



张家港市张运机械制造有限公司

Zhangjiagang City Zhangyun Machinery Manufacturing Co.,Ltd.

Φ 125 HIGH-FREQUENCY WELDED PIPE MILL LINE

1 General Introduction

Φ 125 high-frequency welded pipe production line is designed to produce welded pipes of 50~130mm in diameter and 1.5~6.0mm in wall thickness as well as square and rectangular pipes and formed sections of the corresponding size.

2 Main Technical Specifications:

2.1 Main Specifications:

2.1.1 Pipe Diameter: Φ 50~Φ 130 mm

2.1.2 Wall Thickness: 1.5 ~ 6.0mm

2.1.3 Pipe Length: 4 ~ 10m

2.1.4 To-length Accuracy: ±3 mm

2.2 Raw Material Conditions:

2.2.1 low carbon steel

Mechanical Characteristics:

$\sigma_b \leq 500\text{Mpa}$ $\sigma_s \leq 300\text{Mpa}$

2.2.2 Width of Strip: 150 ~ 410mm

2.2.3 Thickness of strip: 2.0 ~ 6.0mm

2.2.4 Inner Diameter of Coil: 508mm

2.2.5 Outer Diameter of Coil: $\leq 1600\text{mm}$

2.2.6 Weight of Coil: $\leq 5\text{t}$

2.3 Forming Speed: **Max 50m/min**

3 Technological Process:

Uncoiling → Shearing → handed welding → Storing in accumulator → leveling → Forming → Welding → Bead Scraper → Cooling → Sizing → straighten → Flying saw cutting → Pipe collecting

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4 Main Equipment and Main Data:

4.1 Uncoiled

Firmer Diameter of Coil ,mm	Φ 508mm
Outer Diameter of Coil ,mm	MaxΦ 1600mm
Width of strip ,mm	150~410mm
Weight of Coil , max ,ton	5T
Structure	Single-mackerel
Drum Expansion	Hydraumatic/ sliders
Braking system	Pneumatic



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4.2 Hydraulic Shearing

Shearing Width ,mm	Max 500mm
Thickness of Strip ,mm	1.5~6.0mm
Shearing of Strip	Hydraulic
Adjust of Up and Down	Manual



4.3 welding table

4.4 Horizontal spiral accumulator

Feeding Speed ,max ,m/min	150M/min
Accumulator Dia.	5.5m
Thickness of Strip	1.5~6.0mm
Width of strip	120~420mm
Motor, kW	AC18+22

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4.5 Forming and Sizing Mill

Material	Low carbon steel & low alloy steel
Diameter of Pipe ,mm	Φ 50~Φ 130mm
Thickness of Strip ,mm	1.5~6.0mm
Width of Strip ,mm	150~410mm
Main Motor Power ,Kw	DC200KW×2sets,
H.F.Power, kW	400KW
Forming Mode	Roll forming
Stand	Portal style
Forming Speed, m/min	Max50
Entry Guide	1 set
No. Of forming stands	horizontal 7 φ 110mm, 40Cr vertical 8 φ 65mm, 40Cr

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No. Of sizing stands	horizontal 6 ϕ 110mm, 40Cr Vertical 6 ϕ 65mm, 40Cr
Seam Guide Roll Stand	1set
Squeeze Roll Stand	3Roll
Bead Scraper	1 set
Cooling Zone	self-contained
Turks Head	4-roll style*2sets
Roll Shaft Material	40Cr



4.6 Flying Saw

4.6.1 General Flying Saw

Outer Diameter of Pipe, max, mm	Φ 130mm
Wall Thickness, max, mm	6.0mm
Cut-to-length, m	4~10m
Cutting Motor Power, kW	AC 55kW
Traveling Motor Power, kW	DC 22kW
Cutting Accuracy, mm	\pm 3mm
Control	Computer

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- 4.6.2 Flying Saw
- 4.7 Conveyer
- 4.8 Table
- 4.9 Container

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