

Title (en)
PROCESS FOR PRODUCING HIGH-Cr SEAMLESS PIPE

Title (de)
VERFAHREN ZUR HERSTELLUNG EINES NAHTLOSEN ROHRS MIT HOHEM CHROMGEHALT

Title (fr)
PROCEDE DE PRODUCTION D'UN TUYAU SANS SOUDURE A TENEUR ELEVEE EN Cr

Publication
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Application
EP 07737596 A 20070301

Priority
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Abstract (en)
A billet containing, by mass%, 8.0 to 16.0% of Cr with a value represented by the formula of "Cr + 4Si - (22C + 0.5Mn + 1.5Ni + 30N)" of not more than 9.0%, wherein the symbols of the elements represent the contents, by mass%, of the elements in the steel, is heated by means of a heating furnace conditioned so as to have a soaking temperature of 1100 to 1800 °C and an in-furnace time (min) of not less than "0.5 × Diameter of the billet (mm)". Thereafter, by means of a centering machine capable of forming a center hole having a diameter of not less than "0.34 × Diameter of the billet (mm)" at one end face of the said billet where piercing starts by punch of 60 to 110° punching angle, a center hole is formed at the said face of the billet, followed by piercing and rolling by an inclined roll type piercing mill of not more than 8.0% plug tip draft rate. The thus-produced high-Cr seamless pipe or tube has excellent internal surface properties with minimized internal surface defects.

IPC 8 full level
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