

5.1 LONGITUDINALLY WELDED PIPES

1. Provision of coil raw material



A basic prerequisite for high-quality pipes is high-quality, clean and homogenous raw material

2. Coil on decoiler



When the coil is placed on the decoiler, a careful goods inwards inspection is made on the raw material, based on standardised and individually agreed quality criteria

3. Pipe identification by hard stamping



The pipe is given a permanent stamp according to order specification

4. Forming the open seam pipe



In the forming line, the coil is made into open seam pipes

5. Welding the longitudinal weld



The longitudinal weld can be completed by Laser or PAW-TIG-welding

6. Heat treatment



Heat treatment is carried out online according to project and material specifications; at BUTTING using induction annealing at atmospheric pressure

7. Calibration



In the calibration and straightening line, the pipes are calibrated according to the given tolerances

8. Non-destructive testing (if necessary)



Continuous leakage test of the longitudinal weld by eddy current testing – defective areas are recorded in the data system (QUASCO) and are colour-coded on the pipe

9. Cutting the pipes



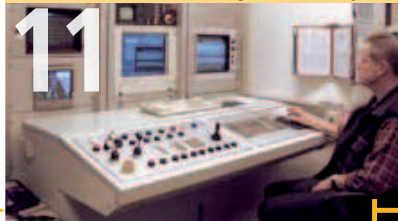
Lengths from 6 to 18 m or fixed lengths with tightest tolerances can be achieved

10. Sorting



After deburring, the pipes are sorted on the basis of clearly defined quality characteristics

11. Non-destructive testing (if necessary)



According to project specification, radiographic examinations can be carried out in the form of X-ray inspection, radioscopy or radiology

12. Processing pipe ends (if necessary)



At customer request, the pipe ends can either be bevelled or cut square

13. Surface treatment



To obtain a bright metallic surface, all BUTTING pipes undergo a full-body chemical pickling

14. Quality control



BUTTING has available a number of non-destructive and destructive testing devices and methods in the accredited company laboratory that can be used at customer request

15. Packaging



To avoid transport damages, customers can choose from a variety of standard or individual packaging solutions