mills which include more than one stand of work rolls.

c5d XRecirculationY means cold rolling operations which include recirculation of rolling solutions at all mill stands.

c6d XSingle standY 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

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.00125               | 0.000626  |
| O&G                             | 0.000522              | 0.000209  |
| Chromiumc1d                     | 0.0000209             | 0.0000084                                       |
| Lead                            | 0.0000094             | 0.0000031                                       |
| Nickelc1d                       | 0.0000188             | 0.0000063                                       |
| Zinc                            | 0.0000063             | 0.0000021                                       |
| Naphthalene                     | 0.0000021             |   |
| Tetrachloroethylene             | 0.0000031             |   |
| pH                              | c2d                   | c2d   |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 160  
Multiple Stand Recirculation Cold Rolling Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------|---|
| TSS                             | 0.00626               | 0.00313   |
| O&G                             | 0.00261               | 0.00104   |
| Chromiumc1d                     | 0.000104              | 0.0000418                                       |
| Lead                            | 0.0000469             | 0.0000156                                       |
| Nickelc1d                       | 0.0000939             | 0.0000313                                       |
| Zinc                            | 0.0000313             | 0.0000104                                       |
| Naphthalene                     | 0.0000104             |   |
| Tetrachloroethylene             | 0.0000156             |   |
| pH                              | c2d                   | c2d   |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 161  
Combination Cold Rolling Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.0751   | 0.0376   |
| O&G                             | 0.0313   | 0.0125   |
| Chromiumc1d                     | 0.00125  | 0.000501   |
| Lead                            | 0.000563   | 0.000188   |
| Nickelc1d                       | 0.00113  | 0.000376   |
| Zinc                            | 0.000376   | 0.000125   |
| Naphthalene                     | 0.000125   |  |
| Tetrachloroethylene             | 0.000188   |  |
| pH                              | c2d  | c2d  |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 162  
Single Stand Direct Application Cold Rolling Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.0225   | 0.0113   |
| O&G                             | 0.00939  | 0.00376  |
| Chromiumc1d                     | 0.000376   | 0.000150   |
| Lead                            | 0.000169   | 0.0000563  |
| Nickelc1d                       | 0.000338   | 0.000113   |
| Zinc                            | 0.000113   | 0.0000376  |
| Naphthalene                     | 0.0000376  |  |
| Tetrachloroethylene             | 0.0000563  |  |
| pH                              | c2d  | c2d  |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 163  
Multiple Stand Direct Application Cold Rolling Mills  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.100  | 0.0501   |
| O&G                             | 0.0417   | 0.0167   |
| Chromiumc1d                     | 0.00167  | 0.000668   |
| Lead                            | 0.000751   | 0.000250   |
| Nickelc1d                       | 0.00150  | 0.000501   |
| Zinc                            | 0.000501   | 0.000167   |
| Naphthalene                     | 0.000167   |  |
| Tetrachloroethylene             | 0.000250   |  |
| pH                              | c2d  | c2d  |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 164  
Cold Worked Pipe and Tube Using Water  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.00125  | 0.000626   |
| O&G                             | 0.000522   | 0.000209   |
| Chromiumc1d                     | 0.0000209  | 0.0000084  |
| Lead                            | 0.0000094  | 0.0000031  |
| Nickelc1d                       | 0.0000188  | 0.0000063  |
| Zinc                            | 0.0000063  | 0.0000021  |
| pH                              | c2d  | c2d  |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 165  
Cold Worked Pipe and Tube Using Oil Solutions  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| TSS                             | 0.00125  | 0.000626   |
| O&G                             | 0.000522   | 0.000209   |
| Chromiumc1d                     | 0.0000209  | 0.0000084  |
| Lead                            | 0.0000094  | 0.0000031  |
| Nickelc1d                       | 0.0000188  | 0.0000063  |
| Zinc                            | 0.0000063  | 0.0000021  |
| Naphthalene                     | 0.0000021  |  |
| Tetrachloroethylene             | 0.0000031  |  |
| pH                              | c2d  | c2d  |

c1d 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.

c2d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>c2d |
|---------------------------------|--|--|
| Chromiumc1d                     | 0.0000209  | 0.0000084  |
| Lead                            | 0.0000094  | 0.0000031  |
| Nickelc1d                       | 0.0000188  | 0.0000063  |
| Zinc                            | 0.0000063  | 0.0000021  |
| Naphthalene                     | 0.0000021  |  |
| Tetrachloroethylene             | 0.0000031  |  |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.000104   | 0.0000418                                       |
| Lead                            | 0.0000469  | 0.0000156                                       |
| Nickelc1d                       | 0.0000939  | 0.0000313                                       |
| Zinc                            | 0.0000313  | 0.0000104                                       |
| Naphthalene                     | 0.0000104  |   |
| Tetrachloroethylene             | 0.0000156  |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.00125  | 0.000501  |
| Lead                            | 0.000563   | 0.000188  |
| Nickelc1d                       | 0.00113  | 0.000376  |
| Zinc                            | 0.000376   | 0.000125  |
| Naphthalene                     | 0.000125   |   |
| Tetrachloroethylene             | 0.000188   |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.000376   | 0.000150  |
| Lead                            | 0.000169   | 0.0000563                                       |
| Nickelc1d                       | 0.000338   | 0.000113  |
| Zinc                            | 0.000113   | 0.0000376                                       |
| Naphthalene                     | 0.0000376  |   |
| Tetrachloroethylene             | 0.0000563  |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.00167  | 0.000668  |
| Lead                            | 0.000751   | 0.000250  |
| Nickelc1d                       | 0.00150  | 0.000501  |
| Zinc                            | 0.000501   | 0.000167  |
| Naphthalene                     | 0.000167   |   |
| Tetrachloroethylene             | 0.000250   |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.0000209  | 0.0000084                                       |
| Lead                            | 0.0000094  | 0.0000031                                       |
| Nickelc1d                       | 0.0000188  | 0.0000063                                       |
| Zinc                            | 0.0000063  | 0.0000021                                       |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.0000209  | 0.0000084                                       |
| Lead                            | 0.0000094  | 0.0000031                                       |
| Nickelc1d                       | 0.0000188  | 0.0000063                                       |
| Zinc                            | 0.0000063  | 0.0000021                                       |
| Naphthalene                     | 0.0000021  |   |
| Tetrachloroethylene             | 0.0000031  |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| TSS                             | 0.00125  | 0.000626  |
| O&G                             | 0.000522   | 0.000209  |
| Chromiumc1d                     | 0.0000209  | 0.0000084                                       |
| Lead                            | 0.0000094  | 0.0000031                                       |
| Nickelc1d                       | 0.0000188  | 0.0000063                                       |
| Zinc                            | 0.0000063  | 0.0000021                                       |
| Naphthalene                     | 0.0000021  |   |
| Tetrachloroethylene             | 0.0000031  |   |
| pH                              | c2d  | c2d   |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 174  
Multiple Stand Recirculation Cold Rolling Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
| TSS                             | 0.00250   | 0.00125   |
| O&G                             | 0.00104   | 0.000417  |
| Chromiumc1d                     | 0.0000418   | 0.0000167                                       |
| Lead                            | 0.0000188   | 0.0000063                                       |
| Nickelc1d                       | 0.0000376   | 0.0000125                                       |
| Zinc                            | 0.0000125   | 0.0000042                                       |
| Naphthalene                     | 0.0000042   |   |
| Tetrachloroethylene             | 0.0000063   |   |
| pH                              | c2d   | c2d   |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 175  
Combination Cold Rolling Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
| TSS                             | 0.0326  | 0.0163  |
| O&G                             | 0.0136  | 0.00543   |
| Chromiumc1d                     | 0.000543  | 0.000217  |
| Lead                            | 0.000244  | 0.0000814                                       |
| Nickelc1d                       | 0.000488  | 0.000163  |
| Zinc                            | 0.000163  | 0.0000542                                       |
| Naphthalene                     | 0.0000542   |   |
| Tetrachloroethylene             | 0.0000813   |   |
| pH                              | c2d   | c2d   |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 176  
Single Stand Direct Application Cold Rolling Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
| TSS                             | 0.00626   | 0.00313   |
| O&G                             | 0.00261   | 0.00104   |
| Chromiumc1d                     | 0.000104  | 0.0000418                                       |
| Lead                            | 0.0000469   | 0.0000156                                       |
| Nickelc1d                       | 0.0000939   | 0.0000313                                       |
| Zinc                            | 0.0000313   | 0.0000104                                       |
| Naphthalene                     | 0.0000104   |   |
| Tetrachloroethylene             | 0.0000156   |   |
| pH                              | c2d   | c2d   |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 177  
Multiple Stand Direct Application Cold Rolling Mills

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
| TSS                             | 0.0726  | 0.0363  |
| O&G                             | 0.0302  | 0.0121  |
| Chromiumc1d                     | 0.00121   | 0.000484  |
| Lead                            | 0.000545  | 0.000182  |
| Nickelc1d                       | 0.00109   | 0.000363  |
| Zinc                            | 0.000363  | 0.000121  |
| Naphthalene                     | 0.000121  |   |
| Tetrachloroethylene             | 0.000182  |   |
| pH                              | c2d   | c2d   |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 178  
Cold Worked Pipe and Tube Using Water

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
| TSS                             | 0.00125   | 0.000626  |
| O&G                             | 0.000522  | 0.000209  |
| Chromiumc1d                     | 0.0000209   | 0.0000084                                       |
| Lead                            | 0.0000094   | 0.0000031                                       |
| Nickelc1d                       | 0.0000188   | 0.0000063                                       |
| Zinc                            | 0.0000063   | 0.0000021                                       |
| pH                              | c2d   | c2d   |

c1d 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.

c2d Within the range of 6.0 to 9.0

Table 179  
Cold Worked Pipe and Tube Using Oil Solutions

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkc pounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
| TSS                             | 0.00125   | 0.000626  |
| O&G                             | 0.000522  | 0.000209  |
| Chromiumc1d                     | 0.0000209   | 0.0000084                                       |
| Lead                            | 0.0000094   | 0.0000031                                       |
| Nickelc1d                       | 0.0000188   | 0.0000063                                       |
| Zinc                            | 0.0000063   | 0.0000021                                       |
| Naphthalene                     | 0.0000021   |   |
| Tetrachloroethylene             | 0.0000031   |   |
| pH                              | c2d   | c2d   |

c1d 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.

c2d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.0000209  | 0.0000084                                       |
| Lead                            | 0.0000094  | 0.0000031                                       |
| Nickelc1d                       | 0.0000188  | 0.0000063                                       |
| Zinc                            | 0.0000063  | 0.0000021                                       |
| Naphthalene                     | 0.0000021  |   |
| Tetrachloroethylene             | 0.0000031  |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.0000418  | 0.0000167                                       |
| Lead                            | 0.0000188  | 0.0000063                                       |
| Nickelc1d                       | 0.0000376  | 0.0000125                                       |
| Zinc                            | 0.0000125  | 0.0000042                                       |
| Naphthalene                     | 0.0000042  |   |
| Tetrachloroethylene             | 0.0000063  |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.000543   | 0.000217  |
| Lead                            | 0.000244   | 0.0000814                                       |
| Nickelc1d                       | 0.000488   | 0.000163  |
| Zinc                            | 0.000163   | 0.0000542                                       |
| Naphthalene                     | 0.0000542  |   |
| Tetrachloroethylene             | 0.0000813  |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.000104   | 0.0000418                                       |
| Lead                            | 0.0000469  | 0.0000156                                       |
| Nickelc1d                       | 0.0000939  | 0.0000313                                       |
| Zinc                            | 0.0000313  | 0.0000104                                       |
| Naphthalene                     | 0.0000104  |   |
| Tetrachloroethylene             | 0.0000156  |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.00121  | 0.000484  |
| Lead                            | 0.000545   | 0.000182  |
| Nickelc1d                       | 0.00109  | 0.000363  |
| Zinc                            | 0.000363   | 0.000121  |
| Naphthalene                     | 0.000121   |   |
| Tetrachloroethylene             | 0.000182   |   |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
| Chromiumc1d                     | 0.0000209  | 0.0000084                                       |
| Lead                            | 0.0000094  | 0.0000031                                       |
| Nickelc1d                       | 0.0000188  | 0.0000063                                       |
| Zinc                            | 0.0000063  | 0.0000021                                       |

c1d 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                            |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| Chromiumc1d                     | 0.0000209                                  | 0.0000084                                       |
| Lead                            | 0.0000094                                  | 0.0000031                                       |
| Nickelc1d                       | 0.0000188                                  | 0.0000063                                       |
| Zinc                            | 0.0000063                                  | 0.0000021                                       |
| Naphthalene                     | 0.0000021                                  |   |
| Tetrachloroethylene             | 0.0000031                                  |   |

c1d 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        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| TSS                             | 0.00125                                    | 0.000626  |
| O&G                             | 0.000522                                   | 0.000209  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 188  
Multiple Stand Recirculation Cold Rolling Mills

| BCT Effluent Limitations        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| TSS                             | 0.00626                                    | 0.00313   |
| O&G                             | 0.00261                                    | 0.00104   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 189  
Combination Cold Rolling Mills

| BCT Effluent Limitations        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| TSS                             | 0.0751                                     | 0.0376  |
| O&G                             | 0.0313                                     | 0.0125  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 190  
Single Stand Direct Application Cold Rolling Mills

| BCT Effluent Limitations        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| TSS                             | 0.0225                                     | 0.0113  |
| O&G                             | 0.00939                                    | 0.00376   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 191  
Multiple Stand Direct Application Cold Rolling Mills

| BCT Effluent Limitations        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| TSS                             | 0.100                                      | 0.0501  |
| O&G                             | 0.0417                                     | 0.0167  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 192  
Cold Worked Pipe and Tube Using Water

| BCT Effluent Limitations        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| TSS                             | 0.00125                                    | 0.000626  |
| O&G                             | 0.000522                                   | 0.000209  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 193  
Cold Worked Pipe and Tube Using Oil Solutions

| BCT Effluent Limitations        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day                      | Average of daily values for 30 consecutive days |
|                                 | kg{kkc pounds per 1,000 poundsd of product |   |
| TSS                             | 0.00125                                    | 0.000626  |
| O&G                             | 0.000522                                   | 0.000209  |
| pH                              | c1d  | c1d   |

c1d 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:

**c1d** XBatchY means alkaline cleaning operations which process steel products such as coiled wire, rods, and tubes in discrete batches or bundles.

**c2d** XContinuousY 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:

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>1,000 poundsd |
|---------------------------------|--|--|
| TSS                             | 0.0730   | 0.0313   |
| O&G                             | 0.0313   | 0.0104   |
| pH                              | c1d  | c1d  |

c1d Within the range of 6.0 to 9.0

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>1,000 poundsd |
|---------------------------------|--|--|
| TSS                             | 0.102  | 0.0438   |
| O&G                             | 0.0438   | 0.0146   |
| pH                              | c1d  | c1d  |

c1d 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:

| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days<br>1,000 poundsd |
|---------------------------------|--|--|
| TSS                             | 0.0146   | 0.00626  |
| O&G                             | 0.00626  | 0.00209  |
| pH                              | c1d  | c1d  |

c1d 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.** c1d 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.

**c2d** 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:

**c1d** XFume scrubberY means wet air pollution control devices used to remove and clean fumes originating from hot coating operations.

**c2d** XGalvanizingY 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.

**c3d** XOther coatingsY 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.

**c4d** XStrip, sheet, and miscellaneous productsY means steel products other than wire products and fasteners.

**c5d** XTerne coatingY 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.

**c6d** XWire products and fastenersY 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

| Pollutant or pollutant property | Maximum for any 1 day                        | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
|                                 | kg {kkg cpounds per 1,000 poundsd of product | kg {kkg cpounds per 1,000 poundsd of product    |
| TSS                             | 0.175  | 0.0751  |
| O&G                             | 0.0751                                       | 0.0250  |
| Lead                            | 0.00113                                      | 0.000376  |
| Zinc                            | 0.00150                                      | 0.000500  |
| Hexavalent chromiumc1d          | 0.000150                                     | 0.0000501                                       |
| pH                              | c2d  | c2d   |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

c2d Within the range of 6.0 to 9.0

Table 198  
Wire Products and Fasteners  
Galvanizing and Other Coatings  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day                        | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
|                                 | kg {kkg cpounds per 1,000 poundsd of product | kg {kkg cpounds per 1,000 poundsd of product    |
| TSS                             | 0.701  | 0.300   |
| O&G                             | 0.300  | 0.100   |
| Lead                            | 0.00451                                      | 0.00150   |
| Zinc                            | 0.00601                                      | 0.00200   |
| Hexavalent chromiumc1d          | 0.000600                                     | 0.000200  |
| pH                              | c2d  | c2d   |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

c2d Within the range of 6.0 to 9.0

Table 199  
Fume Scrubbers  
BPT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------------------|---|
|                                 | kg per day for each fume scrubber | 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 chromiumc1d          | 0.0327                            | 0.0109  |
| pH                              | c2d                               | c2d   |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

c2d 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

| Pollutant or pollutant property | Maximum for any 1 day                        | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
|                                 | kg {kkg cpounds per 1,000 poundsd of product | kg {kkg cpounds per 1,000 poundsd of product    |
| Lead                            | 0.00113                                      | 0.000376  |
| Zinc                            | 0.00150                                      | 0.000500  |
| Hexavalent chromiumc1d          | 0.000150                                     | 0.0000501                                       |

c1d 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

| Pollutant or pollutant property | Maximum for any 1 day                        | Average of daily values for 30 consecutive days |
|---------------------------------|--|---|
|                                 | kg {kkg cpounds per 1,000 poundsd of product | kg {kkg cpounds per 1,000 poundsd of product    |
| Lead                            | 0.00451                                      | 0.00150   |
| Zinc                            | 0.00601                                      | 0.00200   |
| Hexavalent chromiumc1d          | 0.000601                                     | 0.000200  |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

Table 202  
Fume Scrubbers  
BAT Effluent Limitations

| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|---------------------------------|-----------------------------------|---|
|                                 | kg per day for each fume scrubber | kg per day for each fume scrubber               |
| Lead                            | 0.0368                            | 0.0123  |
| Zinc                            | 0.0491                            | 0.0164  |
| Hexavalent chromiumc1d          | 0.00490                           | 0.00163   |
| pH                              | c2d                               | c2d   |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

c2d 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                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.0438                                      | 0.0188  |
| O&G                             | 0.0188                                      | 0.00626   |
| Lead                            | 0.000282                                    | 0.0000939                                       |
| Zinc                            | 0.000376                                    | 0.000125  |
| Hexavalent chromiumc1d          | 0.0000376                                   | 0.0000125                                       |
| pH                              | c2d   | c2d   |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.  
c2d Within the range of 6.0 to 9.0

Table 204  
Wire Products and Fasteners  
Galvanizing and Other Coatings

| NSPS                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| TSS                             | 0.175                                       | 0.0751  |
| O&G                             | 0.0751                                      | 0.0250  |
| Lead                            | 0.00113                                     | 0.000376  |
| Zinc                            | 0.00150                                     | 0.000500  |
| Hexavalent chromiumc1d          | 0.000150                                    | 0.0000501                                       |
| pH                              | c2d   | c2d   |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.  
c2d Within the range of 6.0 to 9.0

Table 205  
Fume Scrubbers

| NSPS                            |                                   |   |
|---------------------------------|-----------------------------------|---|
| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|                                 | 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 chromiumc1d          | 0.00490                           | 0.00163   |
| pH                              | c2d                               | c2d   |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.  
c2d 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                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| Lead                            | 0.000282                                    | 0.0000939                                       |
| Zinc                            | 0.000376                                    | 0.000125  |
| Hexavalent chromiumc1d          | 0.0000376                                   | 0.0000125                                       |

c1d 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                            |   |   |
|---------------------------------|---|---|
| Pollutant or pollutant property | Maximum for any 1 day                       | Average of daily values for 30 consecutive days |
|                                 | kg{kkg cpounds per 1,000 poundsd of product |   |
| Lead                            | 0.00113                                     | 0.000376  |
| Zinc                            | 0.00150                                     | 0.000500  |
| Hexavalent chromiumc1d          | 0.000150                                    | 0.0000501                                       |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

Table 208  
Fume Scrubbers

| PSNS                            |                                   |   |
|---------------------------------|-----------------------------------|---|
| Pollutant or pollutant property | Maximum for any 1 day             | Average of daily values for 30 consecutive days |
|                                 | kg per day for each fume scrubber |   |
| Lead                            | 0.0368                            | 0.0123  |
| Zinc                            | 0.0491                            | 0.0164  |
| Hexavalent chromiumc1d          | 0.00490                           | 0.00163   |

c1d The limitations for hexavalent chromium apply to galvanizing operations which discharge wastewaters from the chromate rinse step.

c2d 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        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
| TSS                             | 0.175  | 0.0751  |
| O&G                             | 0.0751   | 0.0250  |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 210  
Wire Products and Fasteners  
Galvanizing and Other Coatings

| BCT Effluent Limitations        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg{kkg cpounds per 1,000 poundsd of product | Average of daily values for 30 consecutive days |
| TSS                             | 0.701  | 0.300   |
| O&G                             | 0.300  | 0.100   |
| pH                              | c1d  | c1d   |

c1d Within the range of 6.0 to 9.0

Table 211  
Fume Scrubbers

| BCT Effluent Limitations        |  |   |
|---------------------------------|--|---|
| Pollutant or pollutant property | Maximum for any 1 day<br>kg per day for each fume scrubber | Average of daily values for 30 consecutive days |
| TSS                             | 38.1   | 16.3  |
| O&G                             | 16.3   | 5.45  |
| pH                              | c1d  | c1d   |

c1d 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                  |