

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:  $0.15 \# Vb / \{Vi + Ve\} / 2 \# 0.70$  by controlling the speed of movement Vb of the mandrel bar 2.

IPC 8 full level  
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Cited by  
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