

Title (en)

METHOD OF MANUFACTURE THROUGH THE WELDING OF FINNED TUBES WITH COOLED GUIDE DISCS ONTO A TUBULAR BODY SET INTO ROTATIONAL MOTION

Title (de)

VERFAHREN ZUR HERSTELLUNG DURCH SCHWEISSEN VON RIPPENROHREN AUF EINEM IN ROTATION VERSETZTEN ROHRKÖRPER MIT GEKÜHLTEN FÜHRUNGSCHEIBEN

Title (fr)

PROCÉDÉ DE FABRICATION DE TUBES NERVURÉS PAR SOUDAGE SUR UN CORPS TUBULAIRE MIS EN ROTATION, À L'AIDE DE DISQUES DE GUIDAGE REFOIDIS

Publication

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Application

**EP 09780102 A 20090702**

Priority

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Abstract (en)

[origin: CA2730427A1] The invention relates to a method for manufacturing finned tubes made of metal, in particular heat exchanger tubes, wherein at least one continuous strip (4) forming the fins (1) is fed tangentially to a tubular body (2) that is set into rotational motion, said strip wound onto the tubular body, the side of the strip (4) facing the tubular body (2) is connected to the tube surface by way of a welding device (7,8) using a filler material (9), and the strip (4) to be wound is fed just behind the welding area between guide discs (12) that extend toward the surface of the tube and to the point of welding up to the point of being flush therewith. In order to increase the life of the guide discs (12), the guide discs (12) are cooled using cooling water to which about 10 vol.-% of a welding release agent is added.

IPC 8 full level

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