

CONTENTS

INTRODUCTION 17

GEOLOGICAL CONDITIONS 19

Geological conditions in the central Kladno coalfield
(part of the Kladno-Rakovník coal basin) 19

Stratification of Carboniferous layers 19

Delineation of the central Kladno coalfield 19

Tectonic structure of the central Kladno coalfield 20

Coal seams of the Radnice and Lubná seam systems 20

Characteristics of the Radnice seam system 20

Characteristics of the Lubná seam system 21

Geological conditions in the iron ore field at Nučice 21

Geological conditions in areas of limestone quarrying 22

HISTORICAL CONTEXTS 23

Coal mining 23

The discovery of coal deposits 23

The beginnings of systematic mining

in the Vrapice area of the central Kladno coalfield 23

The Buštěhrad estate and the Buštěhrad manor 24

The eastern Buštěhrad coalfield 24

The western Buštěhrad coalfield 25

The Kladno estate, the Kladno manor 25

Václav Černý and the beginnings of deep coal mining 26

A systematic geological survey of the coalfield,
the Imperial and Royal Prospecting Commission 27

Jan Váňa's discovery in 1846 28

The formation of companies with strong capital backing 29

Imperial Buštěhrad Mines (Císařské buštěhradské doly) 29

*The State Railway Company (C. k. privilegovaná rakouská společnost státní dráhy,
k. k. priv. Österreichische Staatseisenbahn Gesellschaft, StEG)* 29

*The Kladno Coal Mining Company (Kladenské kamenouhelné těžařstvo, Kladnoer
Steinkohlengewerkschaft), the predecessor of the Prague Ironworks Company
(Pražská železářská společnost, Prager Eisen-Industrie-Gesellschaft)* 30

*The Prague Ironworks Company (Pražská železářská společnost, Prager Eisen-
-Industrie-Gesellschaft) and its origins* 30

Concentration of mining activities, the demise
of the small mines and the creation of large-scale mines 31

The Mirošov Mining Company (Mirošovické těžařstvo) 32

The First World War 33

Between the world wars, the Great Depression 33

The Second World War	34
The post-war period, nationalization, national administration and the creation of a national corporation	35
The resumption of mining, recruitment drives and new mines	36
Initial workings at the Kačice claim and the concentration of extraction	36
Reorganizations in the coalfield	37
A number of closures in the 1960s	37
Winding-down and closure of the mines, reclamation of former mine sites	38
The incorporation of the Kladno mines into the ČSM Mine in Stonava	38
The definitive closure of the mines	39
Iron ore mining	40
Other mineral extraction – lime quarrying	42
Metallurgical production and the historical development of the Kladno ironworks	42
The initial plans for the ironworks and the first coke production	42
Plans to build blast furnaces and the dispute with the Břevnov monastery over the location for the furnaces	42
The first group of blast furnaces and the name of the Vojtěch ironworks (Adalbertshütte)	43
The foundation of the Prague Ironworks Company	44
The second phase of construction, the second group of blast furnaces, the coking plant and the central coal preparation plant	44
Enlargement of the plant, construction of a puddling plant, rolling plant and bridge works	45
The economic crisis and the introduction of Bessemer converters	46
The first rail-producing cartel	47
The first steel production in continental Europe using Thomas converters	47
The era of Carl Wittgenstein and the iron-producing cartel	47
The closure of the coking plant	48
The new Thomas steelworks, the first Siemens-Martin furnaces	48
The establishment of the Poldi works and the production of refined steels	50
Reconstruction of the blast furnaces at the Vojtěch ironworks (Adalbertshütte), demolition of the old blast furnaces and construction of modern blast furnaces	50
The introduction of the duplex method and the Bertrand-Thiel process	51
The Siemens-Martin steelworks, the second Siemens-Martin steelworks, and the reconstruction of the rolling plant at the Vojtěch ironworks	52
Steel production and the introduction of the duplex process at the Poldi works	52
The first use of electric furnaces for steel production in the Habsburg Monarchy	53
The First World War and a shift to armaments production	53
The inter-war period, the development of production in electrical steel furnaces, successful new brands of steel from the Poldi works	54
The ongoing modernization of the blast furnaces at the Vojtěch ironworks, the Kladno blast furnace school	54
Resumption of coke production using Kladno coal	55

The Second World War, the construction of Steelworks 2 and the new W3 rolling plant at the Poldi works	55
The aftermath of the Second World War, nationalization and the creation of the SONP Kladno national corporation	56
The period following the communist takeover in 1948, the reconstruction of the blast furnace plant and the completion of the coking plant	56
Modernization projects and the construction of a rolling plant and steelworks	57
The discontinuation of duplex production and the introduction of secondary metallurgy at the Poldi works	57
The special steelworks, ESR (electro-slag remelting) production of high-alloyed steels for high-grade applications	58
The plans to modernize the United Steelworks (SONP)	58
The end of the integrated production cycle, the final era of the blast furnaces and coking plant	59
The establishment and construction of an electrical steelworks and rolling plant in Dřívň	59
The change in political and economic circumstances after 1989	60
Production in the steelworks and rolling plants under the new economic conditions	60
Rail and cable transport	61
Horse-drawn railways	62
The Buštěhrad Railway	62
The Kladno-Nučice Railway	
Internal company rail systems, narrow-gauge rail systems at coal mines	64
Internal company rail networks at the Vojtěch and Poldi works	64
Overhead cable systems	65
Conservation of industrial cultural heritage	66
Museum activities and the establishment of the Mayrau mining museum	67
Conservation of industrial heritage (architectural, typological and historical value)	68
 TECHNOLOGICAL AND TYPOLOGICAL DEVELOPMENT	 71
Technological and typological development of coal mining, ore mining and other mineral extraction	71
Extraction methods in the central Kladno coalfield	71
Surface mining and coal quarrying	71
Shallow mining	71
<i>Short adits</i>	71
<i>Shallow shafts</i>	71
<i>Adit mining – sloping adits</i>	72
<i>Overhand mining using the adit entry and pillar method</i>	72
Deep mining	73
<i>“Chessboard” mining</i>	73
<i>Bord and pillar mining, the “Kladno bord and pillar method”</i>	74

<i>Breast and pillar mining</i>	74
<i>Longwall mining</i>	76
<i>Longwall caving</i>	76
<i>The use of benches in longwall mining, bench stoping</i>	76
<i>Mechanized longwall mining</i>	76
<i>Hydromechanical methods of coal extraction</i>	77
Extraction methods used by the Central Bohemian Iron Ore Mines	77
<i>The main extraction method (known as the Nučice method)</i>	78
<i>Other mining methods</i>	78
Extraction methods used in other mineral extraction – limestone quarrying	78
<i>Manual quarrying</i>	79
<i>The funnel method</i>	79
<i>Wall quarrying and shaft quarrying</i>	79
Hand tools	80
Mechanization of mining	80
<i>Pneumatic hammers</i>	80
<i>Cutting machines</i>	80
<i>Shearers</i>	81
Horizontal transport systems in mines	81
<i>Rail transport</i>	82
<i>Cable systems and gravity haulage systems</i>	82
<i>Suspended rail systems</i>	82
<i>Conveyor transport</i>	83
Vertical transport, hoist systems	83
<i>Hand winches</i>	83
<i>Horse- or ox-drawn winches (gins)</i>	84
<i>Steam-driven hoists</i>	84
<i>Electric hoists</i>	84
Pit-head buildings	87
<i>Linear (I-shaped) pit-head buildings</i>	87
<i>Central (T-shaped) pit-head buildings</i>	88
<i>Corner (L-shaped) pit-head buildings</i>	88
<i>Central shafts</i>	90
<i>Free-standing pit-head buildings</i>	91
Winding towers (head frames)	91
<i>Brick winding towers</i>	94
<i>English-type trestle winding towers</i>	94
<i>German-type strut-framed winding towers</i>	94
<i>Reinforced concrete winding towers</i>	95
Mine ventilation	95
<i>Intake and return shafts</i>	95

Mine drainage	96
<i>Drainage shafts</i>	96
Technological and typological development – iron and steel production	96
Coal preparation and coke production	97
Coal preparation	97
The coking process – carbonization	97
Direct coke production	97
<i>Charcoal piles</i>	98
<i>Schaumburg kilns (half-open ovens)</i>	98
<i>Beehive ovens (Belgian-type ovens)</i>	99
Indirect coke production, flame ovens	100
<i>François-type ovens</i>	100
<i>François-Jacobi ovens</i>	100
Regeneration and distillation ovens, the use of by-products and heat regeneration	102
<i>The batch preparation plant</i>	102
<i>Coking batteries, Koppers ovens</i>	106
<i>The coke preparation plant</i>	107
<i>The chemical plant</i>	107
Ores and ore processing	108
Cold processing of ore	108
Hot processing of ore	108
<i>Roasting</i>	108
<i>Walled enclosures</i>	108
<i>Stack furnaces – (multi-level) roasting furnaces</i>	108
<i>Agglomeration (sintering)</i>	109
<i>Pelleting and balling</i>	109
Chemical ore processing	109
<i>Soaking</i>	109
<i>Dephosphorization</i>	110
Limestone processing	110
Limestone processing methods	110
<i>Stack furnaces for producing lime</i>	112
Production of pig iron	112
The pig iron production process, blast furnaces	114
<i>Indirect reduction</i>	114
<i>Direct reduction</i>	114
<i>Basic types of iron</i>	115
Blast furnaces	115
<i>The furnace vessel</i>	115
<i>The charging system and the furnace top</i>	116
The blast furnaces at the Kladno ironworks	116

<i>Belgian-type furnaces</i>	116
<i>Belgian/Scottish-type furnaces</i>	116
<i>Lürrmann furnaces with thick-walled stacks</i>	121
<i>Lürrmann stoves with thin-walled stacks</i>	124
<i>Boshless blast furnaces</i>	125
<i>Thin-walled blast furnaces with welded steel outer shells and surface stack cooling</i>	125
<i>Medium-walled blast furnaces with internal stack cooling</i>	131
Blast stoves and bellows	131
<i>Bellows</i>	131
<i>Blast stoves</i>	132
The principle of recuperation stoves	132
<i>Wasseraufingen recuperation stoves</i>	132
The principle of regeneration stoves	132
<i>Whitwell regeneration stoves</i>	133
<i>Cowper regeneration stoves</i>	133
Cleaning of blast furnace gas, blast furnace pipeways	134
<i>Dust catchers</i>	134
<i>The gas cleaning plant</i>	134
Refining of pig iron, steel production	134
The refining process	135
Acidic and basic processes	135
Wrought iron and carbon steel production, steel furnaces	135
<i>Puddling furnaces</i>	135
Converters	137
<i>Bessemer converters</i>	137
<i>Thomas converters</i>	138
Regenerative reverberatory furnaces	140
<i>Siemens-Martin furnaces</i>	140
<i>Crucible furnaces</i>	140
<i>Cementation furnaces</i>	142
Electric furnaces	142
<i>Electric resistance furnaces</i>	142
<i>Electric induction furnaces (EIF)</i>	142
<i>Electric arc furnaces (EAF)</i>	144
Duplex processes	144
<i>The Bertrand-Thiel duplex process</i>	144
<i>Duplex process: Thomas converter – Siemens-Martin furnace</i>	144
<i>Duplex process: Siemens-Martin furnace – crucible furnace</i>	144
<i>Duplex process: Siemens-Martin furnace – electric furnace</i>	144
Secondary metallurgy	145
<i>Ladle furnace (LF)</i>	145

	<i>Scandinavian lance (SL)</i>	145
	<i>Homogenizing systems and DH vacuum degassing stations</i>	145
	<i>Vacuum-oxygen decarburization (VOD)</i>	145
	<i>Electro-slag remelting and vacuum remelting</i>	146
Casting		146
	<i>Steel casting (casting ladles, coquilles, ingots)</i>	146
	<i>Continuous casting</i>	146
Forming - rolling and forging		148
Rolling		148
Longitudinal rolling		149
	<i>Two-high rolling mills (one-way, reversible)</i>	149
	<i>Three-high rolling mills (Lauth mills)</i>	150
	<i>Universal rolling mills</i>	150
Forging		157
	<i>Hammers</i>	157
	<i>Presses</i>	157
Rail transport		166
	<i>Horse-drawn railways</i>	166
	<i>Ground structures</i>	166
	<i>Rail structures</i>	166
	<i>Steam railways</i>	166
	<i>Passenger buildings, station buildings</i>	166
	<i>Engine-houses, depots</i>	167
	<i>Water towers</i>	169
	<i>Guard-houses</i>	169
	<i>Warehouses</i>	170

CATALOGUE OF ENTREPRENEURS, COMPANIES AND IMPORTANT FIGURES 171

Antonín Vitek and Václav Novotný Mining Company (Težařstvo Antonína Vítka a Václava Novotného) / "Prague Mines"	171
Austrian state	171
Bohemia Art, spol. s r. o.	171
Bohemian Mining Company (Česká montánní společnost, Böhmische Montan-Gesellschaft)	171
Bohemian-Moravian Mines (Českomoravské doly, a.s. (ČMD) v Kladně / Českomoravské doly, člen koncernu KARBON INVEST, a. s., v Ostravě)	171
Buštěhrad Coal Mines (Buštěhradské kamenouhelné doly, a. s., v Dubí u Kladna)	172
Buštěhrad estate (Buštěhradské panství) / Buštěhrad manor (Buštěhradský velkostatek)	172
Buštěhrad manor (Buštěhradský velkostatek)	173
Buštěhrad Prago Coal Mines (Buštěhradské doly Prago, a. s., v Dubí u Kladna / Doly Prago Dubí / "Pragodoly")	173

- Buštěhrad Railway Company (Buštěhradská dráha, a. s. / Bustehrader Eisenbahn – BEB) / Buštěhradská železniční společnost, a. s. 174
- Central Bohemian Coal and Iron Ore Mines (Středočeské uhelné a železnorudné doly, n. p., SUŽD), / Central Bohemian Coal Mines (Středočeské uhelné doly, n. p., Kladno) / Kladno Mines (Kladenské doly, n. p., Kladno) / Kladno Mines – Trust Kladno (Kladenské doly – trust Kladno) / Kladno Coal Mines Holding Company (Kombinát kamenouhelné doly, Kladno) / Kladno Coal Mines Association (Sdružení kamenouhelných dolů Kladno) / Coal Mines – Kladno Concern (Kamenouhelné doly – koncern Kladno) 174
- Central Bohemian Coal Mines (Středočeské uhelné doly, n. p., Kladno) 176
- Černý, Václav / Václav Černý Prospecting Company 176
- ČMD, a.s. 176
- Coal Mines – Kladno Concern (Kamenouhelné doly – koncern Kladno) 176
- Ejpvovice Iron Ore Mines and Balling Plant (Železnorudné doly a hrudkovny Ejpvovice) 176
- Florentin Robert Mines in Dubí and Cvrčovice 176
- Fürstenberg, Karl Egon II, Max Egon I 177
- Imperial and Royal Prospecting Commission (C. k. kutební komise) 177
- Imperial and Royal State Railways (C. k. státní dráha) 178
- Imperial Buštěhrad Mines (Císařské buštěhradské doly / Císařské doly) 178
- Kladno Coal Mines (Kamenouhelné doly v Kladně, a. s.) 178
- Kladno Coal Mines Association (Sdružení kamenouhelných dolů Kladno) 178
- Kladno Coal Mines Holding Company (Kombinát kamenouhelné doly, Kladno) 178
- Kladno Coal Mining Company (Kladenské kamenouhelné těžárstvo, Kladnoer Steinkohlengewerkschaft) / Pražské uhelné doly u Kladna (Prager Kohlenbergwerk nächst Kladno) 180
- Kladno estate (Kladenské panství), Kladno manor (Kladenský velkostatek) 180
- Kladno Ironworks Company (Kladenská železářská společnost, Kladnoer Eisenwerks-gesellschaft) 180
- Kladno Ironworks Mining Company (Kladenské železářské těžárstvo, Kladnoer Eisengewerkschaft / Kladenská železářská společnost, Kladnoer Eisenwerks-gesellschaft / Podnik železných hutí Klein a Lanna v Kladně (Eisenhüttenunternehmung Klein und Lanna in Kladno) 181
- Kladno Mine (Důl Kladno) and Tuchlovice Mine (Důl Tuchlovice) state mining corporations 181
- Kladno Mines (Kladenské doly, n. p., Kladno) 182
- Kladno Mines Office (Středisko Kladenské doly) 182
- Klein, brothers Albert/Engelbert/Franz/Hubert/Libor 182
- Klein and Lanna Ironworks Company in Kladno (Podnik železných hutí Klein a Lanna v Kladně, Eisenhüttenunternehmung Klein und Lanna in Kladno) 182
- Lanna, Vojtěch (Adalbert) 182
- Lindheim, Hermann Dietrich (Heymann David Levy) / Lindheim & Comp. 183
- Mirošov Mining Company (Mirošovské kamenouhelné těžárstvo, Miroschauer Steinkohlen-Gewerkschaft) / Mirošov-Libušín Company (Mirošovsko-libušínská společnost) / Mirošov-Libušín-Svatoňovice Coal Mining Company (Mirošovsko-libušínsko-svatoňovická, a. s., Miroschau-Libuschnin-Schwandowitzer Steinkohlenbergbau, Aktiengesellschaft) 184

Novotný, Václav	184
Nučice Iron Ore Mines (Železnorudné doly Nučice)	185
Palivový kombinát Ústí, Kladno Mines Office (Palivový kombinát Ústí, s. p., středisko Kladenské doly)	185
POLDI – United Steelworks (POLDI – Spojené ocelárny, n. p., Kladno)	185
POLDI, a. s. / Bohemia Art, spol. s r. o. (Vladimír Stehlík) / Huť Poldi ušlechtilé oceli / Strojírny POLDI / Energetické centrum Kladno	186
Poldi engineering works (Strojírny Poldi)	186
POLDI Hütte, s. r. o. / Scholz Stahlzentrum Ost GmbH	187
POLDI, s. r. o.	187
Poldi works, cast crucible steel works (Poldina huť, továrna na litou kelímkovou ocel, Poldi-Hütte, Tiegelgussstahlfabrik)	187
Prago Dubí Mines / “Pragodoly”	188
“Pragomines” (“Pragodoly”)	188
Prague Coal Mines near Kladno (Pražské uhelné doly u Kladna, Prager Kohlenbergwerk nächst Kladno)	188
Prague Ironworks Company (Pražská železářská průmyslová společnost, Prager Eisen-Industrie-Gesellschaft, PEIG) / Pražská železářská společnost (PŽS) / Pražská železářská společnost, a. s.	180
“Prague Mines”	189
Prague Railway Company (C. k. privilegovaná pražská železniční společnost)	189
Robert, Florentin (Florián) / Robert & Cie	190
Šárek, Jindřich (prof. Dr. mont. Ing., DrSc.)	190
Scholz Stahlzentrum Ost, s. r. o.	191
State Prospecting Commission	191
State Railway Company (C. k. privilegovaná rakouská společnosti státní dráhy, k. k. priv. Österreichische Staatseisenbahn Gesellschaft, StEG / Společnost státní dráhy)	191
Stehlík, Vladimír	192
Stein, Ignatz (Hynek)	192
United Steelworks Kladno (Spojené ocelárny Kladno, n. p., SONP)	192
Váňa (Wannia), Jan	192
Vítek, Antonín	193
Wittgenstein, Carl	193
 CATALOGUE OF CULTURAL HERITAGE SITES	 195
Cadastral area Brandýsek	195
<i>Transport</i>	195
Brandýsek railway station	195
<i>Mining</i>	195
Michael Layer / No. XI mine and housing scheme	195
Cadastral area Chrutenice	198
Chrutenice iron ore mine, Chrutenice Engineering Works (Strojírny Chrutenice) complex, mining equipment exhibition at the Chrutenice shaft	198

Cadastral area Dubí 201

Transport 201

Dubí railway station 201

Mining 201

Franz Joseph I / Prago / Antonín Zápotocký mine 201

Jan (Johanni) / Nový Jan mine 205

Cadastral area Kamenné Žehrovice 205

Wannieck / General Svoboda / Nejedlý II mine 205

Cadastral area Kladno 207

Transport 207

Kladno / Staré Kladno station (goods station) 207

Mining 208

Engerth / no. V mine 208

Kübeck mine, miners' housing scheme, power plant, transportation adit 210

Václav mine 214

Metal production 215

The Poldi works (Poldi-Hütte, Tiegelgussstahlfabrik) 215

Vojtěch ironworks (Vojtěšská huť) / Koněv works (Huť Koněv) / Kladno-East industrial zone (průmyslová zóna Kladno východ) 225

Residential buildings and health care facilities 239

Guest house / works hotel / Poldi works company hotel / Poldihaus (Gewerkschaftshotel der Poldihütte) 239

Managers' villas 239

Poldi works health centre and health insurance company 242

Works of art 242

Miners' memorial, in the park outside the secondary school on the corner of Váňova St. and Cyrila Boudy St. 242

Cadastral area Kralupy nad Vltavou 251

Station of the Northern State Railway and the Buštěhrad Railway 251

Cadastral area Kročehlavy 252

Transport 252

Vejhybka/Kladno station 252

Mining 254

Kateřina Josefa shaft, archeological site 254

Cadastral area Lány 257

Transport – horse-drawn railways 257

Horse-drawn railway station, building no. 10 257

Horse-changing station at Píně 257

Mining 257

Na Pustince ventilation shaft 257

Cadastral area Libušín 257

Jan mine, miners' housing scheme of the Jan mine	257
Max mine / President Edvard Beneš mine / Fierlinger II mine, Gottwald I mine	260
Schoeller / Nejedlý I mine	262
Schoeller mine central power plant	265
Cadastral area Mořina	265
Amerika limestone quarries	265
Cadastral area Nučice	268
Mine no. III	268
Nučice iron ore memorial	269
Cadastral area Praha-Dejvice	271
Horse-drawn railway station, today Praha-Dejvice station	271
Cadastral area Pchery	272
Theodor / Na Krétě / no. VIII mine and power plant	272
Cadastral area Rynholec	275
<i>Transport</i>	275
Horse-drawn railway halt, no. 195, Pražská St.	275
<i>Mining</i>	277
Anna / Laušman I / Czechoslovak Army I (Československé armády I) mine and power plant	277
Beatie / Laura / Laušman II / Czechoslovak Army II (Československé armády II) mine	277
Cadastral area Stehelčeves/Stelčoves	279
Stelčoves/Stehelčeves mine, brewery	279
Cadastral area Vinařice	280
Mayrau / Fierlinger I / Gottwald II mine	280
Cadastral area Vrapice/Rapice	284
Remnants of former mine workings at Na Stařínách, archeological site	284
New Bohumír (Gottfried) / hereditary adit	284
New Josef adit / Ferdinand adit	284
Mining Authority (Bergamt) office building	288
Surface coal outcrops	288
REGISTER OF RAILWAY SIDINGS	289
REGISTER OF CABLE CAR SYSTEMS	292
REGISTER OF MAIN MINE WORKINGS (COAL)	294
REGISTER OF MAIN MINE WORKINGS (IRON ORE)	303
REGISTER OF SPOIL-TIPS	306
REGISTER OF COKING PLANTS CADASTRAL AREA VRAPICE (PRECISE LOCATION UNDETERMINED) AND CADASTRAL AREA Kladno	308
REGISTER OF BLAST FURNACES CADASTRAL AREA Kladno	310
REGISTER OF STEEL FURNACES	315

REGISTER OF ROLLING PLANTS/MILLS 321

LITERATURE AND SOURCES 327

Literature 327

Unpublished texts 332

Sources 333

Online sources 334

MAPS 335

Map of the area, scale 1 : 100,000

Map sheets, scale 1 : 25,000