

700

mm

KAWASAKI STEEL GIHO

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Production of Spiral Pipe in Thickness from Heavy to Extra-thin

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Synopsis :

Kawatetsu Steel Tube Corp. (100%-subscribed by Kawasaki Steel Corp.) renewed the spiral mill to satisfy the increased requirements by customers for available sizes. To produce heavy-walled pipe, improvements of the forming roller stand and outside guide roller frame were carried out for achieving good pipe shapes, and a 3-wire submerged arc welding system was applied for improving the quality of weldment. To produce thin-walled pipe, the plate guide roller and inside roller and outside support rollers were newly installed for preventing buckling. Additionally, the welding technique of using a direct current electric source with reverse polarity was applied for stabilizing low heat input welding. As a result, the new spiral mill can produce pipe with a maximum wall thickness of 30 mm and an outside-diameter ranging from 750 mm to 2650 mm and also extra thin-

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要旨

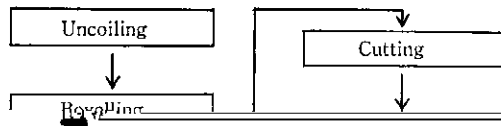
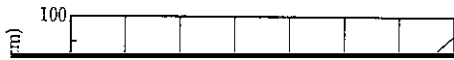


Table 1 Outline of the renewed spiral mill

1. Facilities	
Forming machine	Hoesch type





流位相差とした。この電流位相差は、アークに溶接進行方向の電磁  
力が作用して溶鋼を押し、アークの位置がずれ、溶接の進行方向に

接部の断面を示す。また、この鋼管の寸法形状のヒストグラムを  
Fig. 7 を示す

Outside welding

