The production process from plate

1. Preparation of the plates
   For the production of pipes from plate we use material from our large stock or purchase the plates in relation to the order.

2. Cutting the formats
   The plates are cut with the plasma cutting equipment.

3. Forming an open seam pipe
   Press brakes and a three-roller bending machine are available to form the plates.

4. Welding the longitudinal seam
   All the current welding processes are used.

5. Heat treatment
   The pipes are annealed both in the furnace and inductively.

6. Calibration
   Pipes which have deformed during heating can be rounded later by means of hydroforming (from the inside) or in a calibrating press (from the outside).

7. Non-destructive testing
   Various types of non-destructive testing are possible, e.g. ultra-sonic or X-ray testing, dye penetrant testing.

8. Processing the pipe-ends
   Machining the bevel prepares the pipe-ends for circumferential welding.

9. Circumferential welding incl. non-destructive testing
   Pipes with an outside diameter of up to 2,032 mm can be connected into max. 24-m lengths by circumferential welding.

10. Surface treatment
    All corrosion resistant pipes are full body pickled at BUTTING.

11. Quality testing
    The final quality control is performed acc. to norm or customer specification – including the documentation.

12. Packaging and dispatch
    The packaging protects the corrosion resistant pipes – during transportation and in store on the construction site.