

Title (en)  
DRAWING ROLLING METHOD BY MANDREL MILL

Title (de)  
ZIEHWALZVERFAHREN FÜR ROHRWALZWERK

Title (fr)  
PROCEDE D'ETIRAGE-LAMINAGE PAR UN LAMINOIR A MANDRIN

Publication  
**EP 1889669 A1 20080220 (EN)**

Application  
**EP 06730240 A 20060328**

Priority  
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• JP 2005090432 A 20050328

Abstract (en)  
An elongation rolling method of a mother tube from a hollow shell using a mandrel mill can prevent overfilling and under-filling using a single combination of grooved roll. The outer diameter of the hollow shell is set such that the ratio of outer circumference of the hollow shell to outer circumference of the mother tube on the exit side of the finishing stand is at least 1.1 when the mother tube contains at least 10% Cr or the ratio is less than 1.1 when the mother tube contains less than 10% Cr. The groove profile of grooved rolls provided in a first stand and a second stand of the mandrel mill is set such that the groove circumference determined by a plurality of grooved rolls provided in the first stand satisfies Equation 1, the groove circumference determined by a plurality of grooved rolls provided in the second stand satisfies Equation 2, and the groove circumferences in the first stand and the second stand satisfy Equation 3. Under these conditions, elongation rolling of a mother tube is carried out using a mandrel mill.

IPC 8 full level  
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CPC (source: EP)  
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Cited by  
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