

Title (en)
SEAMLESS PIPE MANUFACTURING METHOD

Title (de)
VERFAHREN ZUR HERSTELLUNG EINES NAHTFREIEN ROHRES

Title (fr)
PROCÉDÉ DE FABRICATION DE TUYAUX SANS SOUDURE

Publication
EP 2133159 A4 20111026 (EN)

Application
EP 08738871 A 20080326

Priority
• JP 2008055645 W 20080326
• JP 2007092996 A 20070330

Abstract (en)
[origin: EP2133159A1] There is provided a method for manufacturing a seamless pipe or tube that is capable of making more uniform the wall thickness distribution of a pipe or tube along the longitudinal direction of the pipe or tube than the prior art. The method for manufacturing a seamless pipe or tube according to the present invention comprises a first step of measuring the outside diameter distribution of the mandrel bar B along the longitudinal direction of the mandrel bar at normal temperature; a second step of measuring the temperature distribution of the mandrel bar along the longitudinal direction of the mandrel bar in the mandrel bar after it being used for a drawing and rolling step in a mandrel mill M; and a third step of measuring the wall thickness distribution of the pipe or tube in the hot state after it being subjected to drawing and rolling with the mandrel bar being inserted thereinto, along the longitudinal direction of the pipe or tube. And the method comprises a fourth step of calculating the outside diameter distribution of the mandrel bar along the longitudinal direction of the mandrel bar at the time of being used for drawing and rolling on the basis of the respective parameters which have been obtained at the first to third steps, and a fifth step of adjusting the setting position of the grooved roll R in the rolling direction on the basis of the outside diameter distribution of the mandrel bar along the longitudinal direction of the mandrel bar when the mandrel bar is inserted into the inside of a pipe or tube at the next timing for being used for drawing and rolling.

IPC 8 full level
B21B 37/78 (2006.01); **B21B 17/02** (2006.01)

CPC (source: EP)
B21B 37/78 (2013.01); **B21B 17/04** (2013.01)

Citation (search report)
• [AD] JP S5927704 A 19840214 - NIPPON KOKAN KK
• [A] DE 4141086 A1 19920617 - MANNESMANN AG [DE]
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• [A] US 2006059969 A1 20060323 - IWAMOTO HIROYUKI [JP], et al
• See references of WO 2008123276A1

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KR102141689B1

Designated contracting state (EPC)
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EP 08738871 A 20080326; CN 200880018286 A 20080326; JP 2008055645 W 20080326; JP 2009509125 A 20080326