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(54) **Method of continuous finishing of pipe.**

(57) The invention provides a method of finishing long pipes composed of straightening rolled pipes after they have been cooled at a cooling bed (10), inspecting the pipes by nondestructive inspection and cutting the pipes to a predetermined length. A

high speed straightener having five roll pair stands is utilized in the straightening, wherein the plural pairs of the rolls adjacent to each other co-operate to achieve the maximum offset.

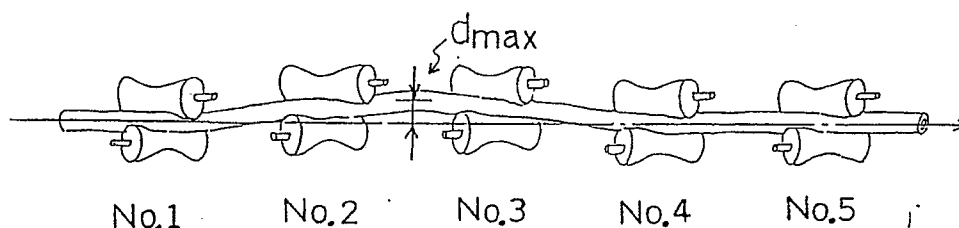


Fig.4

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EUROPEAN SEARCH REPORT

EP 90 31 2467

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
X,Y	DE-A-3 729 619 (BRAUN) * column 2, line 36 - column 3, line 8; figure * - - -	1,2,4,8,10	B 21 D 3/04
Y	US-A-4 663 955 (REDMAN) * column 3, lines 19 - 36; figure * - - -	2	
Y,A	US-A-4 406 141 (NUMANO ET AL) * column 2, line 43 - column 3, line 28; figures 1, 3 * - - -	4,8,10,6, 7,9	
A	US-A-4 494 394 (NILSSON) * column 10, line 56 - column 11, line 20; figures 8, 9 * - - -	1,4,5,8,10	
A	EP-A-0 182 003 (TH.KIESERLING & ALBRECHT GMBH & CO.) * page 9, line 14 - page 10, line 9; figure 3 * - - -	1,4,10	
A	US-A-3 207 289 (F.M.SMITH) * column 1, lines 10 - 36 * - - - - -	3,5	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B 21 D
The present search report has been drawn up for all claims			
Place of search		Date of completion of search	Examiner
The Hague		10 May 91	GARELLA M.G.C.D.
CATEGORY OF CITED DOCUMENTS X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention E: earlier patent document, but published on, or after the filing date D: document cited in the application L: document cited for other reasons &: member of the same patent family, corresponding document			