

Title (en)

METHOD OF MANUFACTURING SEAMLESS TUBE BY THREE-ROLL MANDREL MILL

Title (de)

VERFAHREN ZUR HERSTELLUNG EINES NAHTLOSEN ROHRS DURCH EIN ROHRWALZWERK MIT DREI WALZEN

Title (fr)

PROCEDE DE FABRICATION D'UN TUBE SANS SOUDURE PAR LAMINAGE A TROIS ROULEAUX

Publication

EP 1679136 B1 20090812 (EN)

Application

EP 04792128 A 20041007

Priority

- JP 2004014830 W 20041007
- JP 2003348689 A 20031007

Abstract (en)

[origin: EP1679136A1] A method for manufacturing seamless tubes by a three-roll mandrel mill according to the present invention, wherein the ratio of the inner circumferential length of the tube material to the outer circumferential length of the mandrel bar is set in the range of 1.07 to 1.17 in the last two stands, that constitute said mandrel mill, in which the tube material is subjected to a wall thickness reduction process, makes it possible to effectively suppress the unsuccessful withdrawal of the mandrel bar as well as the inner surface scratch defects of the tube material by the mandrel bar without excessively increasing the wall thickness difference in the circumferential direction (the wall thickness eccentricity) after rolling, whereby a production run by said three-roll mandrel mill can be performed. Thus, the method for manufacturing seamless tubes by a Mannesmann-Mandrel Mill process can be widely applied.

IPC 8 full level

B21B 17/02 (2006.01); **B21B 17/04** (2006.01); **B21B 19/10** (2006.01); **B21B 27/02** (2006.01); **B21B 25/00** (2006.01)

CPC (source: EP)

B21B 17/04 (2013.01); **B21B 25/00** (2013.01); **B21B 27/024** (2013.01)

Designated contracting state (EPC)

DE FR IT

DOCDB simple family (publication)

EP 1679136 A1 20060712; **EP 1679136 A4 20070815**; **EP 1679136 B1 20090812**; CN 100368102 C 20080213; CN 1863608 A 20061115; DE 602004022574 D1 20090924; JP 2005111518 A 20050428; JP 4103082 B2 20080618; RU 2309015 C1 20071027; WO 2005035154 A1 20050421

DOCDB simple family (application)

EP 04792128 A 20041007; CN 200480029358 A 20041007; DE 602004022574 T 20041007; JP 2003348689 A 20031007; JP 2004014830 W 20041007; RU 2006115563 A 20041007