

Title (en)  
METHOD FOR PRODUCING SEAMLESS PIPE

Title (de)  
VERFAHREN ZUR HERSTELLUNG EINES NAHTLOSEN ROHRS

Title (fr)  
PROCÉDÉ DE FABRICATION D'UN TUBE SANS SOUDURE

Publication  
**EP 2281641 A1 20110209 (EN)**

Application  
**EP 09723678 A 20090227**

Priority  
• JP 2009053652 W 20090227  
• JP 2008082734 A 20080327

Abstract (en)  
Disclosed is a method for producing a seamless pipe by using a piercing mill which pierces and rolls a round billet heated to 1300°C or lower, wherein the piercing mill is composed of a pair of skew rolls disposed to face each other across a pass line, a pair of guide devices disposed to face each other across the pass line, and a plug disposed along the pass line, between the pair of the skew rolls and also between the pair of the guide devices, wherein the piercing-rolling is performed under the conditions satisfying the following formulas (1) to (3) to prevent wrinkle flaws of the seamless pipe:  $-1.0 < \alpha, \beta = \alpha_p - \alpha_r - 0.37 \times \beta + 1.47 \beta R n \beta 0.37 \times \beta + 2.67$  wherein the meanings of the individual symbols in the above-described formulas are as follows:  $\alpha_r$ : The half angle (°) between the pass line and the main roll face in the condition of the feed angle of the main rolls being zero  $\alpha_p$ : The half angle (°) between the pass line and the reeling section of the plug R n: The number of times of the reeling of the plug

IPC 8 full level  
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