



MET-TECH | Product Data Sheet

20" ERW TUBE LINE - DIA. 5"-20" - 3-12 MM T - 5-20 M L

Ref. No.: TUBELERW200801

Year: 1986/2008

Brand: DONGBU STEEL, DHM , DAEWOO HEAVY IND.,

Qty. 1 Second-hand ERW tube production line

Mfc.: Design

Fabricated: DHM (Daehan Heavy Machinery), Daewoo Heavy Industry

Welding Machine: THERMATOOL (USA)

Driving Parts: PAKER (USA), TOYODENKI (JAPAN), MITSUBISHI (JAPAN)

Forming Parts: WYKO (UK, 1986) Split Machine

On Line U/T: NDT ENGINEERING (KR, 2008) End facer #1 & 2

Off Line U/T: NDT ENGINEERING (KR, 2008.)

Out dia.: 141.3 ? 508.0 mm Wall thickness

Grades: ASTM A53A/B API 5LB~X70-PLS2, API 5CT J55 General Construction Grades

Capacity: 140,000 MT/year Total weight of the line

Line consist of: Uncoiller ? Leveller ? Forming Mill ? Welder ? Bead Remover ?

Ultrasonic Tester? Seam Annealer ? Cooling Device ? Sizing Mill ? Cut-off ?

Straightener ? Flatening Tester ? Hydrostatic Tester ? Split Machine ?

Ultrasonic Tester ? Bevelling? Weighting Machine ? Final Inspection ?

Varnish Coater/Oiler

Equipment overview

Power supply: THYRISTOR control Welding type

Cutting type: DISC CUTTER (D.D.S type) Seam Annealing

Online UT: Seam UT Offline UT

Welding Machine Mfc.: THERMATOOL(USA)

Max. Plate Volt: 20 kV, DC Filament Volt

Max. Plate Current: 50 AMPS DC Grid Current

Frequency: 400 kHz

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Driving Parts Mfc.: PAKER (USA), TOYODENKI (JAPAN), MITSUBISHI (JAPAN)

Fin Pass: DC 200 HP, 460 V Forming

Sizing: AC 150 HP, 440 V (4EA)

OD: 5" (141.3 mm) ~ 20" (508.0 mm) Length

Line Speed: 35 m/min. Drive Motor

Forming Parts Mfc.: WYKO (UK, 1986)

OD: 73 mm ~ 225 mm Wall Thickness

Speed: 4.5 ~ 90 m/min Max. Pressure

Max. Bending Moment: 380 TON S/M Straightness

On Line U/T Mfc.: NDT ENGINEERING (KR, 2008)

OD: 130 mm ~ 610 mm Detection type

Ultrasonic Inspecting System (USIP40) MELSEC PLC

Size: 4000 x 520 x 2700 mm Weight

Split Machine Mfc.: PMC (USA)

OD: 5" (141.3 mm) ~ 20" (508.0 mm) Length

Type: Holding Pipe and Rotating Processing

End Pacer #1 Mfc.: PMC (USA)

OD: 5" (141.3 mm) ~ 20" (508.0 mm) Length

Usage: Cutting, Bevel Type

End Pacer #2

OD: 6" (168.3 mm) ~ 24" (610.0 mm) Length

Spindle Drive Motor: 100 HP, DC, 450 V, 60 Hz

Spindle Head Motor Mfc.: Reliance Type

Off Line U/T Mfc.: NDT ENGINEERING (KR, 2008)

OD: 130 mm ~ 610 mm Length

Detection Type: SEAM U/T, FULL-BODY U/T

Ultrasonic Inspecting System (USIP40), MELSEC PLC

Material Transfer Device of Walking Beam Full-Body/SEAM Inspection

Size: 24,800 mm x 11,200 mm x 5550 mm (H x V x H)

- **Varnish Coater Mfc.:** Sejong Coater

Type: Airless Cold Spray Type OD

Main Unit Devices

Reel Type Driving Motor: DC 45 kW, 850/2400 RPM HYD. CYL.

Brake Air Cyl.: 160? x 45 ST

Forming Driving Motor: DC 450 kW, 580/1700 RPM Main Reducer

Fin Pass Driving Motor: DC 150 kW Main Reducer

Pull Out Reducer 1st - 1/60.008 2nd - 1/118.86

Outside Bead Cutter Air Cyl.: 80? x 60 ST

Seam Annealer 600 kW, 2 kHz (Themotool, 2010) 600 kW, 2 kHz (PSTech, 2013)

Voltage: 460 V, 3 ph., 60 Hz Annealing Thikness

Annealing Pipe Size: 5" (141.3 mm) ~ 20" (508.0 mm)

On Line U/T Voltage: 440 V, 3 ph., 60 Hz U/T

Sizing Driving Motor: AC 150 HP (4EA) Reducer

Off Line U/T Voltage: 440 V, 3 ph., 60 Hz U/T

Disc Cutter(DDS) Driving Motor: DC 45 kW, 850/2400 RPM HYD. CYL.

Brake Air Cyl.: 180? x 45 ST

Forming Machine Main Drive: 2 x 120 kW DC Cross Feeder

End Facer #2 Spindle Speed: 250 ~ 600 RPM Lube Pump

Spindle Drive Motor: 100 HP, 1150/2000 RPM

Transfer Table: 100/66 HP, 1800/1200 RPM

Hydraulic Press Low Pressure Water Supply Pump: 75 kW x 3 ea, 8 kg/cm²

Seam Roll Motor: 0.4 kW Tail Move Range

Intensifier Low Pressure: 120 kg/cm² High Pressure

Max. Spec.: 20" (508.0 mm) Pipe 18.5 m, 500 kg/cm²

Split Machine Pipe Size Range: 5" (141.3 mm) ~ 20" (508.0 mm) O.C

Cut Length Range: 16" ~ 32" Spindle Speed

Main Motor: 60 HP, 1150/2400 RPM

End Facer #1 Spindle Speed: 50 ~ 350 RPM Lube Pump

Spindle Drive Motor: DC 100 HP, 1150/2000 RPM

Transfer Table: 100/66 HP, 1800/1200 RPM

Marking Printer LP7200 + Inkjet Printer: LP72LP703

2.5 Liters Standard Ink Container x 2 EA

Varnish Coater Spray Gun: 24 AUN - 8980 - 24 (5 EA) 24 AUN - 8990 - 18 (5 EA)

Pump: Air Pressure 2~7 kg/cm² Scrubber Nuzzle Tip

Blower Type: AF - 650 - 4H Capa

Power: 3.7 kW

Threading Machine No.1 Spindle Motor: 100 HP, 1150/2000 RPM, 500V/300V

Transfer Table Drive Motor: 500 HP, 1200 RPM, 230 V/460 V, 3 ph., 60 Hz

Hydro Pump Motor: 40 HP, 1200 RPM

Threader Spindle Lube Pump Motor: 1 HP, 1800 RPM

Threader Coolant Hight Pressure Pump Motor: 20 HP, 3600 RPM

Threader Coolant Recovery Pump Motor: 7.5 HP, 1800 RPM