



张家港市张运机械制造有限公司

Zhangjiagang City Zhangyun Machinery Manufacturing Co.,Ltd.

Φ 32 HIGH-FREQUENCY WELDED PIPE MILL LINE

1 General Introduction

Φ 32 high-frequency welded pipe production line is designed to produce welded pipes of 12~50mm in diameter and 0.6~1.2mm in wall thickness as well as square and rectangular pipes .

2 Main Technical Specifications:

2.1 Main Specifications:

- 2.1.1 Pipe Diameter: Φ 12-50
- 2.1.2 Wall Thickness: 0.6 ~ 1.2mm
- 2.1.3 Pipe Length: 4 ~ 10m
- 2.1.4 To-length Accuracy: \pm 3mm

2.2 Raw Material Conditions:

2.2.1

Low carbon steel and low alloy constructional steel

Mechanical Characteristics:

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

- 2.2.2 Width of Strip: 40 ~ 160mm
- 2.2.3 Thickness of strip: 0.6 ~ 1.2mm
- 2.2.4 Inner Diameter of Coil: Φ 508mm
- 2.2.5 Outer Diameter of Coil: \leq 1600mm
- 2.2.6 Weigh of Coil: \leq 1.5T
- 2.3 Forming Speed: 0 ~ 90m/min
- 2.4 Total Power: 200Kw

3 Technological Process:

Uncoiling → Shearing and welding → Storing in accumulator → Forming → Welding → Cooling → Sizing → Flying saw cutting → Pipe collecting

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4 Main Equipment and Main Data:

4.1 Uncoiled

Inner Diameter of Coil ,mm	508mm
Outer Diameter of Coil ,mm	Max 1600
Width of strip ,mm	40~160
Weight of Coil , max ,ton	1.5
Structure	Double-drum
Drum Expansion	Manual
Swivel	Manual
Braking system	Pneumatic



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4.2 Shear Welder

Shearing Width ,mm	40~160
Thickness of Strip ,mm	0.6~1.2
Structure	Hydraulic Shearing + Welder
Adjust of Up and Down	Manual

4.3 Vertical accumulator

Width of Strip,mm	40~160
Thickness of strip,mm	0.6~1.2
Speed,m/min	200
Structure	Pinch roll assembly
Diameter	5*2.4m
Motor, kW	YCT 6P 3KW

4.4 Forming and Sizing Mill

Material	Low carbon steel & low alloy steel $\sigma_b \leq 500\text{Mpa}$ $\sigma_s \leq 300\text{Mpa}$
Diameter of Pipe ,mm	12~50
Thickness of Strip ,mm	0.6~1.2
Width of Strip ,mm	40~160
Main Motor Power ,kW	75KW \times 1set
H.F.Power, kW	100KW

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Forming Mode	Roll forming
Stand	Portal style
Forming Speed, m/min	Max90
Entry Guide	1
No. Of forming stands,material,diameter	- horizontal 8 40Cr, φ 45mm - vertical 8 40Cr, φ 35mm
No. Of sizing stands,material,diameter	- horizontal 6 40Cr, φ 45mm - Vertical 6 40Cr, φ 35mm
Seam Guide Roll Stand	1
Squeeze Roll Stand	1
Bead Scraper	1
Cooling Zone	1
Turks Head	4-roll style.
Reduction Gear Box	Gear Box



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4.5 Flying Saw

Outer Diameter of Pipe, max, mm	12-50
Wall Thickness, max, mm	0.6-1.2
Cut-to-length, m	4.0~10.0
Cutting Motor Power, kW	7.5
Traveling Motor Power, kW	11
Cutting Accuracy, mm	±3
Control	Computer



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4.6 Roller Device

Stand Structure	Welded steel structure
Motor, kW	2.2

4.7 Table

4.8 Container

5 Notes to the quotation:

5.1 Construction of building and inner arrangement except the machine members mentioned above.

All the foundation for the machines and the conduits for the course of the various feedings of line.

All the foundation for the machines and the conduits for the course of the machines, including air compressor, water pump, channels and vent stacks for the exhaust of the gaseous products, solder wire, impeder, CO₂gas etc.

Switchboard and its correcting cables and wires.

All the connecting cables and wines except those in the machines.

Lifting system (bridge crane and devices for internal transportation of steel coils and pipe products).

5.2 Quotation for some of the assistant equipment:

5.2.1	Air Compressor (1.5m ³)	1 set
6.2.2	Air Container (0.6m ³)	1 set
6.2.3	Water Pump (2'' -1/2'')	3 set
6.2.4	Saw Bride Grinder	1 set
Total		

5.3 Delivery time: 90 working days after received deposit.

5.4 Validity of Quotation: September.9,2017~September.30,2017

5.5 Payment: T/T, pay 30% deposit before production; pay 70% before shipment

5.6 Above-mentioned quotations do not contain abroad machine debug costs (installation and debugging cost: \$100 a day for one person, also, the purchaser will supply accommodations of manufacturer's team).

5.7 Specific price determined according to the configuration to meet the needs of users

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