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
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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 < #ᵧ #ᵧ = ᵧ p - ᵧ r - 0.37 × #ᵧ + 1.47 #¤ R n #¤ 0.37 × #ᵧ + 2.67 wherein the meanings of the individual symbols in the above-described formulas are as follows: ᵧ 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 ᵧ 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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