

Title (en)
PROCESS FOR PRODUCING SEAMLESS STEEL PIPE

Title (de)
VERFAHREN ZUR HERSTELLUNG EINES NAHTLOSEN STAHLROHRS

Title (fr)
PROCEDE DE FABRICATION DE TUYAUX EN ACIER SANS SOUDURE

Publication
EP 1878514 A1 20080116 (EN)

Application
EP 06713910 A 20060216

Priority
• JP 2006302769 W 20060216
• JP 2005038689 A 20050216

Abstract (en)
A seamless steel tube is manufactured from a high alloy steel containing at least 5% of Cr while effectively preventing mandrel bar withdrawal troubles after elongation rolling of a material being rolled. A seamless steel tube of a high alloy steel containing at least 5% of Cr is manufactured by subjecting a material being rolled 3 to elongation rolling using a retained mandrel mill 1 in which the speed of a mandrel bar 2 in the axial direction is maintained constant while the speed of movement Vb of the mandrel bar 2, the speed Vi of the material being rolled 3 on the inlet side of the retained mandrel mill 1, and the speed Ve of the material being rolled 3 on the exit side of the retained mandrel mill 1 satisfy the relationship: $0.15 \leq Vb / \{ (Vi + Ve) / 2 \} \leq 0.70$ by controlling the speed of movement Vb of the mandrel bar 2.

IPC 8 full level
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CPC (source: EP US)
B21B 17/04 (2013.01 - EP US); **B21B 37/78** (2013.01 - EP US); **B21B 3/02** (2013.01 - EP US); **B21B 2275/06** (2013.01 - EP US)

Cited by
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Designated contracting state (EPC)
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