

Title (en)
HIGH-ALLOY SEAMLESS STEEL PIPE MANUFACTURING METHOD

Title (de)
VERFAHREN ZUR HERSTELLUNG EINES NAHTLOSEN HOCHLEGIERUNGSSTAHLROHRS

Title (fr)
PROCÉDÉ DE FABRICATION DE TUBE EN ACIER SANS SOUDURE À ALLIAGE ÉLEVÉ

Publication
EP 2286934 B1 20150304 (EN)

Application
EP 08873626 A 20081204

Priority
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• JP 2008087150 A 20080328

Abstract (en)
[origin: EP2286934A1] Pipe-swelling can be prevented by piercing-rolling a high-alloy steel billet heated to a temperature range from 900 to 1250°C with a piercing mill equipped with main rolls having a surface roughness R max of 150 to 500 μm. A ratio (the gap W G of guide rolls/the gap W R of the main rolls) is preferably at 1.10 to 1.20. The difference ($\alpha_P - \alpha_R$) is preferably set at 0 to 3.0°, where α_R is an angle between an exit-side face of each of the main rolls of the piercing mill and the pass line; and α_P is an angle between a rolling face of the piercing plug and the pass line.

IPC 8 full level
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