

The international magazine for the tube

and pipe industries

TUBE & PIPE TECHNOLOGY



March 2009 | Vol 22 No 2 | US\$33



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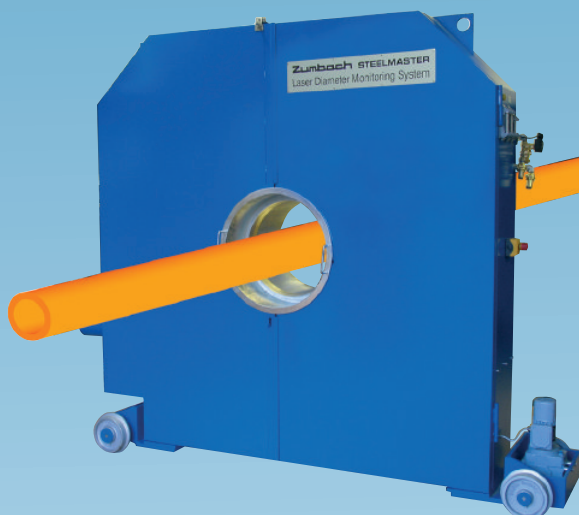


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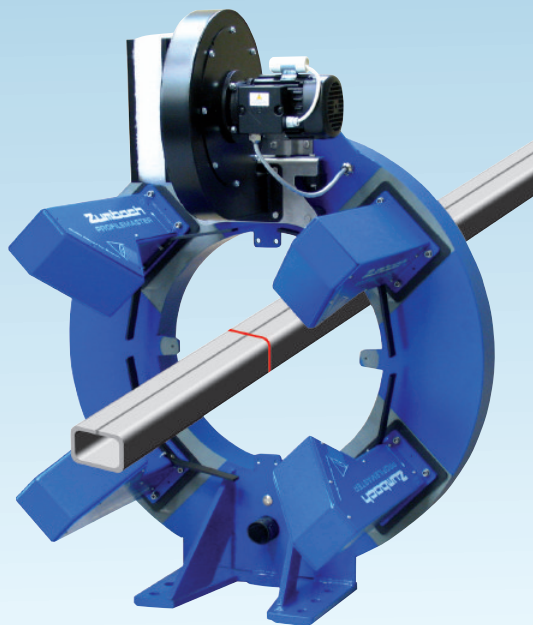
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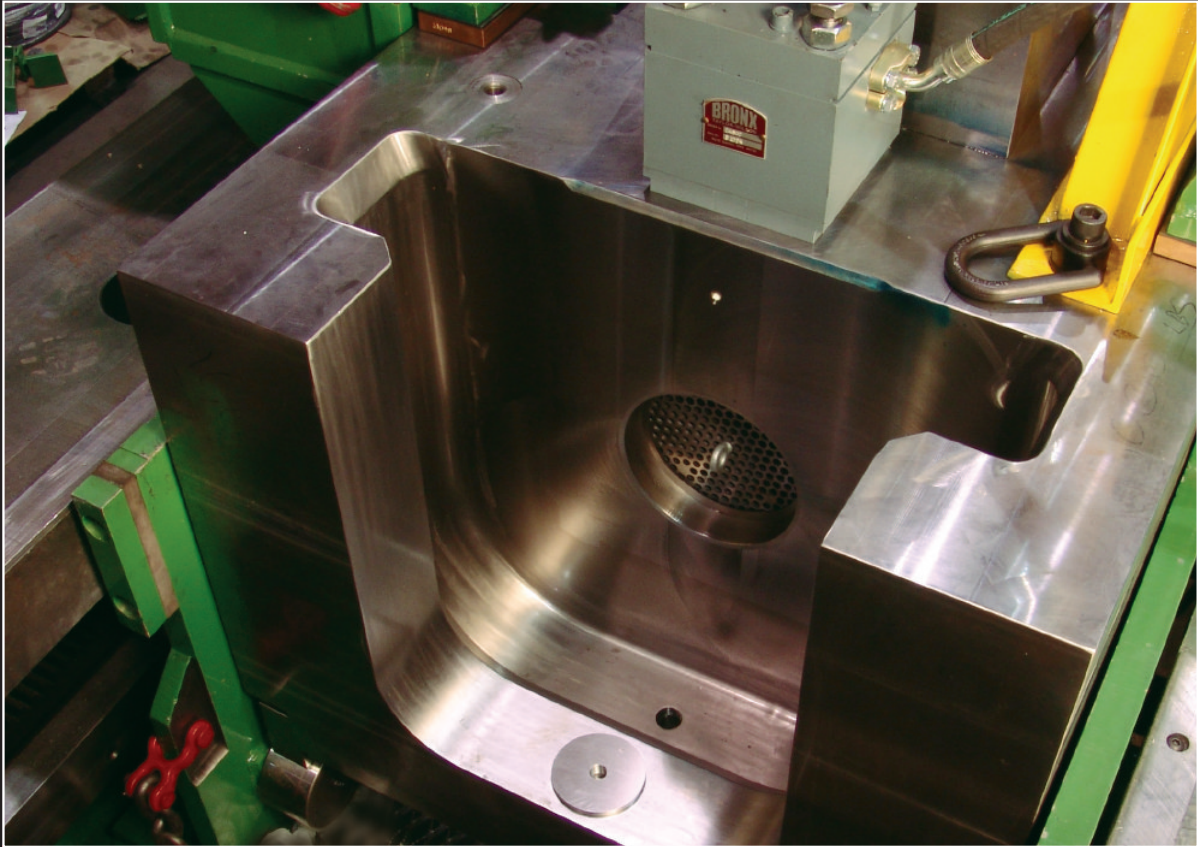
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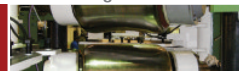


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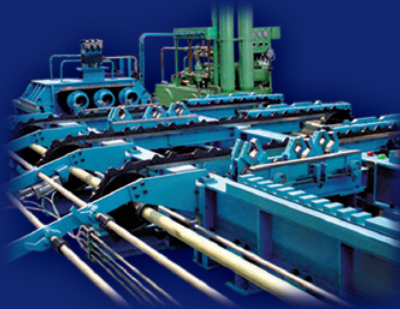
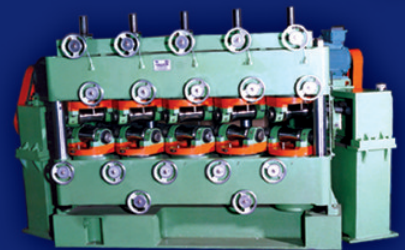
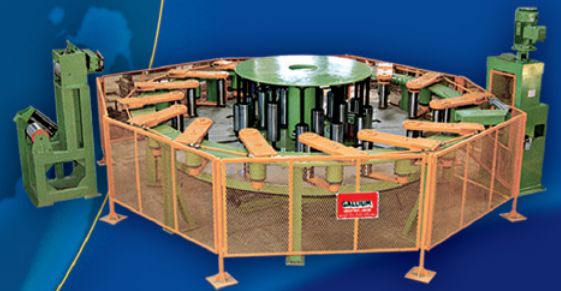
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Contents

Keeping faith in the Russian market

It was 2003 when I had the honour to attend the very first Tube Russia exhibition. Started at the height of Russia's (and the world's) economic boom, the inaugural Tube Russia revealed a market to the tube and pipe community that had hitherto been a bit of a mystery.

At the time, other than the Russian history studied at school, I knew little about the world's largest country: its traditions, culture, language, economy and business mentality. But from my first visit, I discovered Moscow to be a fascinating and complex city, with hidden and enriching layers beneath a surface hardened by history. The country had clearly been waiting for some form of economic stability, increased living standards, and free market business.

Tube Russia has now been running for six years, in which time an increasing number of companies have been drawn into the Russian market. Some rules still apply for this difficult to penetrate market, such as expensive freight and the necessity to find a regional partner. But a more open approach is gradually emerging, assisted by easier business policies and a more dynamic generation of business people.

With the current state of the global economy, and Russia traditionally being a place of financial instability, the best approach to take with the Russian market is one of faith. While the world holds its breath over the current economic crisis, the majority of businesses are still out there trying to carry on as normal.

And this year's sold-out Tube Russia will be a great opportunity for companies to put this faith and confidence on display. The event should prove to be as on-song as ever, especially taking place in the same week as the Eurovision Song Contest.

To help the industry communicate with the Russian market, *Tube & Pipe Technology* has just launched a Russian language news service. The main news and feature sections will be translated into Russian every issue and posted on www.read-tpt.com.



Rich Sears

Editor • Email: richard@intras.co.uk

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TUBE & PIPE TECHNOLOGY

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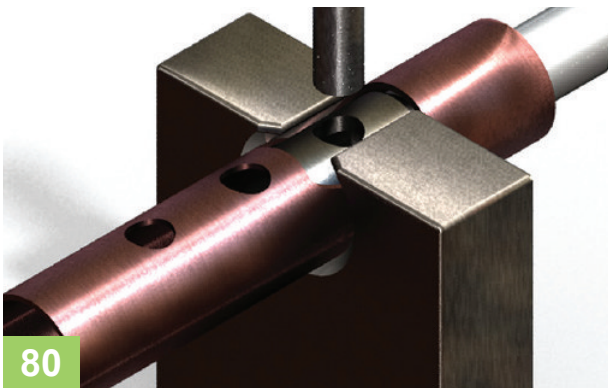
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58 Tube Russia 2009: Moscow, Russia

Tube Russia has not stopped growing in strength since it was first launched in 2003. Held annually – and every two years alongside wire Russia – the event continues to attract the big names in the tube and pipe industry. This year's sold-out event will take place from 12-15 May 2009 at the Krasnaya Presnya exhibition centre in Moscow. The event will again provide a comprehensive networking opportunity for Russia and the CIS region.



80

80 Drilling, Piercing & Punching Technology

The related areas of drilling, piercing and punching deliver true precision to tube and pipe manufacturers. However, it is essential that this equipment must not only operate with pinpoint accuracy, but also offer incredible versatility with minimum scrap. And these machines deliver – offering punching and drilling expertise with multi-hole capability for a whole range of sections, profiles and materials.



94

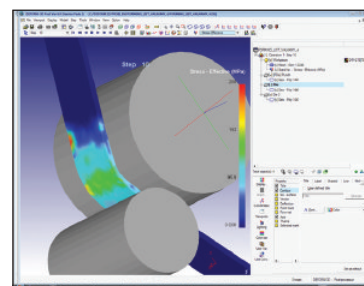
94 Handling & Packaging Equipment & Technology

'Handle with care' is often a phrase uttered in caution, but not often taken as seriously as in the handling and packaging of tube and pipe. From machine to shopfloor, to loading bay, and out the door to its final destination, tube and pipe must be protected every step of the way. But what is often not fully realised are the efficiency gains and space saving facilitated by innovative handling. The handy equipment of this feature includes storage systems, forklift trucks, bundling systems, and transport tracks.

Technical Article

108 New solutions for simulation of hot and cold tube rolling processes

By Mr A Vydrin, OJSC RosNITI, Russia





International Tube Association launches 30th anniversary celebrations

The International Tube Association, the leading global association for tube and pipe engineers and other industry professionals, will mark its 30th anniversary in 2009 with a series of celebrations to highlight the milestone.

Established in 1979, the ITA has continually sought to develop and increase its influence in virtually every corner of the globe. To document the occasion of the 30th anniversary, the ITA will publish and distribute a commemorative booklet charting the ITA's history.

The ITA's celebrations will be aimed at recognising the loyal support of long-standing members, while also informing newer and potential members of the Association's rich history. The 30th anniversary year will again be busy punctuated by several important events, reflecting the ITA's continuing role within the tube and pipe industry.

Firstly, a members' buffet reception will take place at the annual general meeting on 20 May 2009. In addition, members attending the Tube Russia, Tubotech and

Tube Southeast Asia exhibitions in 2009 will be invited to visit the ITA booth for special hospitality.

Later in the year, the ITA will stage a celebration at the Istanbul Pipe & Tube conference in Turkey.

During its 30 year existence, the ITA has organised or co-organised no less than forty-seven technical conferences or seminars in the UK, Belgium, Germany, Singapore, France, USA, India, Mexico, Italy, Hong Kong, China, Goa, Canada, Spain, Thailand, Czech Republic, Japan and Ukraine.

The conferences in 2009 are planned for China (Pipe and Tube Beijing 09) and Turkey (Pipe & Tube Istanbul 09).

International Tube Association – UK
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Website: www.itatube.org

TUBE & PIPE INDUSTRY
30
Years of Global Experience

South American success on the agenda for Tubotech 2009

Tubotech will take place for the fifth time from the 6-8 October at the Imigrantes Exposições facility in São Paulo, Brazil. The influential show will again run concurrently with Metaltech, set to develop into the most important wire exhibition in South America.

Major international sponsorship will again come from the International Tube Association.

The president of Abitam, Carlos Eduardo de Sa Baptista, states, *"Tubotech is a fair that surpasses its previous results, in exhibitors as well as in exhibition area, volume of business and technological innovations. The event has shown an extraordinary drive resulting in a synergy between visitors from Brazil and abroad that will enable them to find product launches, leading technologies and business opportunities."*

Organisers Grupo Cipa will again be joined in a successful partnership by Messe Düsseldorf, the international organisers for Tubotech. Abitam – the Brazilian Metal Pipes and Accessories Industry Association – is the official local sponsor of Tubotech.

The last event in 2007 drew a very positive response from many exhibitors and visitors. A total of 11,921m² of exhibitor space was booked for the 2007 exhibition, compared with 5,500m² for the 2005 event.

The number of exhibitors also increased by just under 50 per cent in 2007 compared to 2005. Similarly, visitor attendance grew from 8,700 in 2005 to just over 12,000 in 2007. This substantial increase was facilitated by the introduction to the event of Messe Düsseldorf as the organisers and promoters of international exhibits from outside South America.

This year's Tubotech is set to be even more popular, with the news that Messe Düsseldorf has been tasked by the German Federal Ministry of Economics and Technology with coordinating an official national participation. This will ensure an attractive participation for all German exhibitors and attests to the success the event has enjoyed in the past.

Tubotech offers free entry to trade visitors and its opening hours are 2-9pm over 3 days.

Grupo Cipa – Brazil
Fax: +55 11 5585 4359
Email: cipa@cipanel.com.br
Website: www.tubotech.com.br

⬇ Tubotech 2009 will again take place in Brazil's largest city and business hub, São Paulo





SMS Meer acquires Schumag machinery division

SMS Meer GmbH, Germany, a company within the SMS group, has taken over the machinery division of Schumag AG, Germany, and thereby supplements its product range for plant and machinery in the fields of copper and bright steel.

Around 300 of the total of 1,000 Schumag employees will work for the new company, SMS Schumag GmbH & Co KG, which will continue to be operated as an independent unit at the Aachen location. To this end, Schumag has leased office facilities and production shops to SMS Meer on a long-term basis.

The capacities in respect of production, sales, engineering and service as well as the employees of the Schumag machinery division abroad (UK, USA, China) are likewise being transferred to SMS Meer. The Schumag brand name will be retained.

Dr Joachim Schönbeck, president & CEO of SMS Meer GmbH, states, "Through the purchase of the Schumag machinery segment we are expanding our product range and opening up further potential for growth of the SMS group as part of its global presence."

Mr Heiner Kudrus, a member of the executive board of Schumag AG, says, "The product ranges of SMS Meer and of the Schumag machinery segment complement each other optimally, and therefore no jobs are endangered. Furthermore, the SMS group enjoys an excellent reputation as an employer. By belonging to the SMS group, the employees of the Schumag machinery segment have the very best of prospects opened up to them."

The SMS Group is an international group of companies active in plant construction and mechanical engineering for the steel and nonferrous metals industry. It consists of the two business areas SMS Demag and SMS Meer, which jointly form SMS metallurgy.

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DIARY OF TUBE EVENTS

2009

MARCH

- 05-08 Boru 2009**
Istanbul, Turkey
Exhibition ➔ Email: info@ihlasfuar.com
 Website: www.ihlasfuar.com
- 18-20 Global Oil & Gas Pipeline Congress**
Beijing, China
Conference ➔ Email: david.xiao@araworldwide.com
 Website: www.globalpipelinecongress.com

MAY

- 05-07 Shanghai Tube Expo**
Shanghai, China
Exhibition ➔ Email: ndpymq@126.com
 Website: www.gangguan-expo.com
- 12-15 Tube/wire Russia 2009**
Moscow, Russia
Exhibition ➔ Email: wolfgramc@messe-duesseldorf.de
 Website: www.metallurgy-tube-russia.com
- 26-29 Citypipe**
Moscow, Russia
Exhibition ➔ Email: citypipe@sibico.com
 Website: www.citypipe.ru

JUNE

- 02-04 Fabtech Mexico**
Monterrey, Mexico
Exhibition ➔ Email: info@fmanet.org
 Website: www.fmanet.org
- 10-12 Tubes + Fittings Ukraine**
Kiev, Ukraine
Exhibition ➔ Email: olga@welding.kiev.ua
 Website: www.weldexpo.com.ua

JUNE

- 23-24 Pipe & Tube Beijing 2009**
Beijing, China
Conference (ITA) ➔ Email: info@itatube.org
 Website: www.itatube.org

OCTOBER

- 06-08 Tubotech/Metaltech 2009**
São Paulo, Brazil
Exhibition ➔ Email: cipa@cipanet.com.br
 Website: www.cipanet.com.br
- 13-15 Tube/wire Southeast Asia**
Bangkok, Thailand
Exhibition ➔ Email: tube@mda.com.org
 Website: www.tube-southeastasia.com

NOVEMBER

- 02-03 Pipe & Tube Istanbul 09**
Istanbul, Turkey
ITA conference ➔ Email: info@itatube.org
 Website: www.itatube.org
- 10-13 Metal Expo**
Moscow, Russia
Exhibition ➔ Email: yakovenko@metal-expo.ru
 Website: www.metal-expo.ru
- 15-18 Fabtech/AWS Welding Show**
Chicago, USA
Exhibition ➔ Email: information@mfafabtech.com
 Website: www.mfafabtech.com

2010

FEBRUARY

- 10-12 Tube India**
Mumbai, India
Exhibition ➔ Email: schreiberg@messe-duesseldorf.de
 Website: www.tube-india.com

APRIL

- 12-16 Tube/wire Düsseldorf**
Düsseldorf, Germany
Exhibition ➔ Email: liedtkeM@messe-duesseldorf.de
 Website: www.tube.de

Exhibitor bookings start for Tube 2010

Exhibitor bookings are now being taken for the next Tube Düsseldorf, planned for 12-16 April 2010, in accordance with a number of changes to the booking procedure and media service. Following the last event in 2008, organizers Messe Düsseldorf carried out a complete review of the highly successful Tube and wire shows.

 The Messe Düsseldorf website will be the source of even more information for Tube 2010



The next event in 2010 should prove an even bigger draw, particularly due to the removal of Metav from the show billing. It will be possible for tube exhibitors to take full advantage of the expanded Messe Düsseldorf showgrounds, with a higher number of prime positions available for 2010. Tube 2010 will return to its more familiar location of halls 1 to 7.0, while wire 2010 will take place in halls 9-12 and 15-17

To speed up the booking process, Messe Düsseldorf will now accept exhibitor applications for Tube 2010 directly via the www.tube.de website, in addition to the usual faxed and mailed forms. To download the application forms for 2010, it is necessary to register and log on (see www.tube.de/2330 for the English form).

Exhibitors at the next show will also be given an enhanced media service, which involves a compulsory web portal media charge of €320. This

binding fee will enable Messe Düsseldorf to provide an expanded media service to supplement the already successful printed version of the show catalogue. Exhibitors can still submit a catalogue entry at <http://tube.media-entries.com>.

The media service will provide exhibitors with a company profile and product descriptions on the online portal and the KATI visitor information system. There will be a special visitor news section, containing the latest company and product news.

Exhibitors will be able to list company contact names, integrate website links into their company profile, upload photo and video content, and publish a timetable of stand events. Other benefits will include online appointment scheduling, visitor/exhibitor matchmaking, and user controlled editing.

The International Tube Association (www.itatube.org) has announced it will offer members an exclusive exhibitor shell scheme package for Tube 2010, set at lower prices than 2008.

Messe Düsseldorf – Germany

Fax: +49 211 4560 87

Email: zanderh@messe-duesseldorf.de

Website: www.tube.de

Nivora completes successful takeover of Bewo

Nivora Holding BV, the Netherlands, has acquired the activities of Bewo BV, based in Tilburg, the Netherlands. Bewo has been in operation for many decades on an international scale in the field of metal tube cutting systems.

The Dutch based company Safan BV (www.safan.nl) in Lochem is also part of Nivora Holding BV and has an excellent reputation as a worldwide manufacturer of high quality and innovative sheet-metal working machines. Safan has a very solid financial backing with a successful track-record and operations/branches in the Netherlands, UK, Germany and Asia.

Nivora Holding financed this 100 per cent acquisition including the working capital by its own financial means. As Safan and Bewo are serving customers in similar and/or complementary markets, occasionally also operating through the same agents and/or distributors, these and other synergies between Bewo and Safan will be strengthened.

The name of the new company is Bewo Cutting Systems BV. The company will continue with its former activities, which include the manufacture of its existing range of metal tube sawing machines and systems – both the standard devices (CPO machines), and the speciality machines (tailor made and customized sawing and cutting solutions).

The company's staff is focused on restructuring and preparing the organisation for the near future, placing emphasis on marketing, production, product development, engineering and logistics. Bewo will continue to provide the market with high quality machines and services, achieved through proactive organisation and existing professionals and experts.

Bewo Cutting Systems BV – The Netherlands

Fax: +31 013 4680201

Email: info@bewo.nl • **Website:** www.bewo.nl

Roll-Kraft continues to grow

Roll-Kraft has added Mr Norman VanHorn and Mr Bruce Wolfe to the staff at its headquarters in Mentor (OH), USA. Mr VanHorn and Mr Wolfe are both experienced as machinists and have held various positions in the manufacturing field.

The company has also implemented a new ERP (enterprise resource planning) system to coordinate the information, resources, and activities within the company. This custom-designed package uses a modular format to maintain data and allow easy access by various departments to the basic functions of the business.

The popularity of Roll-Kraft's on-site seminars has also increased in recent months. On-site seminars are more customized and allow discussion and instruction on individual situations that are beneficial to the particular organization.

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Expert forum on narrow gap welding

Polysoude, France, played host to an expert forum on narrow gap welding from 5-7 November 2008. The successful event welcomed around one hundred experts from France, Germany, Austria, Switzerland, Russia, Hungary and the Czech Republic.

The event involved two different sessions in both the French and German languages. A number of high profile speakers gave presentations targeted at welding experts from the high-purity industries, including food, pharmaceuticals, chemicals, semiconductor technology, aerospace and the onshore/offshore industry.

The power plant construction sector is currently booming worldwide, with 700 degree power plants the focus of attention. For plant construction this means using more pressure-resistant, thick-walled pipes made from high temperature steels such as P91 and its successor P92 (X10 CrMoVNb 9-1, WKN 1.4903), conforming to the ASTM standard (American Society for Testing Materials).

The key quality features of this new steel grade are the values for high creep rupture strength that also apply without restriction as the benchmark for every weld seam on these pipes. In particular, the forum on narrow gap welding addressed this area of automated welding technology.

Before the start of the conference programme, delegates were given a tour of the factory where P91 pipes (Ø 620mm and 180mm wall thickness) were joined using a narrow gap torch in the TIG orbital welding process using a hot wire additive. The joined seams offer 100 per cent

penetration, are x-ray proof, and meet the highest requirements for metallurgic and mechanical quality values.

Following the tour, the host and Polysoude's CEO, Mr Hans-Peter Mariner, offered an in-depth insight into the latest developments in narrow gap welding. This presentation highlighted that with wall thicknesses of over 60mm, welding time is shortened by a factor of five to ten in comparison to conventional TIG processes with a traditional V seam.


The welding characteristics of the parent material are the decisive factor in the application of the narrow gap process. Technical advances in equipment technology such as automatic centring, HF-free ignition, seam preparation and optimised gas protection further increase the application limits.

The geometry and gap width of the weld groove are based on the mechanical properties of the materials being joined, with the shrinkage characteristics of the seam being particularly important.

Another key part of the programme was a presentation on the three different narrow gap-welding techniques. The first involves a single pass weld per layer and torch or workpiece revolution. The second is dual pass welding next to one another, when the seam preparation or positioning exceed the required narrow tolerances of a few tenths of a millimetre for one stringer bead per layer.

TIG narrow gap welding with a shuttle-motion electrode is ideal with very large wall thicknesses of 150-200mm. This is particularly the case if the necessary



 In practice – setting of a narrow gap torch on a P91 pipe (620mm diameter and 180mm wall thickness)

boundary conditions – such as accuracy of the seam preparation, handling of the shrinkage process and torch design – cannot easily be ensured for joining using one stringer bead per layer.

The second day of the forum began with an in-depth presentation on 'Applications, solutions – implemented projects'. During the past financial year, in the area of boiler construction for power plants, Polysoude has fitted more than 30 made-to-measure circumferential seam welding systems for automated TIG welding and several hundred orbital welding systems for custom applications.

Following a comprehensive question and answer session, the perfected, mechanised welding process was demonstrated on a rotating part. To conclude the expert forum, the turnkey solutions offered by Polysoude for joining rotors were on display for participants. A narrow gap welding system for manufacturing turbine rotors of up to 300 tonnes was set up in the factory hall.

Polysoude will hold a new conference session for experts in narrow gap welding in the English language, at the end of March.

Polysoude – France
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 The expert forum for narrow gap welding – specialists all over Europe were interested in this technology for the field of energy production and boiler manufacture



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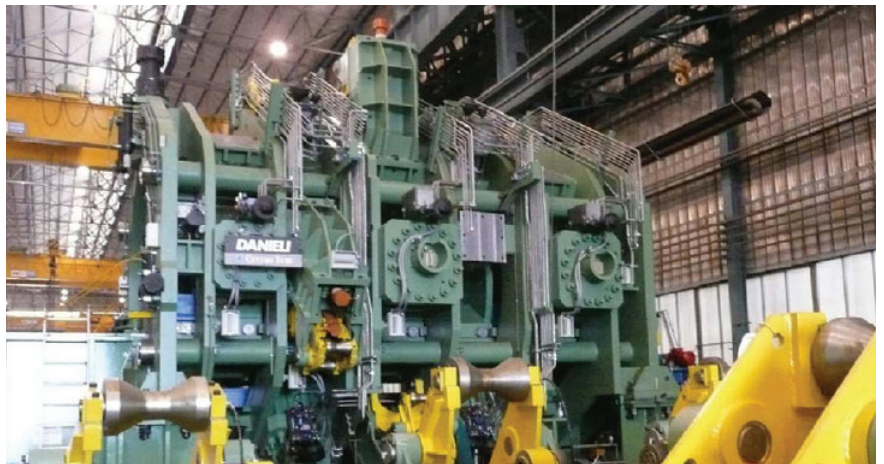


Seamless pipe mill to commence operations in the Middle East

Jubail Energy Services Company (Jesco), Saudi Arabia, will begin operations at its new seamless pipe mill at the start of this year. The first seamless pipe mill in the Middle East came about due to an initiative between Duferco, Switzerland, TAQA – Industrialization and Energy Service Company based in Riyadh, Saudi Arabia, and other prominent Saudi investors.

Based in the Jubail industrial area, the pipe mill was planned as a strategic objective and commercial necessity for the Middle East region and specifically Saudi Arabia. The plant will have an estimated pipe production capacity of up to 500,000tpy, mainly OCTG and linepipe, in a range of 139.7mm up to 406.4mm.

The state-of-the-art plant will incorporate a Danieli designed FQM mill – fine quality mill (3-rolls continuous rolling mill with retained mandrel), a 3-stand extractor mill and 10-stand sizing mill, all in 3-roll design. Sophisticated heat treatment will allow Jesco to achieve up to 140,000psi yield strength, with a capacity up to 200,000tpy.



 Jesco's new seamless pipe mill in Saudi Arabia

The seamless pipe manufacturing facility is completed by two quality lines, two finishing lines and a coupling workshop. In-house laboratories include a horizontal pipe test collapse machine and a sour gas testing section. Level 1 and 2 automation systems provided by Danieli Automation will allow overall plant control and maintenance.

Level 3 software also supplied by Danieli will provide the tools to optimize the internal supply chain through its specific functions.

The plant is located in a dedicated area of 322,000m², 10km from the Arabian Gulf and 80km from Dammam port.

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Website: www.danieli.com

Jesco – Saudi Arabia
Fax: +966 3 340 4495
Website: www.taqa.com.sa



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Standard: EN10216-5, ASTM A269/A213, DIN17458

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OCTG LLP adds thread line capacity

OCTG LLP, USA, is adding a third double-ended PMC thread line at its Houston facility, expected to be operational by March 2009. The new line can accommodate tubing and casing with diameters from 2 3/8" through to 5 1/2" OD.

The company presently operates two PMC thread lines with OD capacities of 4 1/2" to 13 3/8". The company claims these to be the only mill-speed threaders available for contract end-finishing in the United States.

OCTG LLP is a leading provider of end-finishing services, such as API threading and inspection, to major manufacturers, distributors, and end-users of oil country tubular goods. The company operates at its 150-acre facility with a private rail spur, and has plans to return its on-site barge terminal to operation.

Available inspection services include full-body ultrasonic (UTFL), electromagnetic (EMI), ultrasonic weld line (UTWL), dry and wet magnetic particle (MP), and a variety of API thread gauging and inspection.

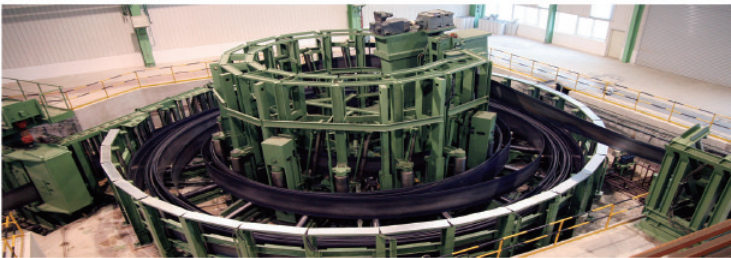
Threading services are performed on PMC double-ended tube mill thread lines, which include facing/bevelling operations, threading, and buck-on. OCTG also operates a complete double-ended Mori Seiki SL-8 casing line.

OCTG LLP – USA
Fax: +1 281 456 8877
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Second time round for Tube Southeast Asia 2009

Tube/wire Southeast Asia will take place for the second time from 13-15 October 2009 at the Bangkok International Exhibition Centre (BITEC), Thailand.

Following a highly successful launch show in 2007, which attracted 381 exhibiting companies from 30 countries and 7,038 visitors, the event is set to build on the success of Southeast Asia's economic growth.

Southeast Asia continues to exhibit good economic development despite the global economic situation, with Vietnam leading the region with 8.5 per cent growth in 2007. Thailand, Singapore, Malaysia, Indonesia and the Philippines have also recorded positive growth. GDP projections for these countries remain positive for the next few years.

Foreign direct investment (FDI) inflow registered a 25 per cent increase in 2006, to reach its highest level of US\$51 billion. The Thai government is targeting investment of one trillion baht by 2009 from both domestic and foreign businesses. Both Vietnam and Malaysia are viewed as competitive investment destinations.

There is a necessity for infrastructure investment in Southeast Asia. Thailand,

Vietnam, Malaysia and Indonesia are prioritizing their infrastructure development so as to enhance their competitiveness and long-term growth. Thailand has recently set a goal to complete the 770 million baht Bangkok mass transit project within 3.5 years.

The automotive industries in Thailand, Indonesia and Malaysia continue to grow in importance as end users of wire, cable, tube and pipe products.

In 2007, Thailand manufactured close to 1.3 million light vehicles, a figure that is forecast to grow to over 2 million by 2012. Indonesia has emerged as an export centre for multi-purpose vehicles. Malaysia's automotive clusters are to be developed at several locations and local production of parts and components is also set to rise.

The Thai Board of Investment (BOI) aims to promote the upstream steel sector, turning Thailand into ASEAN's hub of high-quality

steel. Vietnam has plans for a major steel complex with a capacity of 7.5 million tonnes per year starting in 2011.

Taiwanese companies will invest US\$6 billion in the plant. Malaysia plans to expand its steel industry through investing around US\$13 billion to support the needs of the metal fabrication, engineering and construction industries.



Home to Tube Southeast Asia – the Bangkok International Exhibition Centre

Bangkok will again be host city to the second Tube/wire Southeast Asia



Thailand is one of the largest petrochemical producers in the world and continues to invest in new facilities, with at least six major plants set to start up in 2010.

Vietnam plans to invest heavily in petrochemicals and petroleum refining. Two oil refineries are being built and a third targeted for completion in 2015.

A number of gas transmission projects have been proposed in Indonesia, including the building of a gas pipeline from South Sumatra to Batam.

"The importance of the southeast Asia tube and pipe market cannot be over-emphasised. The relocation to Bangkok was readily supported by the ITA as we recognised the importance of the Thai market as well of those in surrounding countries. The successful outcome of the 2007 exhibition fully justified that support," says Mr Albert Sedlmaier, chairman of the International Tube Association (ITA).

Tube Southeast Asia 2009 is organised by Messe Düsseldorf Asia, with sponsorship and support from the International Tube Association.

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Extensive modernisation for seamless pipe manufacturer

Valcovna Trub TZ, AS, Czech Republic, has reported notable success from the start-up of its most extensive investment project. In the middle of last year, the company began operation of its modernised main production line – the big Mannesmann. The reconstruction and modernisation cost 700 million Czech koruna.

customers, and a generally increasing demand for seamless steel pipes of larger diameters. *“The main asset, besides increasing the amount of our overall production, is improvement of the pipes’ surface quality and accuracy,”* commented Mr Jaroslav Sarovsky, MBA, director of the company.

The company decided to modernise due to the requirements of present and potential

Valcovna Trub TZ (VTTZ) has two production lines – the small Mannesmann, which produces pipes with an outer diameter from 60-168mm, and the big Mannesmann, which manufactures pipes from 168-406mm outer diameter.

VTTZ has had success from its biggest ever modernisation programme



During the last year, the company produced more than 105kT of pipes, about 57 per cent of which were delivered by the big Mannesmann’s production line.

“After the modernisation we envisage an increase in our annual production of about 18kT on the main production line

(around 32 per cent),” said Mr Sarovsky. Within the context of the modernisation, a large number of employees had to be retrained for more exacting equipment.

In addition to the Czech market, the markets for these products are most European countries and some of the states of North Africa, and the Middle East, Asia and the American continent. The share of the export represents around 70 per cent.

The company’s products are used in applications in engineering and the automotive industry, construction, chemicals, oil and gas extraction, and water drainage.

The pipes have been used in truck frames, trolleys, railway wagon bumpers, frames as part of construction of roller coasters, in the O₂ Arena in Prague, Czech Republic, and in the Olympic stadium in Berlin, Germany. They are also to be found in two Czech nuclear power plants – Temelin and Dukovany.

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Hypertherm acquires leading manufacturer of CAM nesting software

Hypertherm, the Netherlands, a provider of plasma arc metal cutting technology, has acquired the core assets of MTC Software, a developer of computer-aided manufacturing (CAM) software used by the metal processing industry.

MTC's software product helps companies in the metal cutting industry optimize cuts so that cut quality and productivity are improved while producing less scrap. The CAM software is used in conjunction with CNC systems for oxy-fuel, plasma, waterjet, laser and other cutting processes.

"Hypertherm's plasma cutting systems already provide industry-leading performance, reliability, and productivity," said Hypertherm founder and president Mr Dick Couch. *"The marriage of MTC's software with our CNC motion control products will continue to provide Hypertherm and MTC customers with repeatable, optimized cutting outcomes and easy integration."*

"Both Hypertherm and MTC share the same goal of making products that will help our customers to become more productive and profitable," said MTC CEO John Rosenberg. *"And while this has always been an MTC goal, it is even more critical in the current economic environment."*

MTC Software, celebrating its 25th anniversary this month, has built a reputation as one of the industry's leading developers of computer aided manufacturing software.

The company is widely recognized for its strong customer focus and first-class technical support. Its ProNest, TurboNest and other products are known for delivering ease of use and increased productivity.

Hypertherm does not plan any significant changes to MTC's operations as a result of this purchase. MTC headquarters will remain in Lockport, New York and its 40 associates will continue to work at their current locations. MTC has offices and distribution partners throughout the world.

Hypertherm designs and manufactures the world's most advanced plasma

cutting systems for use in a variety of industries such as shipbuilding, manufacturing, and automotive repair.

The company's product line includes handheld and mechanized plasma systems and consumables, as well as CNC motion and height controls.

The company's reputation for plasma innovation dates back 40 years, to 1968, with Hypertherm's invention of water injection plasma cutting. The company has more than 1,000 associates along with operations and partner representation worldwide.

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ITA continues technical tradition with Istanbul conference

The International Tube Association's next biennial technical conference, organised jointly with Ihlas Fuar, will take place at the WOW Hotel and Convention Centre in Istanbul from 2-3 November 2009.

The provisional timetable for the conference on 2 November 2009 features welded, seamless and non-ferrous papers as well as a market overview presentation by Metal Bulletin Research. Sessions will be conducted in two very well appointed conference

rooms, with simultaneous Turkish, Russian and English translation.

On the evening of 2 November all delegates and speakers will join with those from the concurrent wire conference to enjoy a social event at the famous Binbirdirek Cistern, located in the old city, close to Hagia Sophia and the Blue Mosque. On 3 November optional plant visits will be available.

The gala dinner will involve an evening of traditional Turkish entertainment. This will form part of the ITA's 30th anniversary celebrations. A selection of sightseeing tours will also be on offer to delegates and their partners before, during and after the conference days.

The joint organisers for the conference are recruiting a high quality panel of speakers for the technical programme and a call for

papers was issued in November 2008. Anyone interested in submitting an abstract for consideration should contact the ITA secretariat immediately.

The ITA's sister organisation, the International Wire & Machinery Association, is co-organising a concurrent wire conference Istanbul Cable & Wire 09. This will be a similar format to the ITA's Prague conferences held in 2005, when a total of 400 delegates participated at the joint events with many enjoying the synergies of these complimentary technical events.

Confirmed conference sponsors include Borusan Mannesman Boru San, *Tube & Pipe Technology Magazine*, *Tube Products International Magazine*, Messe Düsseldorf GmbH and Boru Magazine.

International Tube Association – UK

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Website: www.tube-istanbul.com

 Istanbul will play host city to the ITA's major 2009 technical conference



Tube India 2010 to be held in Mumbai

The organizers of Tube India 2010, Messe Düsseldorf GmbH and Messe Düsseldorf India Pvt Ltd, have announced that the show will be held in the new location of Mumbai. Set to take place from 10-12 February 2010, the event will build on the success of the last event held in New Delhi.

A satellite event of Tube Düsseldorf, Tube India 2010 will take place at the Bombay Exhibition Centre in Mumbai. Tube India will be joined by two concurrent shows – Metallurgy India 2010 and Schweissen & Schneiden India 2010.

This event will be held under the patronage of the International Tube Association (ITA), International Tube Association – India Management Board (ITA-IMB), and the German Engineering Federation (VDMA).

At the 2008 event, over 215 companies participated from 18 countries, inclusive of country pavilions, which were showcased by Austria, China and Germany. Compared to 2006, these 3 shows witnessed an increase of 121 per cent in the exhibitor numbers and 54.8 per cent in visitor numbers.

Messe Düsseldorf India Pvt Ltd – India

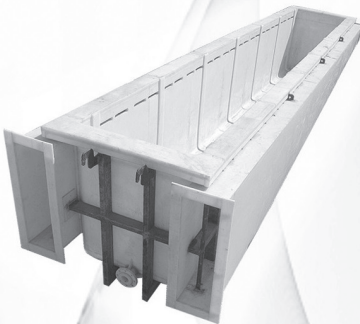
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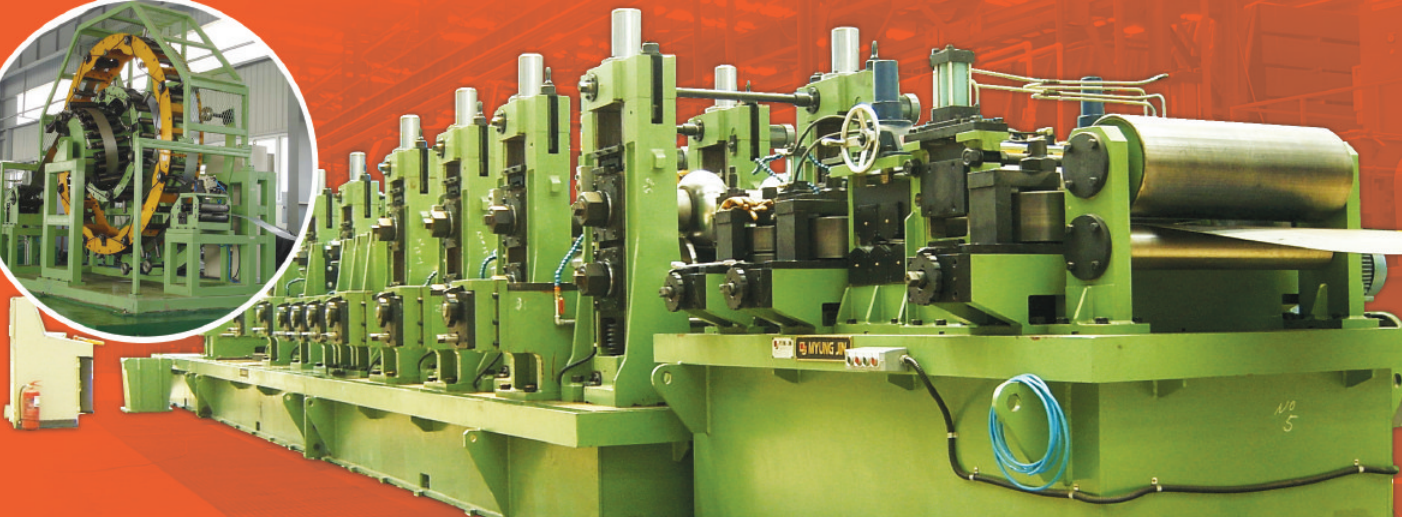
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Precitec and Scansonic combine expertise in laser welding

Precitec and Scansonic have enhanced their cooperation to include an agreement for Russia and other CIS countries. Scansonic has been active for several years in these markets and has already developed important customer relationships. In addition to selling the equipment, technical support and local service will be established in order to speed up the acceptance of the advanced technologies in the industrial sector of the target countries.

Precitec will sell and support the laser brazing and welding products of Scansonic in Korea, North America and parts of China. These geographies are home to some of the biggest producers of automobiles in the world. The markets are rapidly catching up with the modern laser manufacturing technologies first implemented in Germany. Market size in the targeted area opens up extraordinary opportunities for growth.

Both partners will jointly develop an optimized product combining modular components and tactile seam tracking technology from Scansonic with Precitec's

process monitoring for laser brazing and welding. The proven Precitec laser weld monitor (LWM), as well as the seam inspection systems SGM and Souvis®5000, will be utilized.

Scansonic is the leading supplier of laser welding and brazing equipment with tactile seam tracking. The company's specialist areas are car bodies and other complex components in automotive manufacturing.

Since 1971, Precitec has been a leading solutions provider in the field of laser processing and serves the entire industry. Both companies now partner up and make use of their complementing strengths to supply customers with the best of both worlds.

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Fax: +49 30 91 20 74 29
Email: info@scansonic.de
Website: www.scansonic.de

Precitec KG – Germany
Fax: +49 7225 684 900
Website: www.precitec.com

Joint regional technical conference in Beijing

The International Tube Association and its representative in China, the China Cold Roll-forming Steel Association (CCRSA), will co-organise a joint technical conference in Beijing in 2009. *Pipe & Tube Beijing 2009* will take place at the North China University of Technology from the 22-23 September 2009.

The conference theme will be 'Advanced manufacturing techniques for pipes and tubes for structural, oil, gas and auto industries'. Added attractions will be tabletop exhibits and optional plant tours to an oil/gas tube producer, an auto tube producer and a technical tour and explanation of the iconic Birds Nest Olympic stadium.

The conference is expected to attract a large Chinese audience as well as international delegates. The conference will be conducted in simultaneous Chinese and English.

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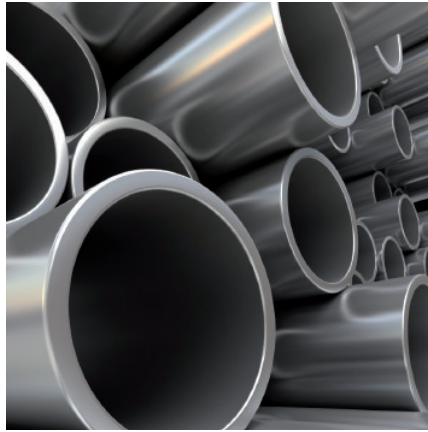
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Valve World moves to Düsseldorf in 2010

Valve World Expo has been acquired by Messe Düsseldorf from KCI Publishing BV, the Netherlands. The next event will be held in Düsseldorf, Germany, from 30 November to 2 December 2010.

KCI Publishing will remain the coordinator of the leading international industry event. The two organizers have agreed to work closely together to promote the trade fair's further development.

Mr Donald Wiedemeyer, CEO of KCI Publishing, comments, "Over the past few years, Valve World Expo has developed very positively to the extent that we have reached our limits in terms of venue and organizational capacity. In Düsseldorf, the event will have a chance to continue expanding and extending its international reach even further."

Werner Matthias Dornscheidt, president and CEO of Messe Düsseldorf, is delighted with this addition to the trade fair program, "Valve World Expo is the world's No 1 event for its industry and, together with

the Valve World Conference, it serves as an important meeting point for flow control professionals. It also fits in perfectly with our portfolio of metallurgy trade fairs staged here in Düsseldorf as well as around the world."

Valve World Expo's positive development over the past few years is reflected not only in the steady increase in exhibitor and visitor numbers but also in the amount of exhibit space booked. The last staging in November 2006 attracted 430 exhibiting companies from 34 countries and 9,000 trade visitors from Europe, Asia, North and Latin America.

The trade visitors are predominantly from the on- and off-shore oil and gas industry, the petrochemical industry, the nuclear power generating industry, the food industry, and the shipbuilding industry.

Messe Düsseldorf – Germany

Fax: +49 211 4560 87

Email: zanderh@messe-duesseldorf.de

Website: www.valve-world.net.

CRC-Evans celebrates 75th year

CRC-Evans, a global provider of pipeline equipment and services, will celebrate its 75th anniversary in 2009. To mark the event, the company will produce an exclusive commemorative book containing historical photos of the industry captured in the last 75 years.

"As we commemorate our 75th year, we want to also honour the industry," said Mr Paul Evans, chairman of CRC-Evans. "If it were not for the hard work, tenacity and perseverance of pipeliners who had such foresight, we wouldn't have the foundation and framework in place today to continue to deliver our equipment and technology."

"Because we've been so involved in the major industry developments of the past 75 years, we've been able to collect an archive of dynamic photos that capture the spirit of the industry," said Mr Tim Carey, CRC-Evans chief executive officer. "We felt the anniversary was an opportunity to archive our shared history as well as share memories with our friends in the industry."

TUBE FINNING MACHINE

This machine works on the principle of Roto Advancing mechanism of tube & fins are crimped and wound around the periphery of the tube under high tension.

CAPACITY: Two models are available:

PTF-40: Suitable for Tube OD 9.5mm to 40mm.

Fin Height 5mm to 20mm.

Fin Thickness upto 0.5mm

PTF-100: Suitable for Tube OD 25mm to 100mm.

Fin Height 5mm to 25mm.

Fin Thickness upto 0.5mm

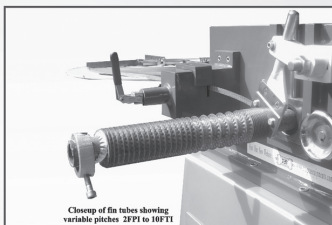
POWER: PTF 40: 2 HP Geared Motor with V.F.D.
PTF 100: 5 HP Geared Motor with V.F.D.

CONSTRUCTION:

BASE: M.S. Fabricated with foundation provision and leveling arrangement.

BODY: Capsule type Roto advancing arrangement of Tube for continuous tube finning and mandrel arrangement for manufacturing of Fin Coil. Adjusting for pitch 2.5mm to 6.00mm.

DRIVE: Geared Motor with variable frequency drive for changing speed various sizes of Tubes.



Closeup of fin tubes showing variable pitches 2PPI to 16PPI

AWARDS:

Mr. L.C. Tolani has received the NATIONAL AWARD for the outstanding SSI entrepreneur on 30th Aug. 2000 at Vigyan Bhawan, New Delhi from the Honourable Prime Minister Shri Atal Bihari Vajpai.

Earlier in 1997 he received the BHARAT VIKAS AWARD from Dr. V. Venugopalachari, the Minister of State for Agriculture (Govt. of India).

Our Team, headed by Mr. L.C. Tolani, Consists of other Senior Directors, G.M. & Works Manager having an experience of 15 to 35 years in the fields of oil seed processing.



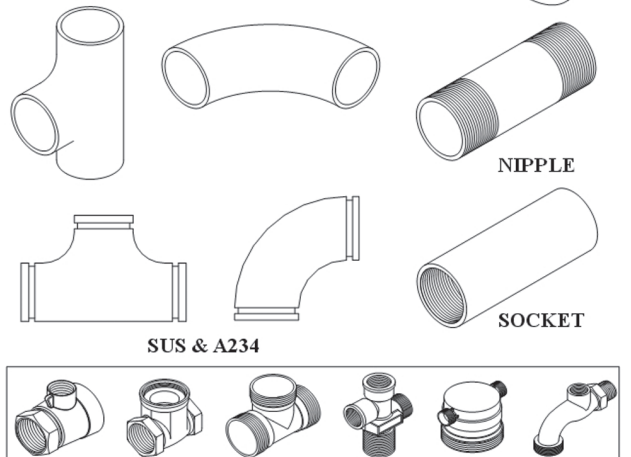
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- ⊕ Pipe fittings for fire protection , petro-chemical & pulp industry , etc.
- ⊕ Auto threading m/c for socket & nipple.
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Since 1933, CRC-Evans and its predecessor companies have supported the industry's pioneers and leaders by developing much of the pipeline construction equipment used to build the world's pipelines. With a rich history entrenched in innovation, CRC-Evans has continuously sought to improve processes through its technology and equipment.

From the introduction of the first coat and wrap machine in 1934 to the development of fully digital automated pipeline welding systems in 2007, CRC-Evans has supported the industry's progression for three quarters of a century.

Today, CRC-Evans provides bending and padding equipment, automatic welding systems, weighting systems, field joint coating, heat treatment, inspection services, pipeline equipment, pipe coating, and laybarge equipment.

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Website: www.crc-evans.com

18th international conference on pipeline protection

BHR Group's 18th international conference on pipeline protection will provide the latest information on research, development and applications in this critical area. The organisers have issued a call for papers for presentation at the conference that will be held in Antwerp, Belgium, from 4-6 November 2009.

Established in 1975, this biennial event is recognised as the premier technical conference on the subject. Building on the success of its predecessors, the latest event presents an ideal opportunity for anyone involved in the commissioning, operation and maintenance of pipelines.

Pipelines are big business with an estimated five million kilometres dedicated globally to energy and water transmission and supply. They are universally recognised as the most sustainable, efficient and cost-effective way to transport liquids, slurries and gases. But without proper design, installation, operation and maintenance they can fail with potentially disastrous consequences in terms of pollution from leaking hydrocarbon pipelines or unacceptable losses from water mains.

The conference will provide a forum for presenting practical solutions and debating the future direction of the pipeline industry. Contributions are welcomed in the form of technical papers or case studies on all aspects of pipeline protection including current techniques and new developments.

Papers are likely to cover themes including field joint coatings, engineered coating solutions, internal drag-reducing coatings, surface preparation, external and internal coatings, and cathodic protection. Other

topics include operation of very large diameter water pipelines, maintenance and monitoring, and rehabilitation.

The conference is designed for anyone associated with the oil and gas, chemical and water industries.

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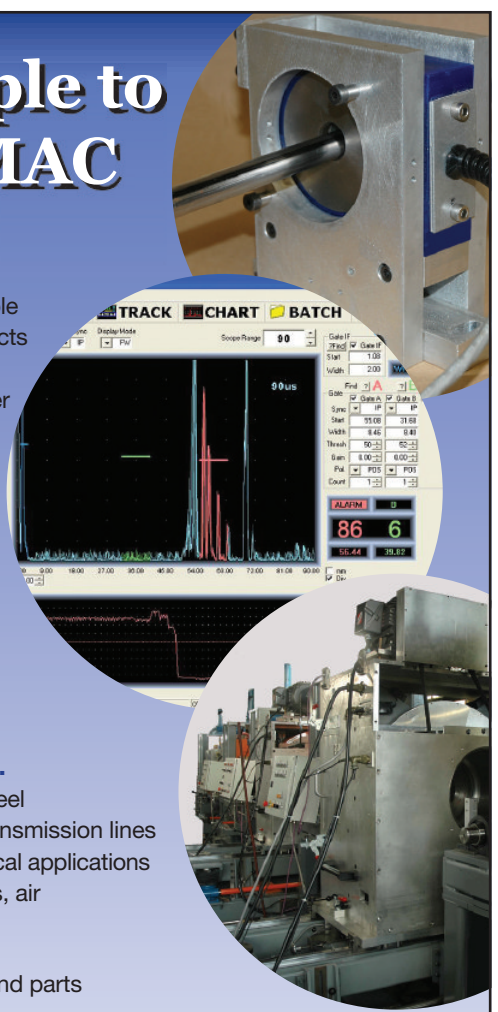
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Event News in Brief...
event news in brief...

 The **5th Shanghai Tube Expo** (www.gangguan-expo.com) will be held from the 5-7 May 2009 at the Intex Shanghai showgrounds in Shanghai, China. Shanghai Tube Expo is one of the largest exhibitions of its kind not only in China, but also in the Asia-Pacific region. The exhibition is targeted at equipment and tube products for industries including petroleum, automobile, petrochemical, shipbuilding, boiler, power station, and construction.

 Following its recent Intube in-house event, the **BLM Group UK Ltd** (www.blmgroup.com) has received orders valued at nearly £1.5 million. The five-day event introduced the new BLM Adige LT 722D Lasertube tube processing system to the UK, building on the success of a similar event early in 2008 that highlighted various models of BLM all-electric tube bending and forming machines.

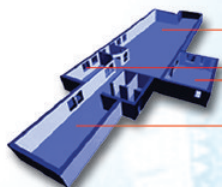
 **Metal Expo** (www.metal-expo.com) was held successfully from 11-15 November 2008 at the new Crocus Expo showgrounds in Moscow, Russia. It was the first time for the exhibition at these more modern showgrounds, with the exhibition having previously taken place at the old style site All Russian Exhibition Centre (VDNK).

 The **3rd Tolexpo** (www.tolexpo.com) will be held from 17-20 November 2009 in Paris, France. Tolexpo, the international show for sheet metal, coil, tube and section equipment, will coincide with Midest, the world's leading industrial subcontracting show and maintenance expo. The exhibition is aimed at nearly 11,000 visitors in search of new equipment, for both renewal and modernization. The last exhibition achieved a 63 per cent increase in the number of its exhibitors (220) and occupied nearly 16,000m² exhibition space.

 **Wire, Tube & Cable Expo 2009** (WTC'09) is scheduled to take place at the Chennai Trade Centre, Chennai (India) from the 14-17 May 2009. Targeted at the tube and cable sectors, WTC'09 will be held in conjunction with IndiaMart International Machine Tools Expo (IMEX'09).

 **Steel-Tech** (www.thermalexpo.com/steeltch-about.htm) will take place from 18-20 May 2009 at the Expo Centre Sharjah in Sharjah, United Arab Emirates. Steel-Tech will be held as part of Thermal Industry Middle East and will be a key component of the show together with an industry conference.

 **Rusmet Group** held its 4th international conference, titled 'Galvanized & Coated Steel 2009' (http://zn2007.rusmet.ru/index_eng.php), from 29-30 January 2009 in Miass, Chelyabinsky region, Russia. Discussion topics included new capacities in Russia and Ukraine and cooperation with Europe.

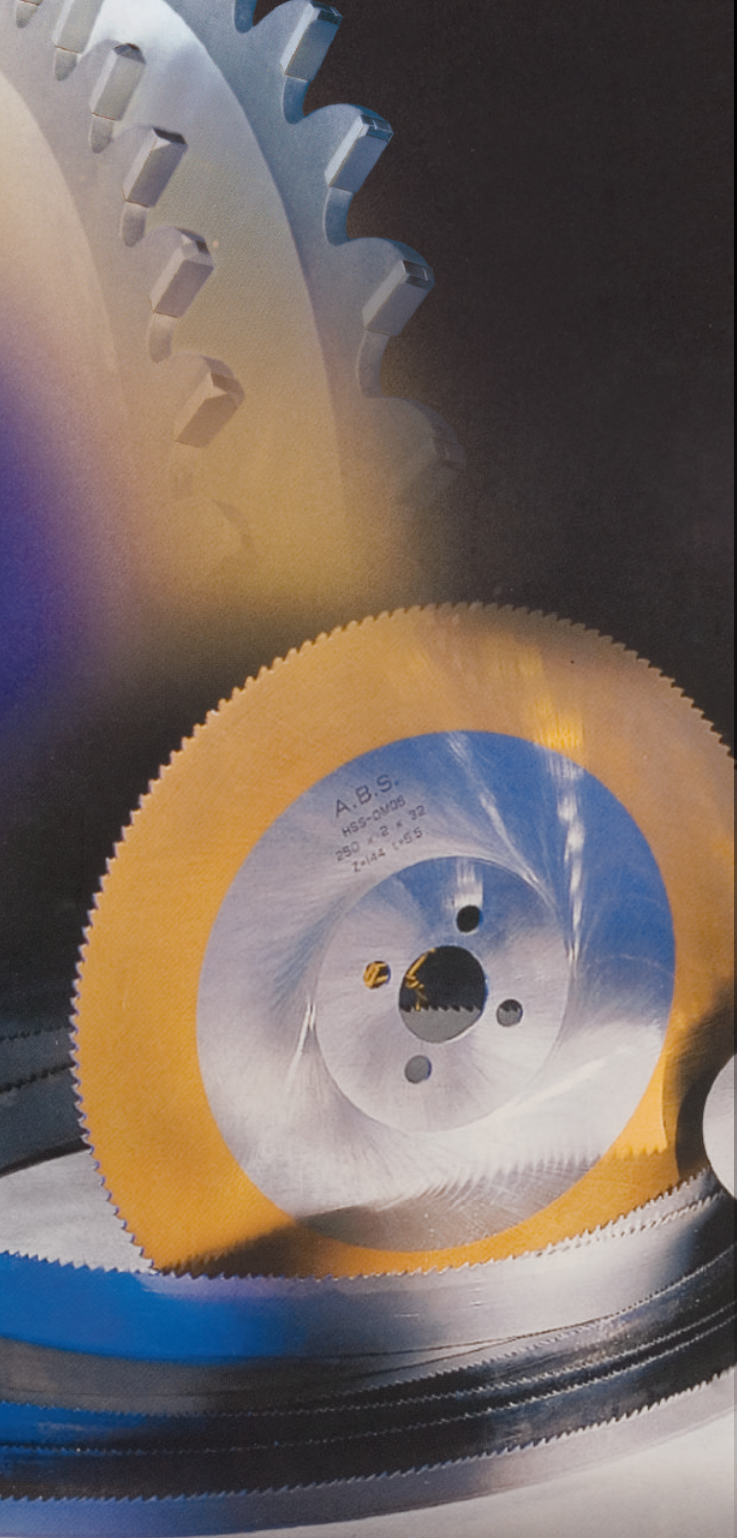


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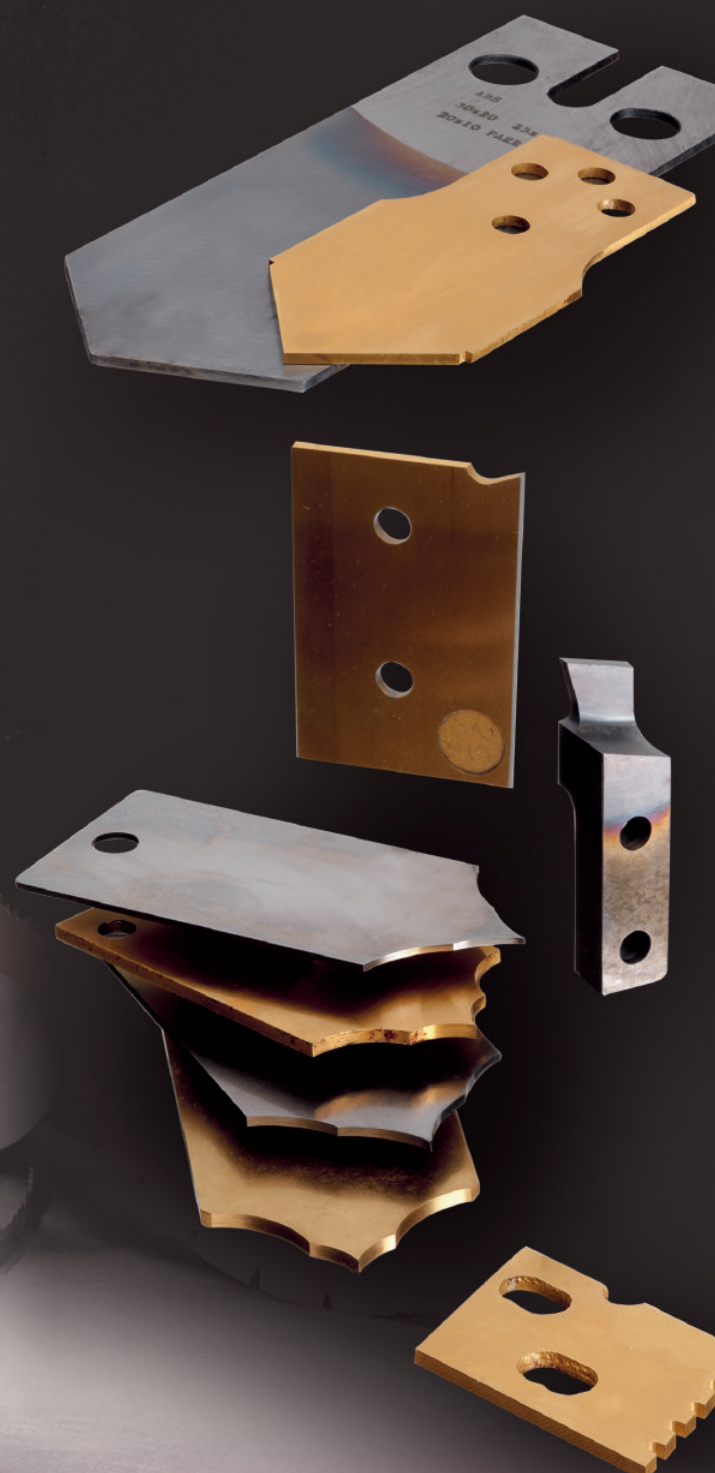
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Business News in Brief... business news in brief...



Randolph Tool (www.randolphtool.com), USA, has announced the purchase of the National Knife Co and Service Grinding Co. Randolph Tool has specialized in the manufacturing and sharpening of industrial knives and tooling for industries worldwide as well as precision machining since 1968.



KTM Tech Co (www.karam90.com), Korea, has developed and released a titanium tube and pipe mill with its own brandname. This mill has been in R&D for a number of years, based on the company's advanced technology. The KTM brand is popular on the domestic market and growing in recognition on the international stage.



Combilift Ltd (www.combilift.com), a leading manufacturer in the long-load handling sector, has appointed Mr Anthony Rooney as product manager responsible for Scotland

and Northern Ireland. Mr Rooney will add support to current Combilift dealerships in these areas. Prior to his appointment, Mr Rooney had already been with Combilift for just under eight years.



Rafter Equipment Corp (www.rafterequipment.com), USA, has added Mr Mark Prasek as vice-president of sales & marketing. Mr Prasek has spent the last sixteen years in the tube and pipe industry working for both Yoder Manufacturing and EFD Induction. Rafter Equipment manufactures tube and pipe mills, rollforming machines, cutoff machines, and other tube mill machinery.



Abbey International (www.abbeyintl.com), a division of Bronx International, has appointed Mr Eric Martin as its new sales manager. Mr Martin will be responsible for growing the sales of Abbey International tube and pipe mill products. The company

has recently shipped a complete 3K2H-3.5 tube mill to a large tube manufacturer in China, who will use it to produce a range of tube ODs and wall thicknesses on one tube mill.



Suraj Stainless Ltd (www.surajgroup.com) has received the Federation of Indian Export Organization's 'Niryat Shree' certificate of excellence (Non-SSI) award at Vigyan Bhavan in New Delhi. The company is a leading manufacturer of welded and seamless tube, pipe and U-tube. About 70 to 80 per cent of the company's production is exported to European countries.



SMS Meer GmbH (www.sms-meer.com), Germany, has appointed Mr Michael Cottin as new vice president for ERW-welded tube plants. Mr Cottin is the successor of Mr Wilhelm Bungert who recently retired. Mr Cottin joined the SMS group in 1985 as a design engineer, and 3 years later switched to sales where he spent 17 years in the hot and cold rolling divisions. From 2005-2007 he was the global key account manager for ArcelorMittal.



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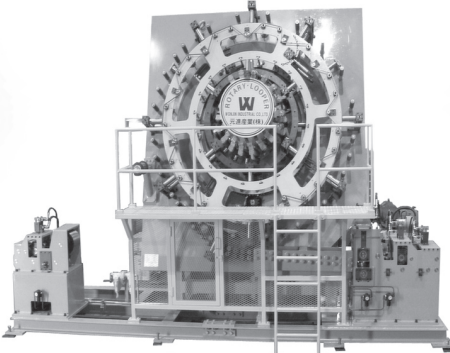
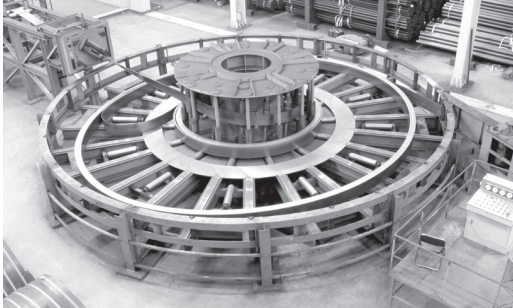
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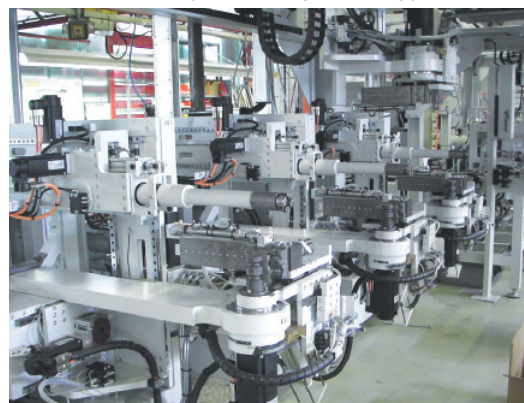
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End-forming and bending technologies in a single unit

Transfluid, Germany, has created an efficient and innovative tube processing solution by arranging existing end-forming and bending technologies into a single unit. A benefit of this new machine is the direct loading process automatically initiated by a container, resulting in a fully automated 3-hour production process that requires no manpower at all.

A specific demand during the conceptual stage of this unit was to speed up the final production process. The results are convincing: both sides can be formed with 7 bends, and a tube can now be processed within 6 seconds.

 German bending machine manufacturer transfluid's next innovation – the supercell – during the bending process



The machine is used for tubes with varying diameter ranges from 6-22mm and lengths ranging from 130-800mm. The tubes pass a one-sided transfer end-forming process which enables complex forming geometries with up to 6 axial forming steps and 1 rotary forming step. The forming of the opposite side takes place in a separate transfer process with 4 axial forming stages and one rotary forming stage.

After both sides are formed, the tube passes through an optical measuring process, which allows an integrated control of the final forming geometries. An additional handling system forwards the formed tube to a bending machine, which utilises three fully electrical clockwise working bending heads. The bending heads are equipped with a front adapter to support the end-forming geometry in the bending process and to facilitate the first bend close behind the end-forming.


A counter clockwise bending unit is located above the three clockwise bending heads. The unit is applied

to a guiding system, enabling the three clockwise bending heads to produce one or more counter clockwise bends. Further bends can be produced with the clockwise processing machines.

The machine can be equipped with an optical control system, which verifies the complete bending geometry after the final bending process. Several functions and positions, as well as the bending geometry itself, can be programmed and adjusted via an integrated touch panel.

Transfluid Maschinenbau GmbH – Germany
Fax: +49 2972 97 15 11
Email: info@transfluid.de
Website: www.transfluid.de



 The transfluid supercell: six axial forming steps enable a more complex end-forming process

IMS delivers new multichannel wall thickness measuring system

IMS Messsysteme GmbH, Germany, has delivered a multichannel tube wall thickness measuring system to Vallourec & Sumitomo Tubos do Brasil Ltda (VSB), following an order last year. The measuring system will be used to measure tube shells at the exit of the PQF mill (SMS Meer). The system will be installed behind the PQF extractor mill.

Apart from the well-established 13-channel measuring geometry for PQF mills, which is used for continuous measurement of polygonal wall distribution, the measuring system will be equipped for the first time for VSB with a high-resolution diameter gauge. A total of 18 laser triangulation sensors will be fitted. This will enable highly accurate detection of out-of-round flaws and profiling of the tube outside diameter.


The laser-based measuring technology integrated here for the first time in an IMS

tube wall thickness measuring system has already been used successfully for several years at Ovako Steel AB in Hofors, Sweden, as a standalone measuring system. The sensor and analysis systems are now being integrated in the IMS measuring system in close cooperation with the company LIMAB.

IMS can therefore simultaneously measure the wall thickness and eccentricity, outside diameter and profile, temperature and length of tubes in a single compact gauge. This avoids the need to install multiple individual systems, which means not only savings in the cost of the overall investment, but also simpler maintenance and upkeep.

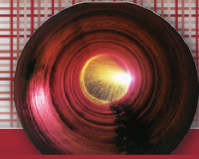
IMS can look back on more than 20 years of close cooperation with Vallourec & Mannesmann Tubes, a member of the



 A multichannel tube wall thickness measuring system from IMS Messsysteme

Vallourec Group, at various locations around the world and Sumitomo in Japan. This new contract included, IMS has already supplied this mill operator with more than 15 individual measuring systems.

IMS Messsysteme GmbH – Germany
Fax: +49 2056 975 140
Email: info@ims-gmbh.de
Website: www.ims-gmbh.de



Advances in ultrasonic measurement for Nitinol tubing

LaserLinc, a producer of precision measurement systems, has developed new testing solutions for its ultrasonic line.

The company has applied ultrasonic technology to measure medical-grade Nitinol tubing, and claims that its application is the only practical, non-destructive and in-process method available.

Using the UltraGauge+ ultrasonic system and a laser scanning micrometer, LaserLinc can provide the inside diameter, wall thickness, and outside diameter of the material.

Nitinol (nickel titanium/NiTi) is a shape memory alloy used in, among other things, medical devices. Because of its unique crystalline structure, Nitinol has been difficult to measure accurately with ultrasonics, and because of its high cost, accurate measurement is a priority for manufacturers.

LaserLinc has also created UltraLock, a wave-analysis procedure designed to simplify the time-consuming and difficult process of setting up ultrasonic measurement systems. With the UltraLock setup procedure, the user can reduce complexity of ultrasonic measurement to one step, without reducing control over the system.

The user can also quickly and automatically set software parameters to ensure accurate and reliable measurement, even if the product size changes during a production run. In addition, the system can be configured to measure all layers of multi-layer products simultaneously.

UltraLock, a feature of LaserLinc's Total Vu software, is designed specifically to work with the company's UltraGauge+ ultrasonic measurement system.

Total Vu gives users access to powerful computational, data processing, and data collection tools. The software makes it possible to use in-process tolerance checking, trending, SPC, feedback control, data logging, recipes and other configurable features.

LaserLinc Inc – USA
Fax: +1 937 318 2445
Email: info@laserlinc.com
Website: www.laserlinc.com

Haventrak™ flying shear for cutting expertise

Haven Manufacturing, USA, has introduced an exciting addition to its tube cutting product line – the Haventrak™ flying shear. Haventrak utilizes the speed and precision of the company's 'dual-blade shear' cut-off head.

The system takes advantage of the 'Utrak' length control system to deliver accurate, high quality, dimple free cuts on-the-fly. This innovative approach will provide improved production rates with increased accuracy at up to 250 FPM.

Haven Manufacturing has gained worldwide acceptance by producing high quality cuts on a variety of tubular shapes and materials utilizing the dual-blade shearing method. Universal Controls Group, USA, developed the Utrak length control system blending hi-tech electronics and simple mechanics to provide an accurate yet rugged solution to length control needs.

Haventrak™ integrates two of the most recognized names and know-how in the tube cutting industry to provide improved quality and accuracy.



 The Haventrak™ flying shear from Haven Manufacturing

Haven Manufacturing – USA
Fax: +1 912 264 9001
Email: derickson@havencut.com
Website: www.havencut.com

Universal Controls Group – USA
Fax: +1 419 874 2825
Email: sales@universalcontrolsgroup.com
Website: www.universalcontrolsgroup.com


Simultaneous conditioning of tube ends – inside and out

After making a weld preparation, most tube and pipe has to be polished in order to avoid pollution of the weld. Th Wortelboer BV, the Netherlands, has developed a revolutionary solution to polish the inside and outside at the same time in one cycle.

The compact TPP 5090 is a safe machine for easy cleaning of welding preparations. It is possible to quickly and safely prepare tube, pipe and plate edges for welding.

The two polishing wheels of the TPP 5090 can be adjusted according to the thickness of the material. The inevitable wear of the wheels, which decreases the wheel diameter, can be corrected. The new innovative TPP 5090 conditioning machine is a registered design.



 The TPP 5090 is used for simultaneously polishing the inside and outside of tube and pipe

Th Wortelboer BV – The Netherlands
Fax: +31 24 358 70 79 • **Email:** info@wortelboer.ws • **Website:** www.wortelboer.ws

Chinese manufacturer of ERW/API tube and pipe mills

Shijiazhuang Zhongtai Company is one of the top manufacturers of ERW/API tube and pipe tube mills in China. Over the last decade, the company has focused on development and innovation in tube making technology.

In China, the company launched the first manufacturing unit for special railway steel, the first production equipment for wide steel sheet, and the first multi-functional production line for welded pipe. In addition, the company has introduced China's first ZTF forming production line, the first production line for direct-forming for square/rectangle tube, and China's first API steel pipe production line.

Last year, Zhongtai signed a large contract with Hebei Wenfeng Iron & Steel Group, which involves the provision of a complete

production line for ERW steel pipe. This line can produce pipe of up to 355mm OD and is used in oil and gas transport lines.

After installation, this line will provide great support to oil and gas transport across North China, where there is a newly discovered oil field near Bohai Sea.

Zhongtai has exported tube mills to Middle East, Southeast Asia, Latin America, and Africa.

High-quality equipment, advanced technology, and perfect after-sales service have



Shijiazhuang Zhongtai is the manufacturer of ERW/API tube and pipe mills

secured the company a dedicated customer base.

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Website: www.ztzc.com

MAC introduces 220mm rotary ultrasonic tester

Magnetic Analysis Corporation, USA, has expanded its line of Echomac® rotary ultrasonic test systems to handle 220mm diameter tube and pipe, often used for OCTG applications. Previous models handled up to 180mm diameter. Rotary ultrasonic systems have the advantage of allowing high throughput speeds combined with full body coverage.

The 220mm Echomac seal-less rotary spins the UT transducers and water couplant at speeds up to 850rpm about the tube as it is fed through the test. The seal-less

design ensures minimum maintenance, and the shear wave transducer holders are designed to allow for easy and accurate reconfiguration for different diameter tube through a simple rotational adjustment of the transducer offset.

The pulser electronics, located on the rotary, allow for very low noise signal processing as the transducer pulse and initial detection is accomplished close to the transducer. Following this, it goes through the rotary transformers to the Echomac FD-4 instrumentation.

Magnetic Analysis Corp's Echomac® ultrasonic rotary inspection system designed for 220mm diameter tube. Pinch stands are used for driving and accurately positioning the tube are on either side of the UT rotary



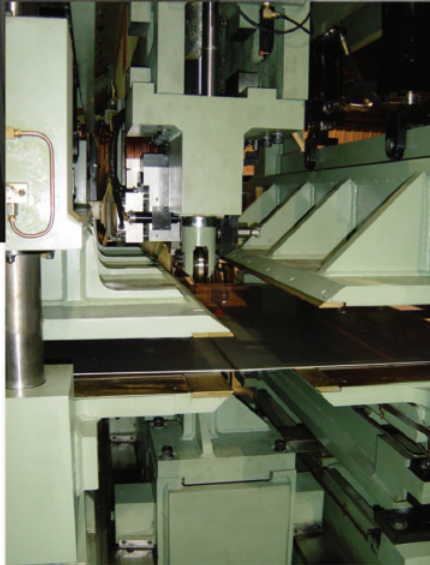
The 220mm system uses Echomac FD-4 instrumentation with 14 transducer channels to detect longitudinal, transverse, and known angle oblique defects, wall thickness, ID/OD measurement and variations such as ovality.

Using FD-4's EchoHunter® software, each channel can be easily configured for any combination of thickness, dimensional measurement, and flaw detection.

Features include simultaneous A-scan and strip chart display of all channels showing peak values of signals within each gate, and full network support for remote viewing and control. The flicker free A-scan captures non-repetitive events or flaws of short duration, even in very high speed UT scanning systems, typical of rotating transducer heads.

A recent computer controlled Echomac 220mm UT system shipped to a tube mill in India includes controls for sorting, marking, and adjusting the automatic test bench and all test and mechanical components to allow for variations in speed. The system for India also includes Rotoflux® transverse and longitudinal flux leakage tests that comply with API standards.

Magnetic Analysis Corporation – USA
Fax: +1 914 699 9837
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Website: www.mac-ndt.com



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World's largest inductive heating plant for pipe bends

SMS Elotherm, Germany, has won an order from Tectubi Raccordi SpA (Allied Group) that further strengthens the company's business relations with this renowned Italian producer of pipe bends. Tectubi Raccordi will receive an inductive heating plant for the production of pipe bends (\varnothing 56") that operates to the 'Hamburg method' and, with an inductor power input of 2,400kW and 1,600kW respectively, represents the world's most powerful plant of its type.

Commissioning was scheduled to start in quarter one of 2009. The company's scope comprises equipment for preheating the still straight pipe section plus two medium-frequency infeed units for heating the bent pipe section. In addition, the order covers

three sets of inductors for the production of pipe bends with diameters from 36" to 56".

The heating plant will be designed for bends of standard steel and austenitic grades, and will be able to process pipes with wall thicknesses of up to 60mm. The power input of the first inductor amounts to 2,400kW, while the bent inductor will be rated for a maximum power input of 1,600kW.

The transistorized converters will be equipped with an SMS Elotherm digital control and are connected with the PLC via Profibus facilities. Two temperature cameras installed at the inductor outlets provide the data for power setting as a function of the pipe feed motion.

 Fabrication of a 24" pipe bend with inductive heating



The 'Hamburg method' for pipe bends production operates according to pipe sections being pushed over a mandrel which has the curvature required for the finished pipe bend. The feed-forward movement is accomplished by means of a hydraulic press.

The pipe is heated in two zones. Preheating is accomplished in the straight part of the inductor without any material deformation or forming, while the bent inductor serves to heat the pipe to the

desired final temperature. It is here that forming takes place.

Heated to final temperature, the pipe is pushed over the mandrel by the press, and thus takes the shape of the mandrel. This method requires the mandrel to be heated before production starts which is undertaken by means of the bent inductor and the associated medium-frequency infeed unit.

The 'Hamburg method' is suited to an array of materials and stands out for the fact that after forming the wall thicknesses are nearly identical over the complete pipe. In addition, the cross-section of the pipe bend maintains the circular contour of the starting pipe.

SMS Elotherm GmbH – Germany
Fax: +49 2191 891 726
Email: m.oelmann@sms-elotherm.de
Website: www.sms-elotherm.com

Skiving and roller burnishing machine

Sierra Machinery Inc, USA, has launched its new-generation Sierra USA[®] machines and patented tooling. The Sierra USA goes to the highest level in finishing steel tubes for the hydraulic cylinder industry and other applications where fine-finishing of the internal diameter of a tube is required.

Skiving is the preference over honing by manufacturers worldwide such as Caterpillar, Komatsu, Wipro India and JC Bamford UK. The company is renowned as being the manufacturer of the world's fastest skiving and roller burnishing machines and patented tooling.

The Sierra USA offers greater speed, increased cost efficiency, and high quality machining solutions to serve the cylinder manufacturing industry.

A skived and burnished surface provides longer seal life and has a 50 per cent higher TP rating than that of a honed surface. On an example of 88.9mm bore tube (762mm long), the Sierra USA can achieve finishing in 30 seconds including loading and unloading. This equates to 122 tubes per hour, achieving H8 and Ra 0.1-Ra 0.4. Skiving and burnishing is 80 to 100 times faster than honing.

Sierra Machinery Inc – USA
Fax: +1 775 358 6739
Email: sierram@sierramachinery.com
Website: Sierramachinery.com

Six axis CNC profile cutting machine

Shandong Fin CNC Machine Co Ltd, China, develops, manufactures and sells CNC machines such as drilling, milling, punching, sawing, cutting machines and other optical, mechanical and electronic integration equipment. The company tracks new technologies and aims to make continuous innovation in technology for manufacturing high-grade equipment, with a focus on the electric power, steel structure and automobile industries.

The company's PB660 CNC profile cutting machine is designed for pipes within the diameter range 60 to 600mm, of thickness from 2.3mm to 25mm, and in lengths from 600mm to 12,000mm. Maximum pipe weight is 5,000kg, the minimum intersection angle is 20°, and the bevelling angle is from 30° to 150°.

The machine is equipped with a colour touch-screen and an air-plasma cutting machine (OTC D-12000), and operates in six axes (workpiece rotating, longitudinal movement, torch swing, torch adjustment, up-down movement and front-rear movement), with a maximum workpiece rotating speed of 8r/min. The maximum distance of longitudinal movement is 12,000mm, and the maximum longitudinal speed is 10,000mm/min.

Shandong Fin CNC Machine Co Ltd – China
Fax: +86 531 88875516 • **Email:** fincm-int@fincm.com • **Website:** www.fincm.com



Innovative diameter gauges for hose and tube extrusion lines

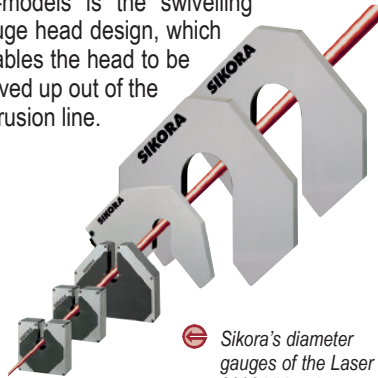
Sikora, Germany, is the manufacturer of the Laser 2000 XY-series of gauge heads for high quality diameter measurement. These XY-gauge heads provide the highest precision, reliability and continuous functionality for a product range of 0.05 to 300mm.

Due to their functional design, the systems can be easily integrated into every production line. Sikora measuring systems are known for their unique non-contact and non-destructive measuring principle. The technology is based on CCD-line sensors and laser light sources in combination with powerful signal processors.

The outer diameter is calculated by diffraction analysis directly from the shadow image. Extremely short exposure times ensure a high single value precision at all line speeds – even when the product is vibrating.

In terms of design, the gauge heads of larger size are open at the bottom, which prevents water and dirt falling into the gauge head, while the smaller devices have

a unique and proven multi-slot protection. A special feature of the larger Laser 2000 XY-models is the swivelling gauge head design, which enables the head to be moved up out of the extrusion line.



Sikora's diameter gauges of the Laser 2000 XY series

The Laser 2000 XY-series guarantees an almost unlimited operating time at the highest productivity. The mean time between failures (MTBF) – the statistical average time after which a device of this series shows a repairable defect – is 15 years.

For specific applications the Laser 2000 T-models for 3-axis measurement and the Laser 2000 Profil for the measurement

of profiles are available. The Laser 2000 T-series offers gauge heads for a precise diameter measurement, inclusive of minimum, maximum and values, ovality and direction.

The ovality is accurately calculated independently from the orientation of the minimum and maximum values to the 3 measuring axes. For the online-measurement of rubber and tube profiles, the Laser 2000 Profil defines distinctive positions of a profile in the measuring field, from the functional equations of tangential laser diodes.

This device is suitable for the exact measurement of round or oval profiles – even if the profiles are arranged in an inclined position. The Laser 2000 XY-gauges offer various interfaces such as Profibus-DP, CANopen, DeviceNet, Ethernet/IP (for the direct connection to a PC), or the display and control devices Remote 2000 – respectively Ecocontrol 600, 1000 and 2000.

Sikora AG – Germany
Fax: +49 421 48900 90
Email: sales@sikora.net
Website: www.sikora.net



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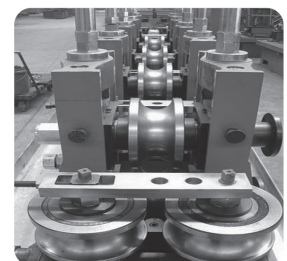


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Bronx/Taylor-Wilson awarded contract for pipe finishing equipment

Bronx/Taylor-Wilson, USA, a leading manufacturer of straightening and hydrostatic testing equipment, has recently won a number of contracts. The company's state-of-the-art equipment can be used to process cold and hot pipes of over 600°C, thin or thick walled tubes of over 50mm, and low or high yield strength alloys of over 1000MPa.

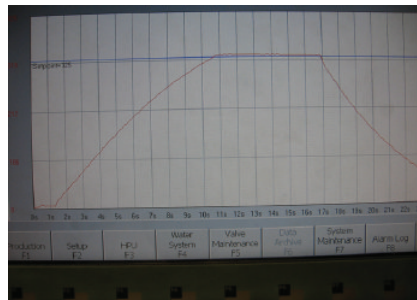
The latest contract won by Bronx is from a new joint venture between a South American company and a Japanese company. As part of the decision process, stringent testing required pressures that have never been accomplished on such high yield equipment for API standard 5CT/5L product diameter ranging from 177.8mm to 406.4mm.


The hydrotesters will be designed to withstand an end load of 8043KN for 406.4mm OD casing. This end load is the highest of any product that will be tested at such diameters. The hydrostatic pipe tester will include the main machine and auxiliaries and will incorporate the Bronx/Taylor-Wilson proven collapsing sealing between the tube and testing head which has a lifetime of 10,000 testing times per piece.

The tester is enclosed in a safety protective hood that includes lifting devices for tool changing and equipment with the possibility to place the tools outside of the protective hood. The controls are equipped with a pressure recorder to store the entire procedure of the testing from water filling to

pressure build up, to pressure-to-pressure releasing and the time of pressure testing.

The data can be stored digitally and on paper, and individually sorted according to the time, lot, shift, product standard, outer diameter, wall thickness, and steel grade (steel type). The fully automatic machine can also be manually operated by push button.



 The hydro pipe hold testing screen, part of Bronx's technology

The hydrostatic pipe tester will be equipped with an automatic self-checking function, fully automatic control, communication with upstream and downstream equipment and interfaces for checking signals. The machine has functions to transfer the necessary information of production and process to an upper level computer.

Bronx/Taylor-Wilson will also supply two 6.CR.11 pipe-straightening machines. These machines will process a diameter range of 177.8mm to 406.4mm diameter at yield strengths above 165,000psi. This

particular design of straightening machine is an example of the design that BTW offers to the market.

The Bronx/Taylor-Wilson 6.CR. 11 six-roll design is used to straighten the top quality API and GOST quality pipes in the most arduous of mill conditions. The machines offer features including a hydraulic lift for ease of tube entry and electronic pressure sensing load cells for an accurate indication of straightening loads. In addition, the machines are supplied with the patented Compass computer aided setting system.

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Bronx International Inc – UK

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Email: europesales@btwcorp.com

Website: www.btwcorp.com

Brushes for pipeline weld cleaning

Osborn International, Germany, is the manufacturer of brushes and abrasives for use in industrial applications. Steel wire brushes are an ideal solution for the cleaning of welded seams.

Wire brushes are a cost effective and practical method for removing welding cinder and beads that prevent the next seam from being applied. The use of cellulose and alkaline electrodes are insignificant, as a brush will carefully remove all types of cinder.

A rotating wire brush will provide a clean welded seam without having to remove up to 30 per cent of the welding material, as is inevitable with a grinding disc. Any defects in the weld seam also become immediately visible, enabling any rework to be carried out promptly.

The use of steel wire brushes reduces the number of seams by a claimed 30-50 per cent, and additional time needed for resoldering work can be avoided. Osborn pipeline brushes can be used for weld cleaning, internal or external cleaning, bevel end cleaning, removal of insulation coats and rehabilitation work. They enable long life, optimal brushing results and safe work.

Osborn International GmbH – Germany

Fax: +49 64 5158 8206

Website: www.pipelinebrush.com

Leading pipe supplier to the Central Asia-China pipeline project

PJSC Khartsyzsk Tube Works, founded in 1898, is involved in the manufacture of pipes for oil, gas and water pipelines. The company's production range includes pipes from 406mm to 1,422mm in diameter with wall thickness from 7mm to 32mm. There is a capability for external anticorrosion polyethylene and internal flow and anticorrosion epoxy coating.

Khartsyzsk operates a management system certified according to ISO 9001, OHSAS 18001 and ISO 14001. The main preoccupation of the company's plant is the project for construction of the Central Asia-China gas pipeline. This project requires pipes with 1,067mm in diameter and wall thickness of 15.9mm and 19.1mm.

In order to carry out this order, the company use high-quality process materials and advanced technologies both for pipe manufacture and the application of external and internal coating. A monitoring system for the technological parameters is installed in the shops to ensure optimum management of all production areas.

Khartsyzsk Tube Works PJSC – Ukraine

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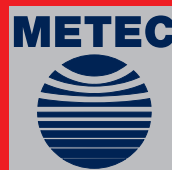
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WALL THICKNESS AREA : 2MM TO 100MM

STANDARD:

ASME : ANSI B16.9, ANSI B16.28, MSS-SP-75

DIN : DIN2605, DIN2615, DIN2616, DIN2617, DIN28011

SGP : JISB2313

EN : EN10253-1, EN10253-2

MATERIALS:

ASME : A234 WPB, A234 WP1, A234 WP5,
A234 WP9, A234 WP11, A234 WP12, A234 WP22,
WP91, WP92, A420, WPHY42, WPHY52, WPHY60,
WPHY65, WPHY70, WP304, WP304L, WP304H,
WP316, WP316L, WP321, WP347, WP347H
DIH : ST37.0, ST35.8, ST45.8, S235JR, P235GH,
P265GH, 10CRMO910, 15CRMO, 12CR1MOV
JIS : JIS G3454 STPG370 STPG410



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E-mail: sales@ruidatong.com Web: www.ruidatong.com

Automated seamless pipe mill order in Brazil

ABB, UK, has won a contract to supply automation systems, equipment and services for a new seamless steel tube and pipe production plant for Vallourec & Sumitomo Tubos do Brasil (VSB). The company is a specialist in power and automation technologies that enable utility and industry customers to improve performance while lowering environmental impact,

The new plant will have an annual capacity of 600,000 tons per year of seamless steel pipes. It will be primarily dedicated to the production of seamless OCTG (oil country tubular goods) products.

ABB will provide engineering, project management, and other related services for the project. The scope of supply includes drives, motors, electrical equipment and automation based on system 800xA, with industry-specific applications for the seamless pipe laminator rolling mill.

ABB's automation solutions maximise productivity and equipment reliability in rolling mills, and also help optimise energy use, enabling plants to run efficiently and profitably from the start.

The new plant will be built at Jeceaba, in the state of Minas Gerais in south eastern Brazil, and is scheduled to start production in 2010. VSB is a joint venture company owned by Vallourec Group and Sumitomo Metals.

ABB Limited – UK

Fax: +44 1480 218 361

Email: enquiries@gb.abb.com • **Website:** www.abb.com

Inclined-bed circular saw technology

For the cutting of continuous casting billets or ingots, system-dependent vertical and horizontal saws are disadvantageous. Linsinger, a specialist in sawing and milling, has therefore developed an inclined-bed-saw to overcome problems of machine stability, inefficient clamped material and low tool life.

The company combined the benefits of vertical and horizontal technology in the development of its KSS inclined-bed circular saw. Linsinger states that inclined-bed technology has generated a lot of enthusiasm worldwide.

Linsinger claims that its professionals can ensure maximum line availability, based on product development and manufacturing experience of more than 500 carbide circular saws.

According to Mr Johann Baumgartner, the Linsinger's sales manager, the saw blade for the saw is like the wheel for the Formula 1 car: minimum deviations in interaction or bad tuning can endanger line efficiency. Linsinger offers a complete package that simplifies service and repair, reduces customer stoppages and avoids unplanned breakdowns.

Linsinger – Austria

Fax: +43 7613 8840 38

Email: maschinenbau@linsinger.com

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Laser tube cutting system takes processing to a new level

BLM Group UK Ltd has launched the new BLM Adige LT 722D Lasertube, described by the company as 'the future of laser tube processing'. The LT 722D can process round, square, rectangular and flat-sided oval section tube up to 152mm in diameter, and lengths up to 6.5m or 8.5m.

The machine uses offline programming software specifically developed for the machining of tubes. This software creates

new programs quickly and easily, while the Siemens Sinumerik 840D CNC allows the operator to manage all the main functions, including program downloads.

The LT 722D has fully automated bar handling throughout the entire sequence of load, measure, feed, cut and unload. Fast set-up and changeover times means short batches can be managed as cost-effectively as longer production runs.

The proprietary Artube CAD/CAM software is dedicated to the tube fabrication process, ensuring that the transition from design to finished component typically takes less than five minutes. This includes components with open profiles and special tube shapes.

Changeovers, which are performed automatically, can be completed in less than two minutes, and once the operator has selected the cutting program the system manages the set-up operations according to the size and type of material. To reduce reliance on individual know-how, a database of 'ready to use' cutting parameters is provided as standard, taking account of different tube sizes, shapes, thickness and material to minimise waste and set-up times.

Raw tube is measured automatically prior to processing and supported during the entire cutting sequence by numerically controlled universal supports located upstream and downstream of the 2,500W Rofin CO₂ laser cutting head. This ensures optimum part accuracy and consistency, while the diffusion-cooled laser combines high cut quality with low running costs.

 The 8th generation BLM Adige LT 722D Lasertube tube processing system



The machine is claimed to be up to 80 per cent more productive than its predecessors – and the more complex the part the greater the productivity increase. It incorporates a number of hardware improvements that contribute to faster processing of tube. However, the greatest change is to the software, which has been configured to make optimum use of the new machine's processing capabilities.



JANG WUEL STEEL MACHINERY CO., LTD.

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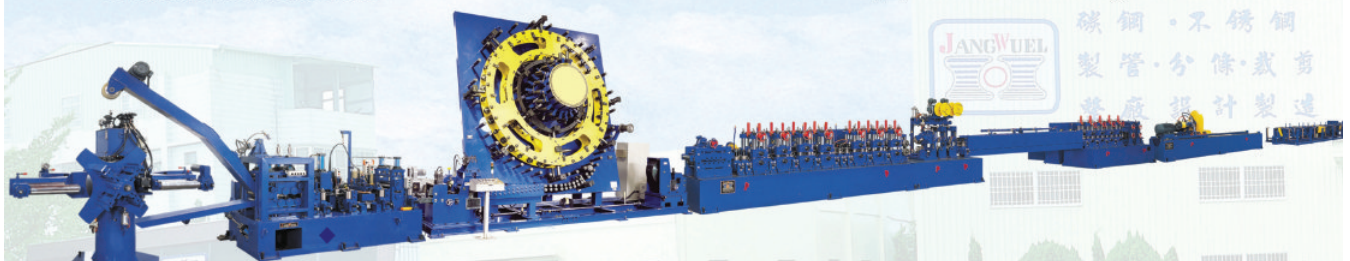
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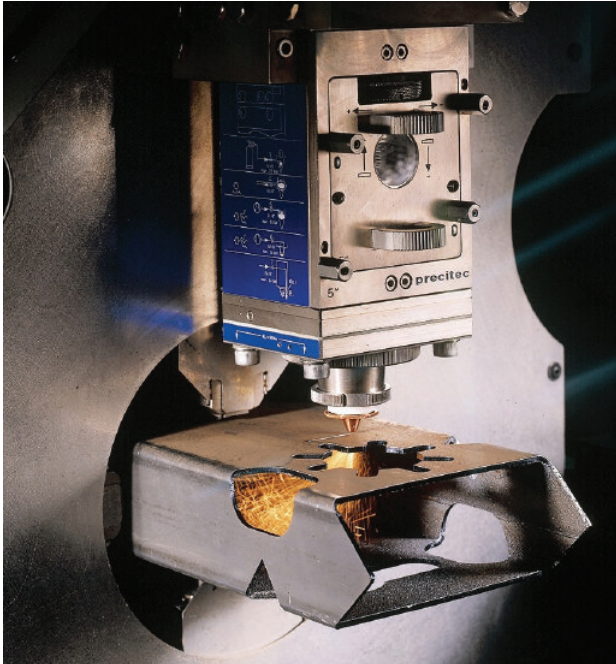
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- ◆ Square & Rec. Tube Polishing Machine
- ◆ Round Tube Straightening Machine
- ◆ End Facing & Cutting Machine





ⓘ The LT 722D tube laser uses a 2,500W laser source to process round, square, rectangular and flat-sided oval section tube up to 152mm in diameter

Optional features contributing to greater productivity include an anti-spatter device for use with stainless steel tube. This prevents damage to the inner surface of the tube, a critical factor in applications where hygiene is an absolute priority.

BLM Group UK Ltd – UK
Fax: +44 1525 402 312
Email: sales@blmgroup.uk.com
Website: www.blmgroup.uk.com

OCTG, tube and fittings from Kuwait

M/S Global International General Trading & Cont Co WLL, Kuwait, is a leading general trading and contracting company for oilfield products and safety items.

The company's product range includes tube, pipe (SS & CS), fittings, valves, gaskets, instrumentation equipment, and testing/measuring equipment. In addition, Global International provides power tools, hand tools, and electrical conduit pipe and fittings.

The company is the local agent of certain well reputed and leading manufacturers including M/S AB Sandvik (Sweden) for stainless steel tube and pipe, and M/S BMT (Superlok), Korea, for instrumentation fittings, and M/S Viraj Forgings (India) for stainless steel flanges.

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Acid pickling tank offers extreme corrosion resistance

Arvind Anticor Limited, India, is a manufacturer and exporter of acid pickling tanks made from extremely corrosion resistant polypropylene thermoplastic. The company's acid pickling tanks are custom designed according to size and weight of load such as tube, pipe, wire coils, bars, rods and structural steel.

Anticor PP tanks are used for pickling, degreasing, electro-plating, rinsing, fluxing, anodising, passivation, pre- and post-treatment and metal surface treatment. The tank is constructed from polypropylene thermoplastic, a material that is highly corrosion resistant. In addition, the tank is housed in a steel structure frame for mechanical reinforcement, covered with fibreglass.

The tanks are designed and engineered on the 'Rita' tank building software module. All areas of design, costing and calculating PP tanks are geared towards maximising the benefits of advanced material over conventional alternatives such as brick lining and fibreglass lining. Benefits include cost saving, impact resistance, corrosion



A PP tank with steel support, fume exhaust slot and integral ducting

resistance, mobility, minimal weight, leak proofing, fume free, increased longevity and zero maintenance.

Anticor tanks are designed, manufactured and tested according to German Welding Association DVS 2205 for safety and longevity.

The tanks are manufactured with certified life of chemical resistance. Anticor's facilities are equipped with butt fusion welding, hot gas extrusion welding technology and hydro-thermo radius forming technology.

In addition to butt fusion technology, Anticor has developed radius instead of a right angle corner at the bottom of tank. This effectively reduces the weld joint at the welded corner radius, thus providing sound mechanical strength. Anticor weld joints are tested as per German Welding Association DVS 2203.

The company's tank fabrication technology offers better performance, higher efficiency, higher productivity, lower rejection, zero failure and an environmentally friendly atmosphere. Welding quality is confirmed by a 3-point bend test, and a specimen seam is subjected to a test of tensile and impact resistance properties. Leakage testing is carried out prior to dispatch by hydro, vacuum and spark test.

Anticor pickling tanks are supplied with accessories such as nozzles, heating/cooling coils, integral suction ducting for fume exhaust, integral slope for drain, lifting arrangement, and top lid cover.

Arvind Anticor Limited – India
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Automatic squeeze pointers for high quality drawn pipes

Politecnica Italia Srl, Italy, is the manufacturer of the Afonat series of hydraulic squeeze pointers that offer a state-of-the-art solution for making the tong-holds of drawn pipes. The machines offer high productivity and advanced technology with silent operation.

 The Afonat series of hydraulic squeeze pointers



The main feature of these machines is sturdiness that, together with the use of very high quality component parts, ensures absolute reliability over the years. Component parts include Siemens motors, PLC and operator panels, Bosch-Rexroth hydraulic components, and Moog pumps.

A highlight of this machine is the 'follow-on' jaw closing system, which mechanically ensures all 4 jaws move at the same time and permits achieving any square end size with just one type of jaw.

The Siemens operator panel, which is connected to the PLC by a loop, sets the control of all functions. It also operates all parameters of the machine, including cycle selection, jaws opening/closing measures and speed ratio, automatic lubrication adjustment, strokes counter, and recipe management.

Politecnica Italia Srl – Italy
Fax: +39 039 6012628
Email: info@politecnicaitalia.it
Website: www.politecnicaitalia.it

Kent Corporation receives orders for two large accumulators

Kent Corporation, USA, has received orders for two new horizontal accumulators in North America. The customer has new mills that will be producing pipe sizes up to 10" (254mm) diameter and 0.630" (16mm) wall thickness.

The company was chosen due to its reputation and vast experience in accumulator systems of all sizes and the ability to run a large range of sizes on one machine. Kent now has over 2,000 accumulators running worldwide in 54 different countries.

Kent supplies horizontal accumulators for strip width from 1" to 72" (25.4mm to 1,829mm) and strip thickness 0.012" to 0.750" (0.3mm x 19mm).

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Aluminium extrusion press for extruded profiles

SMS Meer, part of Germany's SMS group, has won a supply contract for a 75/80 MN aluminium extrusion press from Western Extrusions Corp, USA. Western Extrusions is a producer of extruded profiles for use in the construction sector, transport and industry, and is one of the largest manufacturers of aluminium seats for sports stadia.

The Schloemann front-loading press has an extrusion force of 8,000t and a billet charge weight of up to 630kg, and is the largest machine to date of this kind that SMS Meer has built in North America. It will be used for the production of high-quality extruded aluminium profiles for the transport and automotive industry.

The extrusion press will be built as a shortstroke, front-loading press. Front-loading presses have become established as the standard on the extrusion-press market. The advantages of the design are the compact, sturdy frame and the short cylinder strokes, with associated high productivity.

The machine ensures short idle times and high product quality from the centric loading of the aluminium billet inside the press (resulting in practically no air inclusions). The new extrusion press is scheduled to go into operation in spring 2010.

SMS Meer – Germany
Fax: +49 216 1350 1667
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Website: www.sms-meer.com

Leading Chinese manufacturer of flanges and fittings

JN Piping & Equipment Co Ltd (JNCO), established in 2000, is an exporter and manufacturer of pipeline products, flanges and fittings in China. The company is located in the Jiangsu and Liaoning provinces of China.

With a quality assurance system conforming to ISO, the company supplies a full range of components for pipeline products including

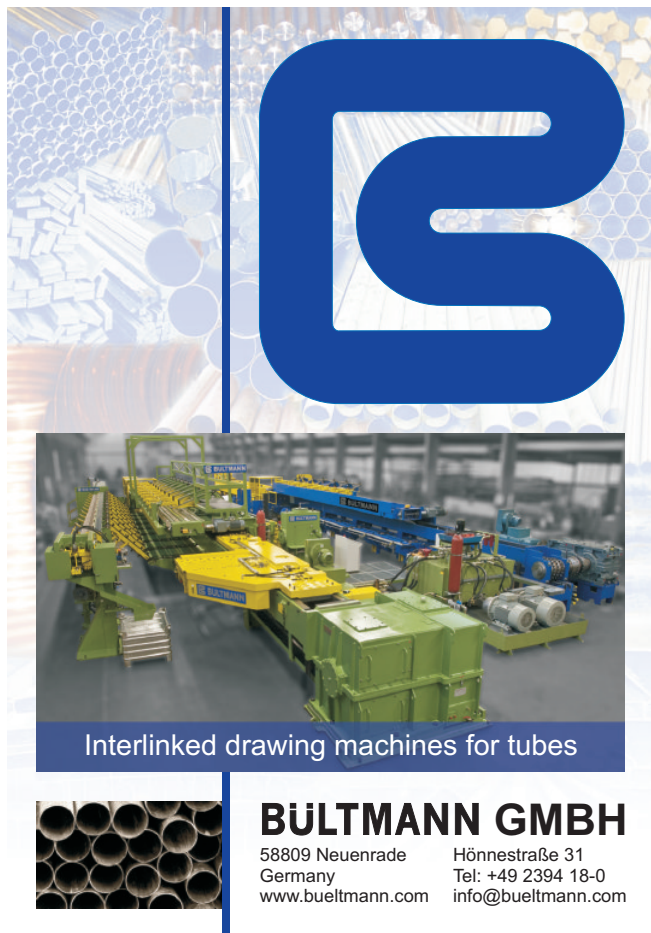
carbon steel and stainless steel fittings, and flanges of all international standards. This range is backed up by technical expertise, excellent quality and good sales services.

The butt weld fittings range includes cold form and hot form, seamless and welded (from welded pipe or plate). The butt weld fittings are available in stainless and carbon steel according to DIN, ANSI, JIS, MSS, and BS in ½" to 60". The fittings come in different types including elbows and bends (45, 90, 180 LR and SR), equal tee and reducing tee, concentric reducer and eccentric reducer, caps, and stub ends.

Forged flanges are also available according to the ANSI, DIN, JIS, BS and ABS standards. They can be supplied in a range from ½" to 60", in stainless steel or carbon steel.

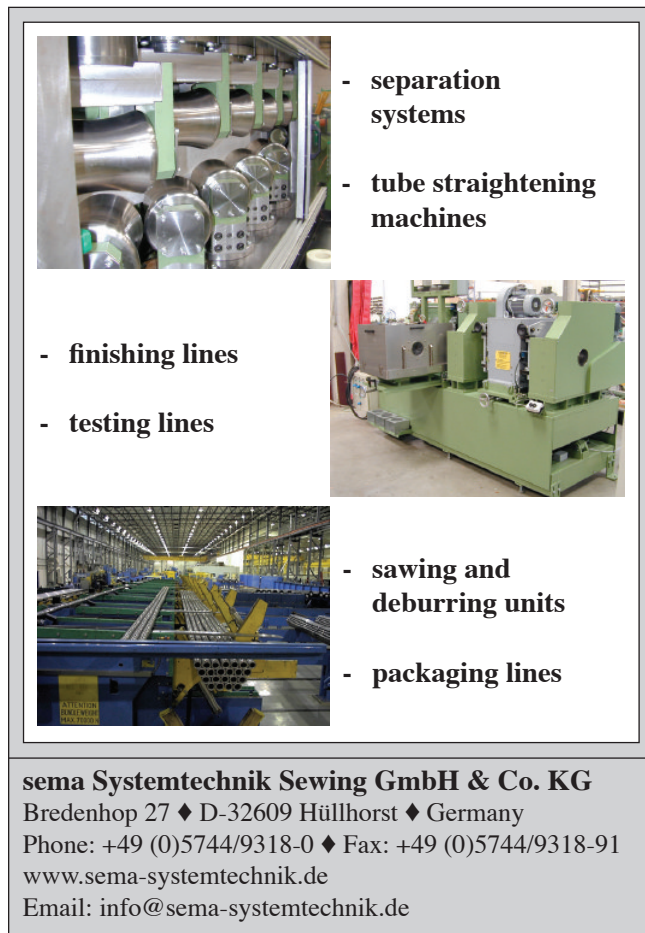
JNCO employs 6 quality inspectors to control the quality, while training is scheduled at least twice a year.

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Launch of 'straightening head' core exchange program

The 900 series of 6-roll rotary tube straightening machines, from Turner/Mackintosh Hemphill, were first introduced in the early 1960's.

There are now many hundreds of 900 series straighteners in regular production and, when maintained in good condition, give very acceptable results to many tube producers.

The 900 series machines are very robust, with modern versions manufactured each year – some with Casam computer control. While Turner offers a 'rebuild back to as

new' service, many users often cannot accept lengthy machine downtime. To address this problem Turner has launched a 'straightening head' core exchange program.

The 'straightening head' comprises the portion of the machine containing the rolls and roll adjustment mechanisms. The supplied factory re-manufactured straightening head is 'as new' and includes all the modern revisions such as digital roll position indicators. Essentially the factory re-manufactured heads are fitted with new rolls, bearings, wearing parts and new roll adjustment devices.



 A model 924 straightening head installed at a customer's plant

 A model 916 straightening head ready for shipment



The straightening head core exchange program has been developed to cut the downtime of a straightener to around a day or two. The re-manufactured straightening head can usually be installed with the existing roll drive equipment during a weekend.

Turner also offers an installation supervisory service to guide engineers in fitting the new straightening head. After installation of the re-manufactured and modernized straightening

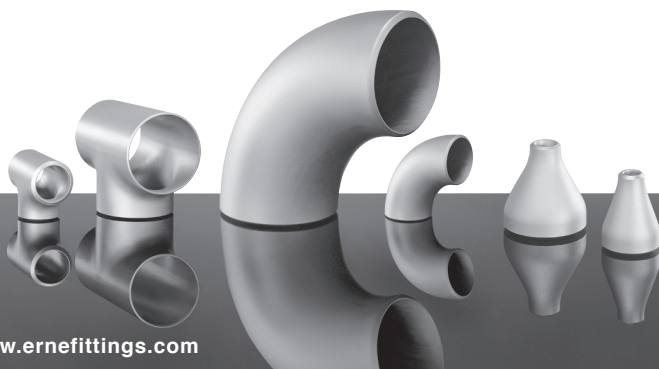
head, Turner recycles the old straightening head core.

In terms of straightening head availability, the 900 series core exchange program is available for models 912.5, 914.5, 916, 920, 922 and 924 machines.

The wait time for a remanufactured head depends upon machine size but can usually be accommodated within a reasonable time span.

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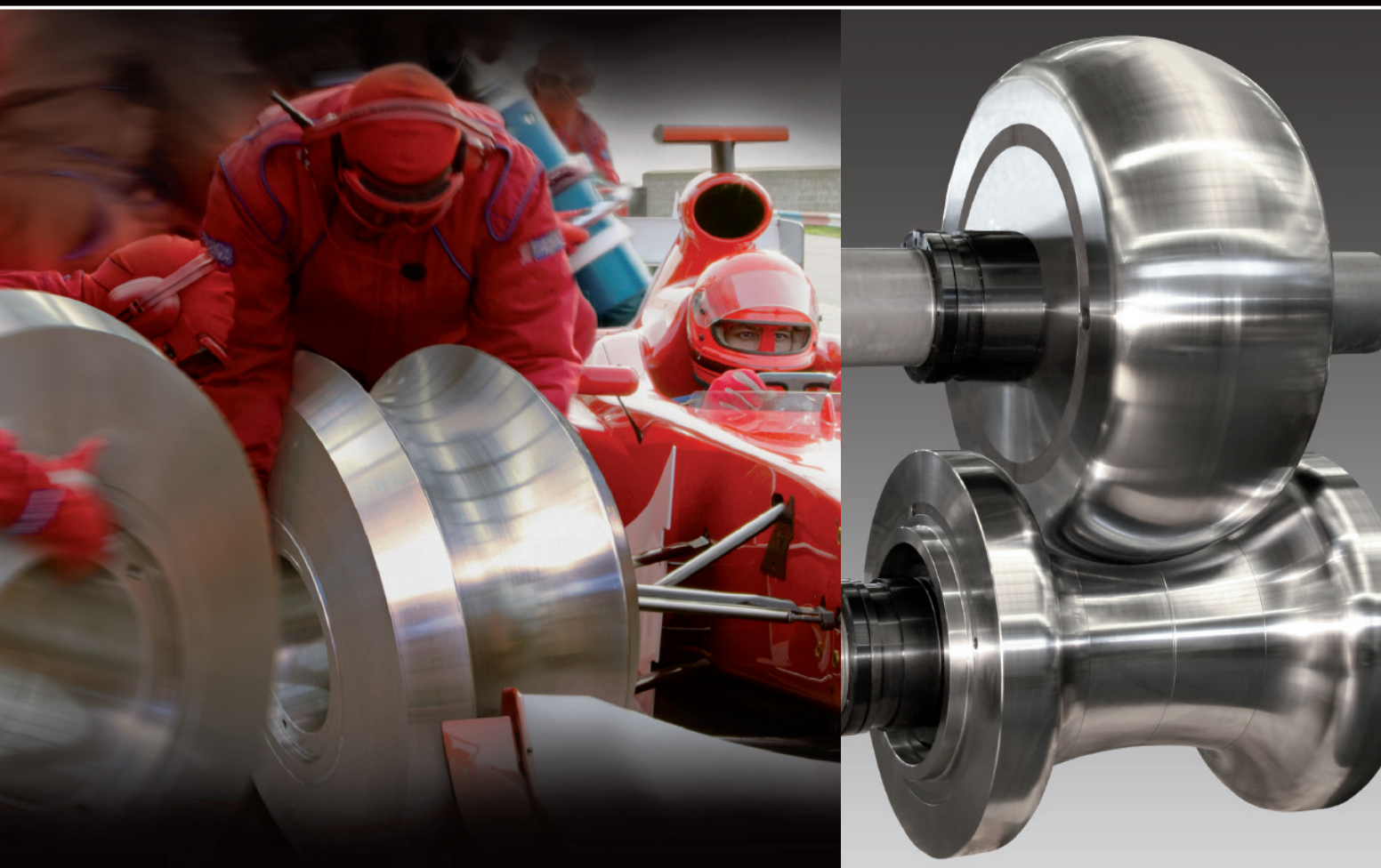
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Stainless steel tubes in standard sizes or produced to order

Tüzün Çelik Boru AS, Turkey, produces mechanical tubes, including stainless steel tubing under the brand name Atinox. The company uses raw material that is mill-certified and procured from the main suppliers of Europe.

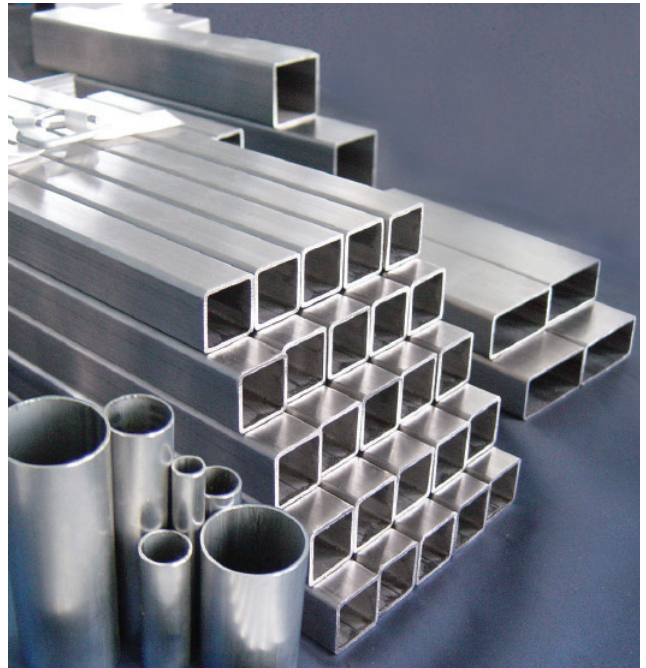
The company's mechanical stainless steel tubes (round/square/rectangular) are high frequency welded and not annealed. They are used for ornamental/constructional purposes and have brushed surface quality. The company will shortly also be supplying polished round tubes.

The stainless steel tubes are produced to standards DIN 2395/EN 10219-2 (round tubes) and DIN 17455 (square-rectangular tubes). The company has an annual capacity of around 10,000 tons. In addition to domestic sales, the company exports to Asia, Europe and Africa.

The surface of round tubes and squares/rectangular tubes is longitudinal brushed as standard. Special prepared grid 180, 240,

320, and 400 surfaces are available upon request. Round tubes can also be sent as mirror polished (also known as 600G). The internal weld bead of round tubes is cleaned as standard, at diameter ≥ 32 mm.

All sizes available from stock are from steel quality AISI 304/DIN EN 1.4301, and can be delivered immediately, regardless of quantity. Dimensions available include round tubes from 16 to 63.5mm, in thicknesses from 0.9 to 2mm; square shaped tubes from 15 x 15mm to 50 x 50mm, in thicknesses from 1 to 3mm; and rectangular shaped tubes from 20 x 10mm to 60 x 40mm, in thicknesses from 1 to 3mm.



Atinox stainless steel tubing

Other qualities of AISI 400, 300 and 200 series are produced upon order. For such orders, provided that the company's supplier has the requested material in

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Pipe Fittings	<ul style="list-style-type: none"> ➤ Size: 1/2 to 8" ➤ Material: Carbon Steel & Stainless Steel

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stock, the company is usually able to finish production within one to two weeks. Orders for lengths other than standard 6,000mm are also welcome. For different steel grades, the company would need a minimum order of around 3 tons (per dimension) in order to start production (daily production is around 15-20 tons).

The company calculates prices according to the actual weight of material delivered, rather than based on the measured thickness of the products.

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Concast supplies a minimill to Vallourec & Sumitomo do Brasil

Vallourec & Sumitomo do Brasil, Brazil, has placed an order with Concast, Switzerland, for the supply of a steelworks plant and equipment for a secondary metallurgy centre, and a continuous caster for the manufacture of seamless tubes. The plant is scheduled to go into production in February 2011.

The company is a joint venture between Vallourec, France, and Sumitomo Metal Industries, Japan. The new works is to be built in Jeceaba, Brazil, and will comprise an electric steel plant with ladle furnace, a vacuum degassing facility and a continuous caster. The works will produce liquid steel with an annual output of 1.1 million tonnes. The order for the seamless-tube rolling mill went to SMS Meer, likewise a company within the SMS group.

The ladle furnace, equipped with a transformer of 26 MVA + 10 per cent, will achieve a heating rate of approximately 5°C/min. The vacuum degassing facility is of twin-tank design and is equipped with a mechanical pump. The emptying time for the system is less than seven minutes, with support for a rapid-casting cycle.

With five strands and a casting radius of around 12m, the continuous caster produces round blooms in the diameters 270mm, 340mm and 406mm. The casting machine is equipped with electro-mechanical tundish stoppers, electro-magnetic stirrers, and a compact hydraulic mold oscillator. In addition, there is a deburrer and an automatic marking machine to which is linked a visual product recognition system.

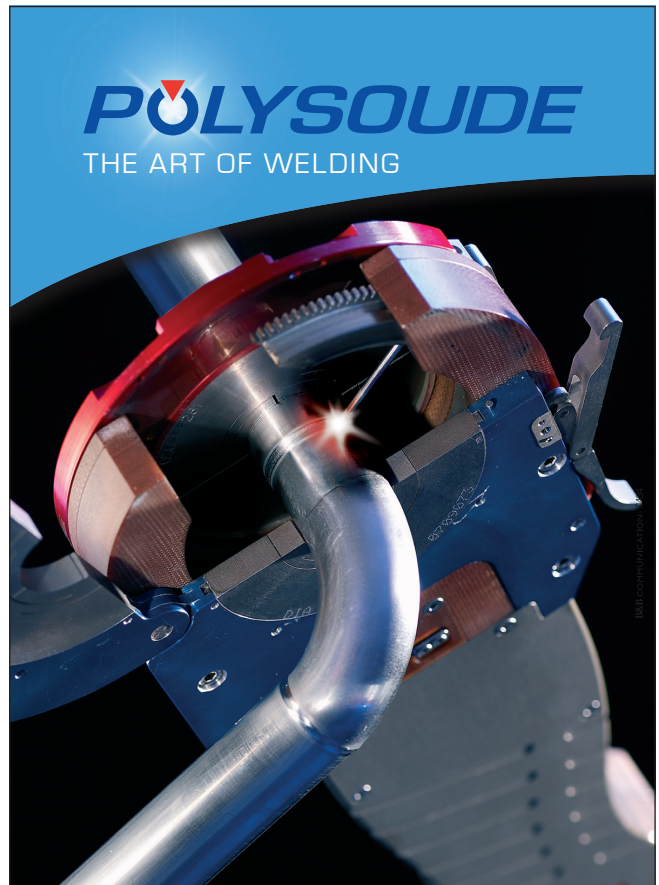
The Concast supply scope includes the complete supply of mechanical and electrical equipment, together with the automation (levels 1 and 2), supervision of erection and commissioning and training.

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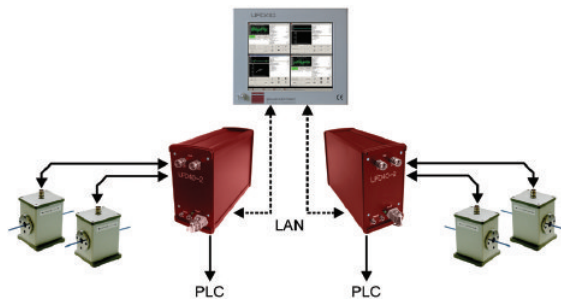
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Digital fault detector for small tubing

Roland Electronic GmbH, Germany, has launched the newly designed digital UFD40 system as a successor to the analogue UFD detector. The system has been designed to detect faults, butt welds and mechanical connections in small tubing, wires, and cables made of metallic materials such as steel, stainless steel, copper, brass and aluminium.



 The UFD40 system accommodates two independent measuring channels in one IP 65 module enclosure

The system is based on the eddy current measurement principle. The material to be monitored passes through the opening of an encircling coil sensor. Roland Electronic offers sensors suited to materials ranging in diameter from 1 – 90mm.

The UFD40 has features typically available in classic eddy current fault detection systems designed for automated production processes. These include adjustable frequencies, high and low pass filters, and y-component and vector analysis, making the

system suitable for monitoring many different discontinuities with one type of hardware.

The system features a modular design and several operating modes. The complete electronic circuitry for two independent measuring channels is housed in one IP 65 module enclosure. Each channel executes the measurement functions completely automatically.

An RS232 interface provides connection to the host PC, which serves as the

operating interface for the system and provides visualisation of all measurement values. Both measuring channels function autonomously, allowing the disconnection of the host PC. Alternatively, a parallel interface or a fieldbus interface are available for communication with production equipment PLC.

Roland Electronic GmbH – Germany
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Website: www.roland-electronic.com

Bending, end-finishing and pipe flanging machines

As a tube fabricating machinery manufacturer, PHI has more than 40 years' experience in the field, originally as Leonard Precision, then as Conrac Corporation's Machine Tool Division, and as PHI since 1985.

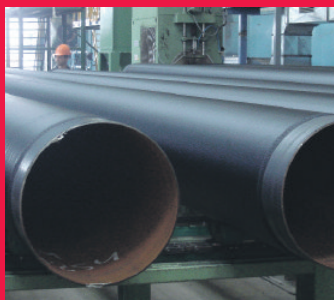
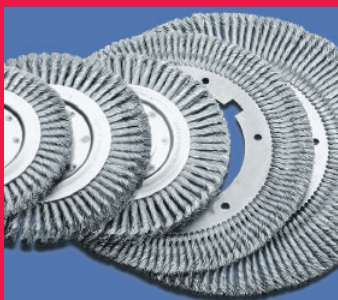
The company offers a complete range of machines and tooling for applications ranging from 1/8" light wall tubing to 8" pipe.

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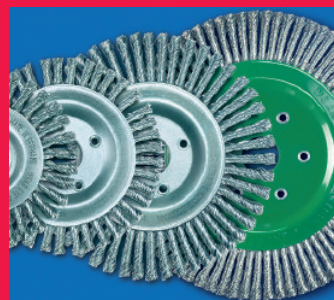


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The company's tube and pipe bending machines are available from small bench-top models to larger machines designed for tubes up to 3" x 0.188" WT, with bend radii as tight as two times the tube diameter. Controls range from manual to programmable.

End-finishing machines are used to shape the ends of the tubes of all material types. PHI's tube end finishing machines perform functions such as squaring and deburring, both ID and OD and squaring of the tube in one operation, flaring the ends of tubes both 37° and 45°, and bead forming the ends of tubes for those applications where hose clamps are required.

PHI offers a full range of machines for tube sizes ranging from 0.125" to 8" OD and wall thickness to 0.125".

The company also manufactures pipe flanging machines for those industries associated with the petrochemical and petroleum industries. These machines offer a fast and inexpensive way to cold form 90° flanges on the ends of pipe with diameters ranging from 0.5" IPS to 8" IPS sched 40, or to 4" IPS sched 80.

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A leader in graphite powders and carbon black

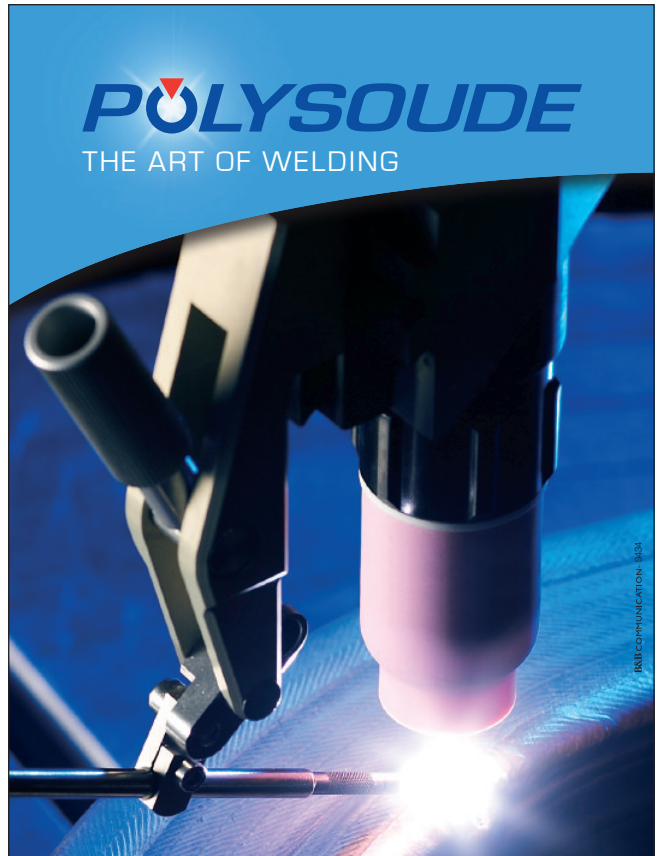
Timcal Ltd, Switzerland, offers expertise in the manufacture of high-grade graphite and carbon powders, with emphasis on the development and end-user application of lubricants and scale treatment agents of hot metal forming processes. These activities fall into three categories: products, application equipment and technical services, collectively forming Timcal Rollit® technologies.

The company provided mandrel bar lubrication technology, in the form of Timcal Rollit® DS or DP, to withstand the high pressures, temperatures and friction during the rolling process. Mandrel bar lubricants are based on high-grade Timcal graphite, selected organic and inorganic additives and water. They can be supplied in either powder or liquid form.

For scale treatment and shell lubrication, Timcal manufacture Timcal Rollit® EZ, designed for treating scale in shell interiors and/or for lubricating shells. These products are supplied in powder form, based on mixtures of Timcal graphite and special organic and inorganic salts.

The Timcal Rollit® DF line of forging lubricants is used to improve metal flow, increase tool life, quality and lower rejects, and improve yield in the forging industry. The forging lubricants are based on these points with high-grade Timcal graphite and ecologically safe inorganic and/or organic additives and water.

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Manufacturer of precision steel tubes

Tube Products of India, a unit of Tube Investments of India, is the manufacturer of precision steel tubes catering to the demands of the automotive and general engineering industries using DOM (drawn over mandrel process).

The company is based in multiple manufacturing locations across India along with one in China. Tube Products of India has a dedicated value added centre located in Chennai, India, which can provide services such as auto-cutting and chamfering, vertical machining, CNC turning, piercing, slotting, flaring, and punching.

The company supplies DOM tubes from 6mm to 117mm OD, with a wall thickness of 0.80mm to 6.40mm. These products conform to various international specifications like EN, JIS, and ASTM, and any other customer specific requirements. Tube Products of India operates 13 tube mills, 14 furnaces and 37 draw benches across various plants, together with a bright annealing facility.

The company has a research and development centre, and complies with standards including ISO/TS 16949:2002, ISO 9001:2000 and OHSAS 18001. The tubes are used in applications including front fork tubes, shock absorbers, steering shaft tubes for two wheelers and steering column tubes, axle shafts, cam shafts and propeller shafts for four wheeler application.

The list of customers include Showa, Kayaba, Visteon, General Motors, Ford, Chrysler, Toyota, Suspa, and Thyssenkrupp Presta.

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Ultrasonic flaw detectors with phased array imaging capabilities

Olympus NDT, USA, provides a portfolio of non-destructive testing (NDT) solutions featuring ultrasonic testing (UT), eddy current (ET), and related testing technologies. The company has launched the Epoch 1000 Series digital ultrasonic flaw detectors with phased array imaging capabilities.

The Epoch 1000 detectors provide advanced conventional ultrasound capabilities for both the standard and advanced level inspector. The portable instruments can also be integrated into small systems for high-speed scanning and single channel imaging.

A host of high performance features are provided as standard, including a 6kHz maximum pulse rate frequency (PRF) with single-shot measurements for accurate high speed scanning applications, tunable square wave pulser with PerfectSquare™ technology, digital high dynamic range receiver, and comprehensive digital filter sets for exceptional signal-to-noise clarity.

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⚡ The Epoch 1000 Series consists of three instrument configuration levels to suit many inspection needs – Epoch 1000, Epoch 1000iR, and Epoch 1000i. The Epoch 1000 is an advanced ultrasonic flaw detector that can be upgraded with phased array imaging.

The Epoch 1000iR provides the same ultrasonic flaw detection as the Epoch 1000, with the benefit of upgrading to phased array with simple remote activation. The Epoch 1000i comes standard with phased array imaging in addition to the ultrasonic flaw detection capabilities of the Epoch 1000.

All Epoch 1000 Series instruments feature a new horizontal case style with sunlight-readable full VGA display, knob and arrow keys for parameter adjustment and navigation, and full EN12668-1 compliance. Designed to meet IP66 environmental rating and tested for shock, vibration, explosive atmosphere and wide temperature ranges, the instruments can withstand operation in harsh inspection conditions.

The Epoch 1000i incorporates phased array imaging capabilities to enhance conventional single-channel inspections.

This advancement in inspection capability allows greater probability of flaw detection, better visualisation of areas of interest, and increases inspection efficiency by allowing simultaneous inspection of multiple focal laws and various angles in a single scan, eliminating the need for multiple probes and/or wedges. This permits operators to perform code-compliant inspections according to conventional ultrasonic standards with the advantages of phased array imaging.

Available with a standard 16:16 probe element configuration, the Epoch 1000i offers many flaw sizing features to aid non-destructive inspections. It comes standard with A-scan and S-scan (sector scan) views, as well as reference and sizing cursors for improved flaw size evaluation. The Epoch 1000i also provides DAC/TVG capabilities for every focal law, allowing flaw characterisation of a selected A-scan based on an acquired DAC curve.

The Epoch series also boasts a portfolio of standard and optional visualisation features



ⓘ The Olympus Epoch 1000i features phased array imaging as standard

to aid inspection. These include SureView™, which mimics the responsiveness of an analogue instrument CRT display, and adjustable video filtering in phased array mode for image smoothing. Combined with other features, these visualisation capabilities provide enhanced interpretation of indications.

Olympus NDT – USA
Fax: +1 781 419 3980
Website: www.olympus-ims.com



DESCRIPTION: STAINLESS STEEL SEAMLESS PIPE
 GRADE: TP304, TP316L, TP310, TP321, TP316Ti
 STANDARD: ASTM A312 A269 A213, JIS3459, DIN17456, DIN17458, EN10216-5

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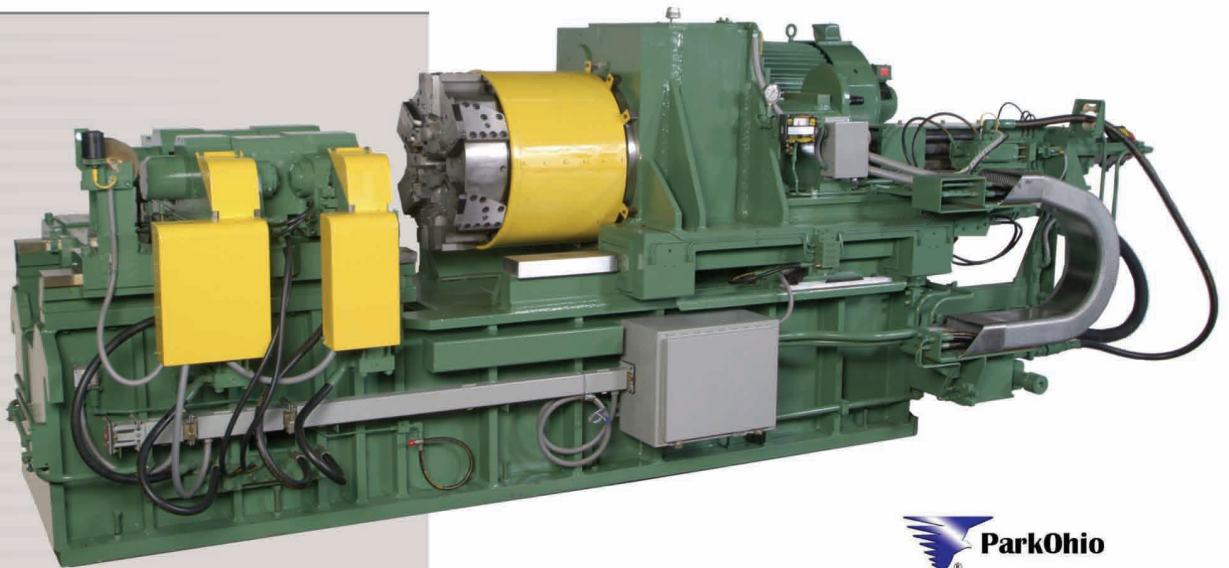
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MODEL

RTP07

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1.9" to 7"



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www.pmc-colinet.com

Smarter temperature control of multi-stage seam annealing stations

Thermatool has launched its innovative Smart Anneal system for precise and simple temperature control of multi-stage seam

annealing stations. With Smart Anneal, API pipe producers can quickly and accurately position adjacent annealer carriages by accessing stored database parameters for a given set of pipe diameters.

The result is faster, easier operation that delivers the additional benefits of superior, repeatable heat treatment plus a reduction in scrap.

At the heart of the system is selectable speed power control (SPC) whereby real time feedback via the PLC will automatically adjust the output power at each annealing heat station, taking into account mill speed.

SPC also enables annealers to engage automatically with the mill run signal.

Offering manual or fully automated temperature control, both minimum and maximum annealing temperatures can be set between 300°C and 1300°C.

Process parameters are stored for each product. Selected process variables are logged during each run for API documentation purposes, and the system is fully automated.

Thermatool Corporation – USA
Fax: +1 203 468 4281
Email: info@ttool.com
Website: www.thermatool.com

Thermatool IHWT – UK
Fax: +44 1256 467 724
Email: info@ihwtech.co.uk
Website: www.inductotherm-hwt.co.uk

 The global console for Thermatool's Smart Anneal system

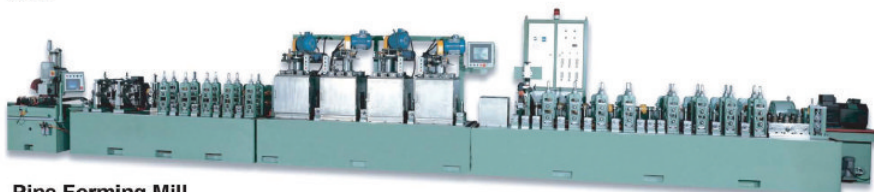


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VEGA ENGINEERING CORPORATION

VEGA specializes in offering whole-plant planning and equipments for stainless-steel and carbon steel tubes. We can provide services for whole-plant establishment plans, turn-key projects, production process improvement plans for tubes of specification as ASTM A-270 sanitary tube, ASTM A-312 industrial pipe, ASTM A-249 heat exchanger tube, JIS G-3468 large diameter pipe and etc.



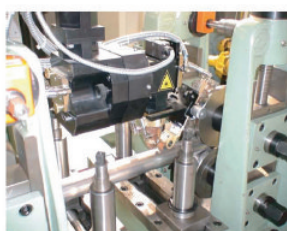
Pipe Forming Mill
Pipe O.D Range 1/2"~24"



Bright Annealing



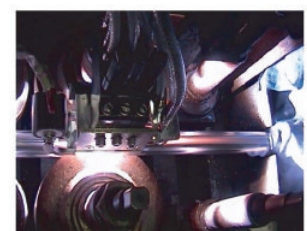
24" Pipe Mill And Annealing



Laser Welding

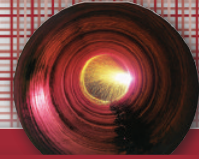


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Complete systems for energy efficient pipe production

Cincinnati Extrusion GmbH, Austria, presented its new KryoSys system for manufacturing polyolefin pipes at the company's in-house pipe symposium in Vienna. Cincinnati claims that the system can reduce energy consumption by up to 30 per cent.

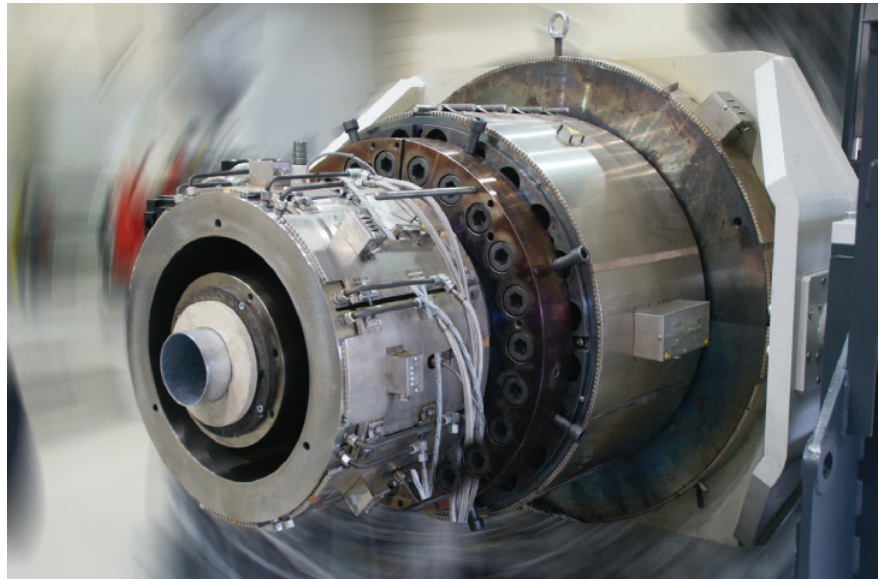
The gain in efficiency with KryoSys is achieved by the combination of a high-speed extruder with a newly developed pipe die, an efficient pipe cooling section and a heat recovery system. Krysos lines lend themselves to the production of smooth mono-layer and multi-layer PE or PP pipes with diameters ranging from 110 to 2,000mm. They are also suitable for the production of corrugated pipes.

The length of the cooling section can be halved compared to conventional extrusion lines, even for large pipe diameters. For example, a total length of 40m is sufficient to produce a 400mm PO pipe with a wall thickness of 36.4mm, using a Monos+90-37G extruder. On the assumption of an identical output level of 1,300kg/h, the total length of a comparable, 'normal' pipe extrusion line would be 85m.

To ensure optimal melt distribution, the KryoS pipe die, specially developed for the system, has been designed on the basis of a spiral mandrel die. The advantage of this particular pipe die is its innovative melt cooling system which makes it possible to start cooling the melt in the die, allowing a substantial reduction in the length of the cooling section. The lower melt temperature also brings about an increase in viscosity at the point of exit from the die, which counteracts sagging, especially in thick-walled pipes.

KryoS features a large internal aperture that allows air cooling of the extruded melt. The system is rounded off by a highly efficient pipe cooling section. In this aggregate, the pipe is cooled simultaneously from the outside and the inside by a combination of water and air cooling, which permits a further shortening of the cooling section.

With its direct drive, the Rapidex high-speed extruder operates with a high level of energy-efficiency. There is a reduction in the number of vacuum and spray cooling baths required for the downstream aggregates and the optimised cooling system consisting



The newly developed KryoS pipe die is a core component of the KryoSys line, featuring a melt cooling system in the pipe die

of water and air cooling. This means that energy consumption can be cut by up to 71kW (about 27kW is saved by the reduction in circulation pumps, and about 44kW is saved by less water circulation).

Another source of energy savings is the use of heat released by the pipe cooling system in the die. This energy can be used for material pre-heating. The torque of the

extruder can be reduced, resulting in energy savings of up to 95kW. By combining all of these measures, Cincinnati claims that a total reduction in energy consumption of roughly 186kW can be achieved.

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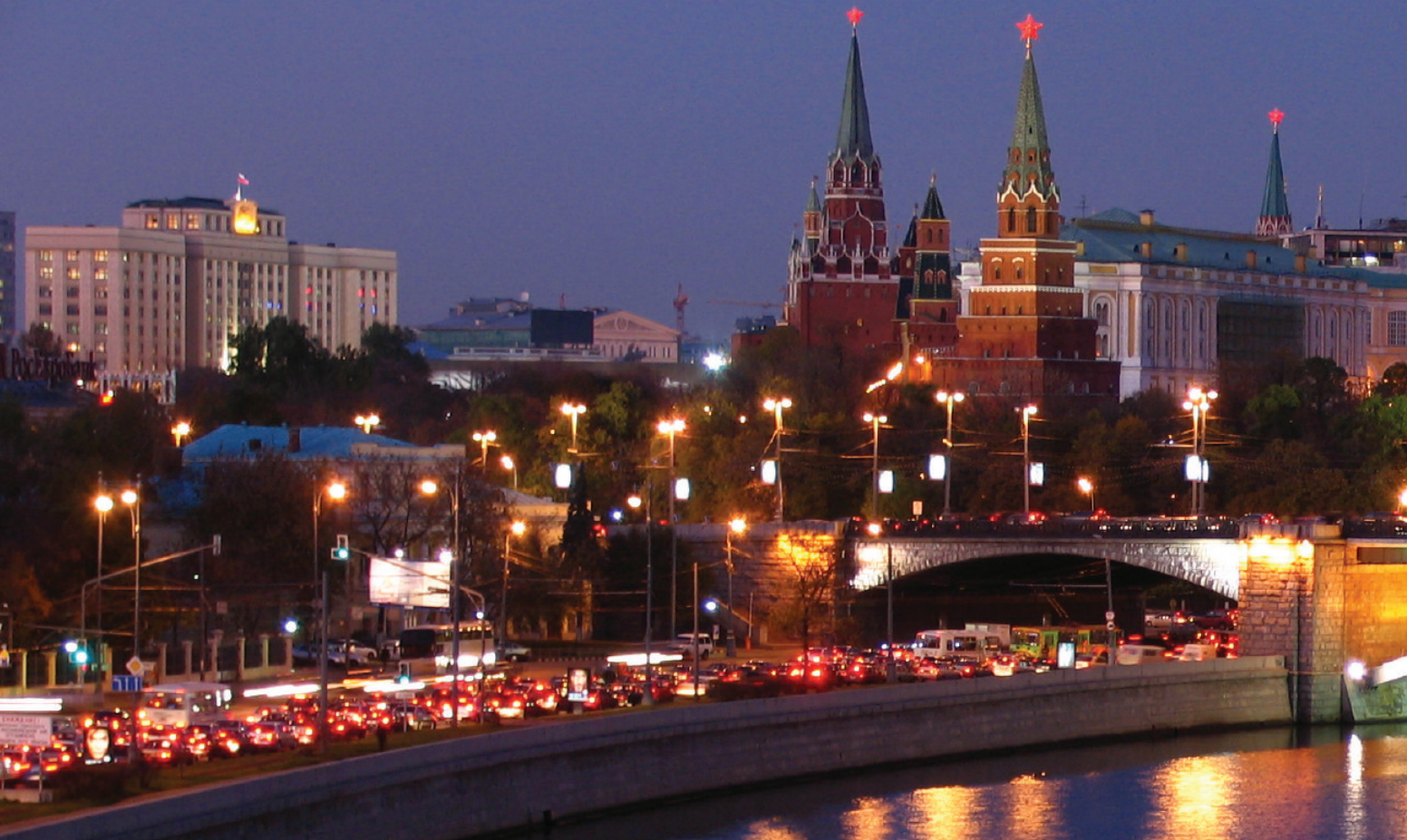
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Visit: www.JesseEngineering.com "Click on Pipe Benders"

Getting On Top Of



The Russian economy is no stranger to instability and crisis, so it could be said that Moscow is the most predictable place to do business at the moment. Due to a sustained period of financial success, with an average GDP growth of 7 per cent between 2000-2008, the country now operates on firmer foundations to secure long-term investment confidence.

Russia has resolved its leadership question, with a government now run by Dmitry Medvedev and Vladimir Putin, which should enable the country to emerge from the current global recession in a stable position. A large part of Russia's development in recent years has been due to the enormous quantities of foreign direct investment, with US\$55-58 billion estimated for 2008 (RIA Novosti).

According to an article titled '*The economic situation and investment climate in Russia (2008)*', authored by the American Chamber of Commerce in Russia and Ernst & Young, over the coming years the Russian economy will "*show stability and continued growth, despite a deteriorating situation on the world market.*"

But although Russia's business and economic outlook is far more stable than in previous decades, doing business in Russia is still a complicated venture. Ernst & Young comments, "*Many companies operating in Russia are unsatisfied with the slow pace of tax reform and disappointed by the tax authorities' inconsistency in the application and interpretation of tax legislation.*"

However, it is only by gaining entry into the Russian market that foreign companies can tackle such issues. An ideal forum to gain a foothold in the Russian market, Tube Russia 2009 will take place from 12-15 May in pavilions 3 and 7 at the Presnaya Krasnaya Expocentre in Moscow.

As qualification for the long-term confidence in the Russian market, Tube Russia 2009 is already sold out, with space only available via a wait list. In such current economic conditions, this is a highly encouraging sign.

The event will again be partnered by wire Russia, Metallurgy-Litmash and Aluminium/Non-Ferrous 2009. Tube 2007, which was the last event to take place alongside wire Russia, welcomed 300 exhibitors from 26 countries and 13,500 trade visitors.

The Russian Market



Image copyright: Bigstockphoto.com

Website: www.metallurgy-tube-russia.com

SHOW FACTS

DATES

12-15 May 2009

VENUE

Krasnaya Presnya Expocentre,
Moscow, Russia
(halls 3 and 7)

ORGANISER CONTACTS

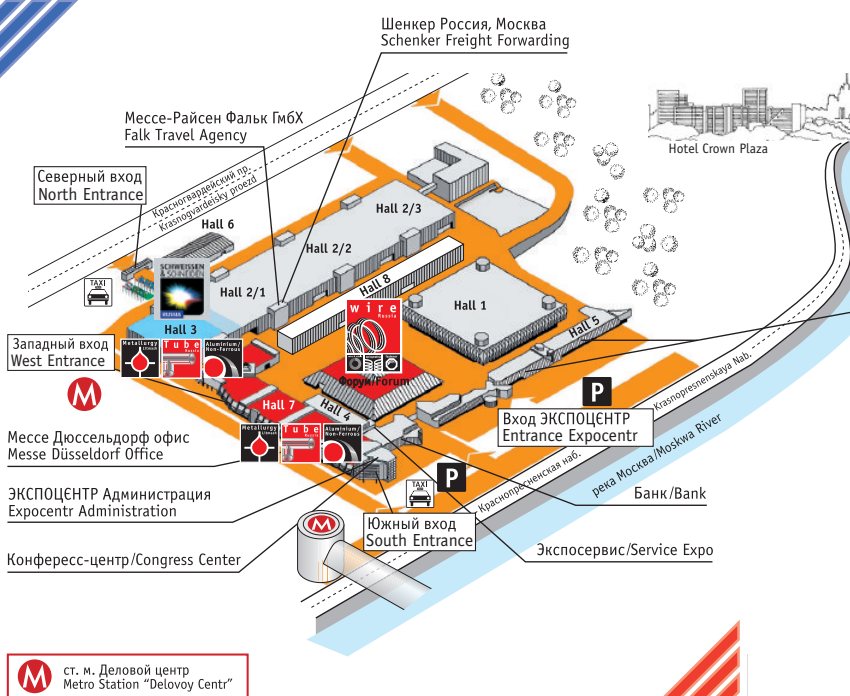
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Buhlmann GmbH + Co KG	Germany	7-5C15	Nakata Mfg Co Ltd.....	Japan	7-5C28
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International Tube Association	UK.....	7-5B19			
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KCI GmbH	Germany	7-5C20			
Koerner GmbH.....	Austria.....	7-5A19			
Künkel-Wagner GmbH	Germany	7-5A11			
Kurtz GmbH	Germany	7-5B08			
Laempe & Mössner GmbH	Germany	7-5B03			



Exhibitor list correct at time of going to press. The list does not contain exhibitor groups from Russia, China and Italy. Please contact Messe Düsseldorf for updates.

**Abbey International Ltd
USA**

With over 100 years of experience, Abbey International Ltd is a source for equipment used in the welded pipe and tube industry. The company designs and builds new pipe mills, tube mills, slitting lines, draw benches, entry coil handling, exit tube handling, cutoff equipment, and other related systems.

Abbey International, a leader in pipe mill technology, is also within the Bronx International group. The group is a single source supplier of mills and finishing equipment with over 3,800 installations in over 60 countries.

Combined, Abbey and Bronx have one of the largest ranges of ERW mills and pipe finishing equipment available.

Abbey's patented Quick Change System® can deliver automated changeovers in as little as 15 minutes and the TBS® forming system can be retrofitted to mills, reducing roll tooling costs and changeover times.

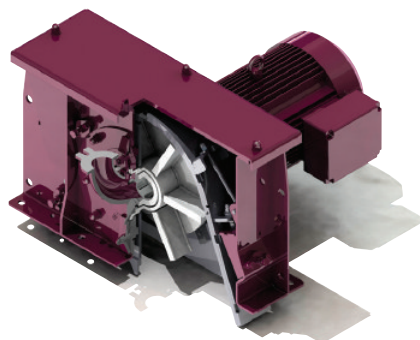
Through partnership with Bronx Taylor-Wilson, the premier builder of finishing equipment, Abbey offers first class equipment for tube and pipe manufacture, including turnkey processes and individual machines.

Website: www.abbeyintl.com

**Agtos GmbH
Germany**

Agtos is a manufacturer of shot-blast machines constructed according to specific user requirements. High performance turbines are used in the design, proving their worth during modernization of older blast machines from other manufacturers. The turbines create advantages in terms of operation and maintenance of the units.

The Agtos high performance turbine is a rugged aggregate structure that is extremely efficient due to a reduced number of wear parts and a high abrasive flow rate. This reduces maintenance times compared with other turbines and saves maintenance costs.



↑ *The Agtos high-performance turbine featuring a sturdy housing made of manganese steel*

The patented shot-blast turbines are equipped with six blades located on one side attached to a single disc. For assembly, normal tools are sufficient.

Compared to other turbines, the blasting wheel only has six blades instead of eight or more. Moreover, the distance bolts that are required for double disc wheels are no longer needed.

The spare part costs are already reduced by the low number of wear parts. In addition, there are fewer components disturbing the flow of the abrasives (no velocities), which improves the blasting result at the same power consumption levels.

Website: www.agtos.de

**Ajax Tocco Magnethermic
USA**

Ajax Tocco Magnethermic Corp is one of the world's leading manufacturers of induction melting and heating equipment, with worldwide operations in nine countries. Along with serving industries such as steel, automotive, forging and foundry, Ajax Tocco has a global commitment to the tube and pipe industry.

The company manufactures induction-heating systems that process up to 120t of high quality pipe and casing per hour with consistent quality and ovality. According to the company, this induction heating equipment provides a reliable and flexible supply of heat, with outstanding control.

The Ajax Tocco converters facilitate this flexibility with a patented, wide operating window. This allows a larger range of sizes to be processed in one induction coil size

without the need for capacitor or voltage switching.

Converting the barrel furnaces to induction heating, for stretch reducing, enables the use of existing handling equipment and the advantage of fast, controllable, energy saving induction heating.

The results can lead to dramatic savings in space, reduced energy consumption, improved quality and the benefit of recipe control.

Ajax Tocco is at the forefront of API pipe production for the oil and gas industry. Because casing drill pipe and line drill pipe reliability is crucial, the company believes it is a highly dependable source of supply systems to harden and temper pipe, casing and couplings to full API specifications.



↑ *Heating a pipe using machinery from Ajax Tocco*

An industry expert for tube and pipe heating, Ajax Tocco specialises in seam annealing, solution annealing, bright annealing, coating, bending and forming.

Website: www.ajaxtocco.com

**Atl a spol sro
Czech Republic**

Atl a spol sro, a regular exhibitor at Tube Russia, is a manufacturer of complete tube mills and components for the mills to produce longitudinally welded tubes and profiles.

The company's products are designed and constructed with the traditional Czech



Sometimes it's good to
plan ahead ...



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ⓘ Attl a spol is a manufacturer of tube mills and related components



attention to detail, high technical standard and quality of construction.

The welding section incorporates HF welders from Thermatool Europe Ltd. Attl a spol also offers mills with welding by lasers from Trumpf, IPG and Rofin.

These machines reflect considerable experience in the field gathered over many years accommodating the highest demands of performance technology.

Website: www.attl.cz



Bronx/Taylor-Wilson, founded in 1896, is a global leader in the manufacture of metal finishing equipment solutions. The company's product portfolio includes bar, section, rail and profile straightening machinery.

The Bronx name is synonymous with its tube straightening machines, both in 6 and 10 roll versions, plus hydrostatic pipe testing machines, rotary pipe cut-off and end facing equipment material handling and other ancillary finishing equipment.

With over 100 years of industry experience, and thousands of installations worldwide, Bronx/Taylor-Wilson provides technology increased speed and efficiency.

Bronx equipment utilizes the latest revision of its highly proven Compass computer aided setting system. This system uses the very latest in industrial electronic technology to predict optimized roll settings based on



ⓘ A 10-roll straightening installation from Bronx/Taylor-Wilson

operator input. The system provides the user with a consistently high quality product and throughput capacity with the added benefit that size changeover times are now reduced to less than 3 minutes.

The Bronx range includes speciality machinery designed for the finishing of long products, including heavy beams, channels, rails and angles plus equipment designed in particular for the OCTG finishing industry. This includes heavy duty straightening machines that can automatically process hot pipes and pipes with upset ends.

Website: www.btwcorp.com



Zibo Wel-Fit Metal Products Co Ltd

Product Range

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- Stub Ends – MSS TYPE-A& B
- Stub Ends – ASME Long
- End Caps
- Sch5S – XXS
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Specifications

- ASME B16.9
- ASTM A403 304/L 316/L 321 347
- ASTM A234 WPB P11 P22 P5 P9
- ASTM A420 WPL6
- ASTM A815 S32205 S32750
- JIS B2311 2312 2313
- DIN 2605 2615 2616 2617
- EN 10253-1



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- Spectro-analysis



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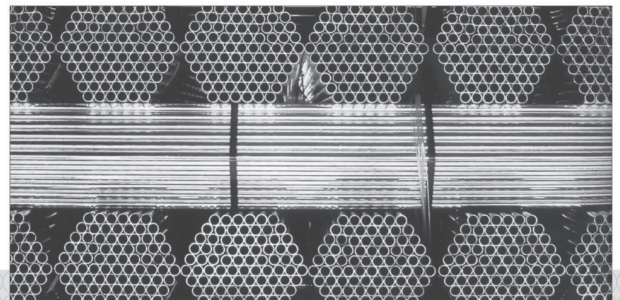


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Bültmann GmbH is a leading manufacturer of tube drawing machines and associated equipment. The company has recently supplied the first of two tube-drawing machines of the latest generation to a well-known European steel tube manufacturer

The drawing machines have special features including automatic tube separation, automatic plug insertion, tool-free drawing die adjustment, and drawing drive by AC motor and toothed rack.



Bültmann supplies an advanced range of tube drawing machines

The machines, which have a nominal drawing force of 600kN, prevent noise from falling tubes during separation. They are fed onto the pusher track, taken over at the end of draw or evacuated into the collecting cradle. This ensures low-noise and highly protective manufacturing. There is also tool-free and automatic changing of mandrels.

The machines operate with a single, double or triple drawing mode, while the drawing speed is a maximum of 90m/min, and the drawing length is 14m.

Website: www.bueltmann.com



Can-Eng Furnaces Ltd is a designer and manufacturer of industrial heat treatment equipment. Since 1964, these rugged furnaces have served commercial and captive heat treaters, stamping and fastener companies, automotive component



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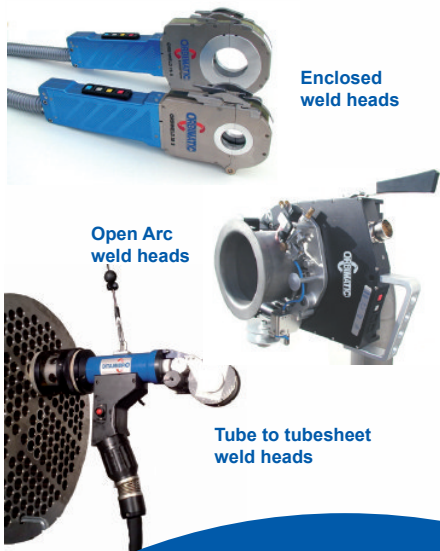
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producers, the iron and steel industries, aluminium foundries, agricultural, construction and appliance manufacturers.

The company's product line includes continuous steel tube heat treatment systems, continuous mesh belt furnace systems, batch integral quench furnace systems, nonferrous heat treatments systems (T4, T5, T6, T7), nonferrous basketless heat treating systems, Scada system process enhancement technology (PET™) and a wide array of custom furnace solutions.

Applicable for API drill tube applications, the Can-Eng walking beam furnace systems offer fully integrated hardening, quenching and tempering for high volume and continuous production up to 10,000kg per hour of long products. Its unique quenching system maintains straightness and provides extremely uniform metallurgical and mechanical properties. Can-Eng's furnaces operate up to 1,100°C, have optimum circulation of hot gases and allow for easy scale clean out.

Website: www.can-eng.com


Condat France

Condat will display its extensive range of lubricants covering all industrial requirements in the field of wire drawing, cold rolling, and drawing of bar and tube. The company provides the Vicafil® range of lubricants for most drawing applications. The Steelskin® range of high tech dry lubricants are used for advanced drawing. The Galvasmooth® line consists of charcoals that work with hot dip galvanizing lines, while Condaclean is a range of cleaners used in most applications.

Condat offers lubricants that meet the most recent environmental and health and safety legislations. Such demands require low dust in workshops, handling for chemicals (Reach, biocides), and eco-friendly lubricants (free of borax, barium, and sodium nitrites).

The show will present an opportunity for Condat to launch a new range of sodium soap based dry lubricants with regards to the latest environmental regulations (Borax) with improved drawing performances. The company's Vicafil Sumac 3, Vicafill TN 1630 and Vicafil TN 21 cover applications in low and high carbon steel, and stainless steel.



 Dry lubricants are used for advanced drawing applications

Significant developments have been made in the field of lubricants for the production of welding wires and electrodes. These developments include dry powders, wet lubricants and pastes for copper free welding products.

Website: www.condat-lubricants.com

Contrôle Mesure Systemes France

Contrôle Mesure Systemes (CMS) is a leading manufacturer of eddy current inspection systems, with a full range of online and offline equipment for wire and bar, tube and pipe, plate and sheet, and automotive parts. The entire range of the company's products meets the requirements of quality standards including API, ASTM, and DIN.

The company offers the Eddyscan® brand for eddy current and UT Scan for ultrasound. These products form the basis of the company's growing range of products designed for all application areas. CMS has recently launched the brand new Zet@Master for eddy current. Despite being one of the smallest instruments on the market, the Zet@Master offers unique features, including multi-channels, multi-frequencies, frequency range from 10Hz to 10MHz, and a supervision system that allows control of all peripheral devices.

A special feature – sorting management and reporting – provides reports that give defect location, type, and the number of good and bad parts. The reports also include different rates with a virtually unlimited number of parameter sets. Remote control is possible via the internet, enabling supervision and support from anywhere in the world.

With a full range of accessories, CMS offers a solution corresponding to specific inspection requirements. Accessories include magnetizing and demagnetizing units, standard or customized coils, and a wider





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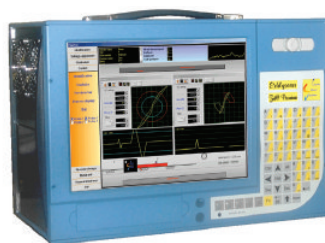
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↑ CMS is a manufacturer of eddy current inspection systems



range of rotating heads to inspect longitudinal defects on wire and bar. Six different sizes are available, from Ø 2mm to 220mm.

Website: www.cmseddyscan.com

Elmaksan Turkey

With over 25 years of experience, Elmaksan is the manufacturer of an extensive machinery range including pipe and profile lines, cut-to-length lines, slitting lines, multi blanking lines, trapeze lines, open profile lines, slitting knives and spacers.

The company also offers coil process equipment, automatic packing machines, levelers, rotary shears, multiple cutting units and associated spare parts. Each of these lines can be modified to meet the specific production needs of the user.

Elmaksan operates two large facilities, one located in Istanbul (5,000m²) and another in Kocaeli (22,000m²), staffed by over 150 people. More than 80 per cent of the total volume of production is exported abroad to 40 different countries all over the world. With a constantly expanding product range, the company's machinery is designed, manufactured and supplied according to the highest quality standards.

Website: www.elmaksan.net

Emmedi (Saet Group) Italy

Emmedi, the welding and annealing division of the Saet Group, is a leading manufacturer of solid-state welders. The company has introduced the new solid-state welder

generation Mosweld, based on a Mosfet type inverter able to work up to 450kHz.

As typical working frequencies in the tube welding process are in the range of 300-450kHz, Mosfets are the most cost-effective choice for this application. A system control board is provided on this unit, which communicates with the inverter through optical fibres. The inverter is a current fed type, composed of an essential number of modules connected in parallel: the output oscillating circuit is directly connected to the inverter.

Mosweld has advantages including high efficiency, modular design, easy maintenance, short circuit proofing, reliability, and much lower voltage inside the cabinets compared with oscillator tube technology. In addition, power components are not subject to obsolescence, while the welder uses the same coils as the Classic oscillator tube welder.



↑ The new solid-state welder generation Mosweld (250kW)

The modular structure and a complete diagnosis system allow very quick and easy maintenance in order to reduce production stops. A special digital control system has been developed for an optimum phase locking (and then for efficiency increase), with the possibility to follow the change of frequency due to load variation, at any working condition.

For a quick and cheap solution in case of technical problems, Saet Group offers a special service in remote mode called Teleservice. This allows the company's engineers to operate from its premises directly into the welding unit installed at the customer's plant.

Website: www.saetgroup.com

Framag GmbH Austria

Framag is the manufacturer of high-speed carbide circular sawing machines that provide precise cutting quality, low tool costs, high cutting capacity, and robust and durable design.

The company's machinery can handle a range of workpiece dimensions from 70-200mm (square) and 130mm x 260mm (rectangle), in materials including alloyed and unalloyed steel, carbon steel and tempered steel. The diameter of saw-blades is from 710mm to 910mm, with cutting speeds up to 250m/min, and length of cut pieces from 100mm to 600mm.

The company has recently supplied its customized technology to QSZ – QualitätsSägeZentrum GmbH in Germany. The first phase of this deal comprises material positioning 'for perfect cut' by frequency-controlled infeed and discharge conveyor as well as by two opposite positioned laser units to control the conveyors. A positioning accuracy of ±5mm is possible. In the second phase the sawing unit will be fitted with a support grate, material feed unit (positioning accuracy of ±0.5mm) and a scrap removal device. This allows a fully automated operation of the whole sawing process.



↑ The state-of-the-art circular sawing machine type KKS 1250

The state-of-the-art circular sawing machine type KKS 1250 billets for sawing of solid material (round, square, rectangular) is equipped with a centric main and auxiliary clamping device as well as with a height adjustable table.

The advantage is the hydraulic support of bent or curved material and protection of the saw blade against jam in the cut. Thus it allows much higher durability of the sawing blades. On average more than 50m² saw blade tool life is reached.

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These values result from the technical combination of a sawing column made of Hydropol®, extreme torsion-stiff and robust sawing gearbox, and stable and vibration-free clamping devices. The combination of these three critical factors reduces vibration caused by the sawing process.

The KKS 1250 sawing machine allows cutting of round material with diameters from 180mm to 420mm and steel square bar with an edge length of 160-400mm. Sawing blade diameters from 1,100mm to 1,350mm are possible. A user-friendly Siemens PLC technics control system is fitted.

Website: www.framag.com



Fronius Ukraine GmbH produces welding machines using conventional technology, and also sells inverter and conventional technology to local markets in Ukraine, Belarus and Russia.

The company claims to offer an ideal solution for any application area, from compact MMA



Fronius manufactures a wide variety of welding machines

welding machines, MIG/MAG and TIG applications to complex automated welding systems. In addition the company offers new technologies for cutting and spot welding.

All the company's products are developed in collaboration with its customers. This means that all Fronius products are matured, tested in real-life situations, reliable and user-friendly.

Technology Centre Tena is an official Fronius sales partner for Russia and carries out the sale, introduction and servicing of Fronius equipment in Russia.

Fronius Ukraine GmbH – Ukraine
Website: www.fronius.ua

Technology Centre Tena – Russia
Website: www.tctena.ru



Established in 1987, Hasemann Maschinen specialises in the worldwide purchase and supply of high quality used machinery for the processing and treatment of steel and non-ferrous products such as semi-finished bright steel bar, tube and wire.

The company's delivery programme includes pointers, swagers, single/multiple drawing machines, bull blocks, combined drawing machines, chain drawing benches, pre-straighteners, and two-/three-roll straightening and polishing machines.

In addition, Hasemann can supply section straighteners, 6-roll tube straighteners, straightening and cutting machines, bar peelers, and centreless grinding machines, and mesh welding machines.

The company's customers value and welcome their expertise, and the ready availability of used machinery.

Website: www.hasemann-maschinen.de

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Inductotherm HWT UK

Visitors to the Inductotherm Group stand will have the opportunity to discuss their heating and welding requirements with application specialists representing the Thermatool and Radyne brands.

Thermatool specialises in providing innovative and cost effective solutions for tube and pipe producers throughout the world. With the largest installed base of more than 1,200 solid-state HF welders worldwide, Thermatool has over 50 years of experience in the continuous high-speed production of quality tube and pipe from 8mm to 24" diameter. The new range of Thermatool VIP seam normalising and full body annealing systems provide added systems capability to producers of high quality API grade oil and gas pipe.

Radyne offers producers and installation contractors of API pipe an unrivalled range of induction heat treatment and coating systems, including pre- and post-weld girth joint heat treatment and coating technology. Designed for both onshore and offshore applications, Radyne Merlin and SwirlCoat systems are engineered to satisfy even the harshest and most demanding installations.

Website: www.inductotherm-hwt.co.uk

International Tube Assoc UK

The International Tube Association (ITA) is the world's largest association of tube and pipe engineers and its presence will be geared towards offering assistance to tube and pipe professionals. Emphasis will be placed on the membership benefits available, including support services at the major tube shows worldwide and the educational opportunities provided through technical conferences and seminars.

Existing members can ensure they are taking full advantage of the enhanced range of membership benefits. Non-members will be able to meet ITA staff to learn all about what the Association can do for them. They can also collect details of the ITA benefits including reduced delegate fees for ITA



International Tube Association

conferences, free promotional opportunities in the ITAN newsletter, and free visitor entry and hospitality at selected exhibitions.

Members can also gain access to copies of ITA technical conference papers, and large discounts for company promotion on www.tubefirst.com (the comprehensive online material, product and equipment database). In addition, all members receive a free annual subscription to either of the two officially endorsed magazines, *Tube & Pipe Technology* and *Tube Products International*.

At Tube Russia, the International Tube Association will also promote its forthcoming conference for Turkey and the surrounding region, jointly hosted with Ilhas Fuar. The 'Pipe & Tube Istanbul 09' conference will take place from 2-3 November 2009 in Istanbul, Turkey.

Website: www.itatube.org

Olimpia 80 Srl Italy

Olimpia 80 Engineering designs and constructs complete mills for the production of welded tubes. The company is able to offer both individual pieces of equipment and complete lines, suitable for any TIG, laser and HF welding, and for materials such as stainless steel, carbon steel, titanium, copper and other non-ferrous materials.

The company can also provide a wide range of equipment for strip handling, tube cutting, inline bright annealing, and inline or offline tube finishing. One of the company's latest developments is a satin and mirror polishing machine for round, square or rectangular tubes.

Olimpia 80 can also supply turnkey systems, find personalised solutions, and provide complete after-sales technical services and personnel training.

Website: www.olimpia80.com

PMC Colinet USA

PMC-Colinet, a division of Ajax Tocco Magnethermic Corp, manufactures advanced coupling starter and screw-on machine systems for secure connections in the oilfield. Designed for API and premium connections, the systems use floating spindles to automatically and precisely fit a coupling onto a pipe end for OCTG applications.

The systems leverage a high-powered motor to screw the coupling on securely, applying and recording the right torque. These systems thus save time, labour and expense in the customer's application by making it easier to assure a tight and precise pipe-to-coupling fit.



 Coupling starter and screw-on machine system

The coupling starter and screw-on machines ensure connections for pipe sizes ranging from 1.9" to 20". The systems are equipped to measure and control torque, turns, stand-off and 'J' dimension metrics. Accompanying operator interface terminals display and store final values and graphical profiles, using PC-based Windows operating systems.

Other technical features include a coupling starter, independently controlled spindle speed, and a hydraulically actuated gripper head and pipe chuck. The coupling screw-on has a variable spindle speed, 75kW (100hp) spindle motor power, and a make-up torque of up to 35,000ft-lb.

The starter and screw-on systems are among the dozens of pipe-processing systems manufactured by PMC-Colinet. PMC-Colinet's parent company, Ajax Tocco Magnethermic, is a leading worldwide designer and builder of heating, melting and processing equipment for pipe applications.





Specialities include quench and temper lines, annealing furnaces, and heat treatment solutions for seams and welds.

PMC Colinet – USA
Website: www.pmc-colinet.com

PMC Colinet – Belgium
Email: sales@colinet.be



Reika offers a range of straightening machines, tube finishing systems and tube cutting machines. The company has recently announced a new sales record of €30 million for 2008. For 2009, Reika's complete production capability is sold out due to big orders from Vallourec & Mannesmann, Tenaris, Interpipe, Benteler, and Tubos Reunidos.

The company has successfully installed a large number of new straightening machines, tube finishing systems and tube

cutting machines. The company's main customers are seamless tube mills and automotive/tube processing companies.

Seamless tube mills are discovering an increasing number of advantages to the automatic material flow in cold finishing lines, with overall material tracking and optimization process. The tube optimizing software in tube finishing lines can help to reduce the material scrap by up to 3 per cent. In addition, precise straightening of tubes up to the ends is an advantage of the new straightening lines and increases the yield of the tube mills.

In particular the east European market is replacing old equipment with new finishing lines. Integrated NDT testing lines, which are interfaced in the material flow and in the data communication in front of the cut-off line, make individual automatic tube treatment very easy. The bad ends and necessary production/finished length can be optimized and cut according to the results from the testing section.

Variable tube positioning allows individual tube handling and saves material. Tool costs for cutting can be saved due to the constant cutting process of the rotary cut-



Reika offers the full scope of cold tube finishing systems

off machines, which are much more efficient in comparison with carbide saws with interrupted cut and long blade change times.

At this year's Tube Russia, Reika will show the advantages of its new finishing line in regards to cost saving and quality improvement. The finishing lines still operating on many tube mills are very labour intensive. They often lack the automatic material handling (with

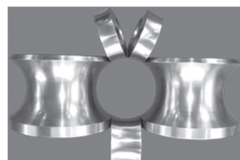


SiFang China

Shandong Province SiFang Technical Development Co., Ltd

The Popularization Center of High Chromium Alloy Roll of Productive Force Promotion Center of National Metallurgical Industry

High chromium alloy straightening rolls are widely used in cold and hot straightening towards seamless pipes, welded pipes, H-steel and other section steels. Applications in large-scale metallurgical enterprises in China, as Tianjin Pipe (Group) Corporation, Shanghai Baosteel Group, Laigang Group and Shougang Group, have proved that the technical level and service life of high chromium alloy roll has reached advanced world level. Being used in cold roll forming steel and welded pipe machines like 24" ERW butt welded pipes and 500mm rectangular pipes, high chromium alloy roll have been proved with its technical level and service life reaches that of products such as D2 and H13 of America, X155CrVMo121 of Germany, SKD11 and SKD61 of Japan. High chromium rolls have been supplied to more and more international customers and got good feedback.



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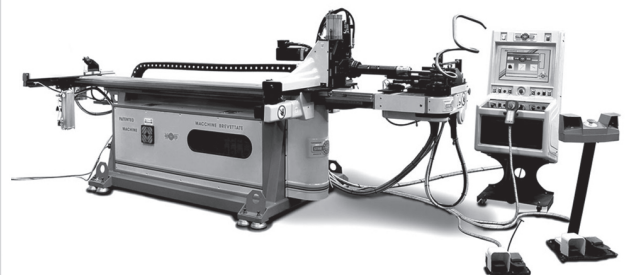
Available in thirteen different size configurations, from the simplest model one axis up to the more complete model 6/8 axis CNC, able to bend seven sizes of tubes from Ø 6x1 to Ø130x8 mm.

This new system, managed by brushless motors, controlled by the latest generation of digital drivers and by the proprietary and exclusive "bending cycles" management software operating in Windows environment.

This ensure a line of machines with the most reliable performance, purchasing costs and managing costs.

Exclusive patented Star Bend design allows the machine to be entirely modular in the maximum range of updating and to interface with any other bending machine; they allow to interact with measurement centre laser 2, by work station remoting or by modem with tele assistance.

A Star Bend machine is one of the most modern, innovative and advantageous solutions to any bending problem.



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Since 1998, 36 units of FFX Mill (ϕ 2" ~ 25") are working in the world among which 14 units are revamping purposes, and 24 units of Milling Cutoff working among which 10 units are revamping purposes



12" FFX Mill




12" Milling type flying cutoff machine



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 automatic tracking system) throughout the different production steps.

Reika can offer the full scope of cold tube finishing systems with integrated material tracking system and quality assurance. The benefits are optimized and automatic material flow operating with efficient tube processing from straightening, testing, cutting, chamfering and transport up to the final finished bundle.

Website: www.reika.de



Tre C Srl is a manufacturer of bending machines for metal profiles based on long-standing experience, technological innovation and operational flexibility. The machinery is designed to improve performance and flexibility of application in various fields.

The company has recently developed a new numerical control – branded the CNW333 –



 The CR238MRIMW bending machine with CNW333 numerical control

that is suited to all its hydraulic bending machines. The new CNW 333 is based on the Windows XP operating system, and can work in single and multi-run functions.

The CNW333 can be applied to hydraulic machines both with two-speed rotation motor as standard and with a speed regulator, which allows operation of 4 processing axes with automatic speed calculation.

In addition to the functions already present in the other versions, it provides a user-friendly programming system. It has programming of up to 36 radii and automatic positioning calculation for new bending radii, facilitating processing performance and programming.

Files can be managed directly in DXF format in order to obtain the geometry to be performed and create network connections for interfacing with other PCs for data exchange.

Website: www.treocrsrl.com



Tuboscope, a manufacturer of high speed, non-destructive testing equipment, offers welded pipe and tube manufacturers and processors several solutions for weld seam inspection. Designed for inline and offline applications, Tuboscope's WeldSonic C, Truscope® and ERW Amalog systems provide flexibility for the customer to select the right technique to meet specifications.

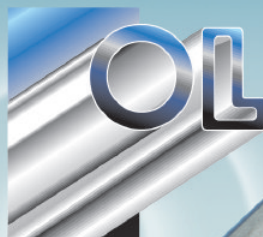
Designed for inline installation after the welder, or offline after heat treatment and hydro-testing, the WeldSonic C enables multi-channel ultrasonic (UT) inspection of the weld seam and HAZ (heat-affected zone).

BiSegno

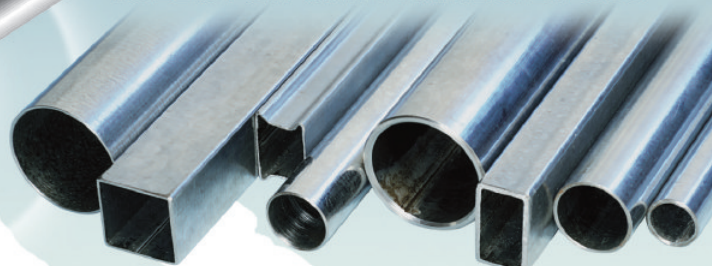


HIGH STRENGTH STEEL TUBES FOR BIKES FRAMES: S 420 MC

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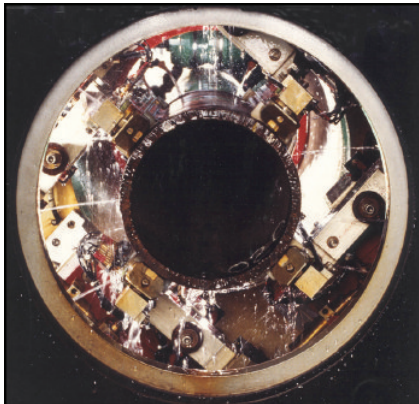



ULTRA HIGH STRENGTH STEEL TUBES FOR CAR FRAMES: DP 800



OFFICINE DI LOMBARDORE S.p.A.
Tubes Manufacturing Company

**High Strength, high quality tubes:
a middle Europe partner for automotive suppliers.**



 *Truscope provides complete full-body ultrasonic inspection*

For complete full-body ultrasonic inspection applications, the Truscope system provides fast and accurate flaw detection and wall thickness measurement for both statistical control and conformance to industry specifications.

The company also offers the ERW Amalog system for full-body electromagnetic induction (EMI) inspection, with longitudinal defect detection of both the weld seam and the pipe or tube body. WeldSonic C, Truscope and ERW Amalog all incorporate Tuboscope's latest developments in digital signal processing, graphical presentation and connectivity to host computer systems.

Website: www.varco.com



Ukrmetallotorg Ltd is the official representative of CJSC Lugansk Tube Plant and delivers its products for export. The company has been working on the international metal market for over 10 years and supplies welded steel tube/pipe produced by Lugansk Tube Plant.

This supply schedule includes more than 25 countries including those in the CIS, Germany, Bulgaria, Hungary, Syria, Turkey, Lithuania, Latvia, Estonia, Poland, Romania, Israel, and South Africa.

Since December 2007, Ukrmetallotorg Ltd has also been the exclusive representative of Tube Works Levoberezhnyy, which is specialized in the production of steel welded profile pipes.

Ukrmetallotorg Ltd is interested in broadening its foreign-economic activity

and would like to extend its business activity to new markets.

Website: www.ltz.com.ua



United Metallurgical Company (OMK) is one of Russia's largest producers of pipes, railroad wheels, and other metal products for energy, transport, and industrial companies. OMK comprises six of the largest enterprises in the metallurgical sector.

The OMK Pipe-Rolling Division comprises Vyksa Steel Works (Nizhni Novgorod Region), Almetyevsk Pipe Plant (Republic of Tatarstan), and Trubodetal (Chelyabinsk Region); the OMK Steel Works Division comprises Chusovoy Metallurgical Works and Gubakha Coke (Perm Territory), and Shchelkovo Steel Works (Moscow Region).

In 2007, OMK products accounted for 18 per cent of pipes consumed in Russia, including 34 per cent of large diameter pipes, 62 per cent of railroad wheels, and 75 per cent of automobile springs. In 2007, the OMK enterprises produced 1.8 million tonnes of pipes of various sizes and 820 thousand railroad wheels.

The main consumers of OMK products include such leading Russian and foreign companies as Gazprom, Russian Railways, Lukoil, Transneft, Surgutneftegas, Rosneft, TNK-BP, ExxonMobil, Royal Dutch/Shell, General Electric, and Samsung. OMK supplies its products to 20 countries.

In 2007, on the VSW site, OMK began a project for construction of a plate mill (mill-5000), Russia's first metallurgical facility for the manufacture of wide sheets used to produce pipes. Mill 5000 will produce wide sheets of high-strength steels (up to X-120) that are not currently manufactured in Russia.

In October 2008 OMK built the casting and rolling complex (CRC) in the Vyksa District, Nizhni Novgorod Region. The commissioning of CRC phase 1 makes it possible to provide the electric-weld pipe workshops of Vyksa Steel Works and Almetyevsk Pipe Plant with high quality hot-rolled steel coils for the production of small- and medium-diameter pipes complying with international standards.

Website: www.omk.ru



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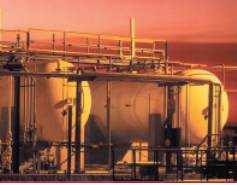
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The heating season may be over, but the mid-winter suspension of Russian gas deliveries to Europe still rankles

When, on 21 January, during the bitter European winter, it was announced that Russian gas supplies had been restored to the greater part of Eastern and Central Europe, the immediate response was gratitude. To whom, or what, was as difficult to establish as it was to positively identify the villain of the piece. Two weeks after furnaces went cold in the latest edition of a row between Moscow and Kiev over the price and shipment of fuel, probably the broadest expression of sentiment was some variant of 'a pox on both your houses.'

The judgment of the European Union – which imports about a quarter of its gas from Russia – is that the episode has damaged its relations with both countries. The president of the European Commission, Jose Manuel Barroso, said it was "utterly unacceptable that European gas consumers were held hostage to this dispute between Russia and Ukraine."

If the back story is not easy to comb out, the resolution is clear enough. When agreement was reached on the prices and methods whereby Ukraine would buy Russian gas and ship it to Europe, the suspended flow was resumed to consumers in Austria, the Czech Republic, Slovenia, Croatia, Serbia, Bosnia, Turkey, Macedonia, Hungary, Slovakia, Bulgaria, Moldova, and Greece. Short of war, how many disagreements between two neighbours can have affected so many others – and at such a remove?

The compromise reached on 20 January enabled both sides to declare victory. Russia's Gazprom, the world's largest extractor of natural gas, gained its objective of compelling Ukraine pay 'market prices' for its product, which will be linked to the European average. But Ukraine achieved a 20 per cent discount for the duration of 2009. Other terms include a one-year freeze on transit fees charged by Ukraine and the elimination of a controversial trading intermediary.

Writing in Business Week ('Lessons from the Russian Gas Dispute,' 21 January), Moscow bureau chief Jason Bush observed that the long-term impact of the dispute will go far beyond the immediate implications for relations between Russia and Ukraine. While there are similarities with a previous such contretemps, in 2006, Western energy experts emphasized that the recent dispute was more significant, both in itself and for the European energy market.

Jonathan Stern, director of gas research at the Oxford Institute for Energy Studies, told Business Week: "This has been the most serious security event in relation to gas that has ever happened in Europe. It cannot be allowed to happen again."

One of Mr Bush's respondents speculated that the dispute might galvanize the European Union into taking bolder steps toward reforming its internal energy market. "The single most effective step the EU could take would be to integrate its energy markets," said Kash Burkett, energy and utilities analyst at Datamonitor, in London. "If we had a single market, and a single consumer demanding action from Gazprom, Europe would have far more leverage over both Gazprom and Kiev."

The world's main energy forecaster sees anaemic growth, if any, in oil consumption

The International Energy Agency has said that oil demand may recover somewhat this year, although at a slow pace, as the global economy turns the corner in the second half. The adviser to industrialized nations sees consumption growing by 0.5 per cent, or 400,000 barrels a day. But in its last monthly report for 2008 the Paris-based IEA hedged even on that modest forecast.

"Clearly, if we are now heading for a prolonged and global outright recession, then the 0.5 per cent global oil demand growth we now envisage for next year may not materialize," the report, issued 11 December, read. And other energy forecasters have painted an even bleaker picture of oil markets in 2009. The US Energy Department has predicted that global consumption will probably fall by 450,000 barrels a day. If so, this would mark the first time in over three decades that demand has declined in two consecutive years.

At the New Year, the world's idle production capacity stood at its highest level in six years: nearly 5 million barrels a day.

A joint venture with Dow Chemical is scrapped by Kuwait

Just days before the scheduled 1 January startup, Kuwait's government on 28 December cancelled a \$17.4 billion joint venture with US petrochemical giant Dow Chemical after Kuwaiti lawmakers raised objections that could have led to a political crisis in the oil-rich state. In a statement carried by the state-owned Kuwait News Agency (KUNA), the Cabinet termed the venture, K-Dow Petrochemicals, 'very risky' in light of the global financial crisis and low oil prices. KUNA said the contract was cancelled by the Supreme Petroleum Council, the country's highest oil authority.

Dow (Midland, Michigan), one of the world's largest chemical companies, and Kuwait's Petrochemical Industries Co, a subsidiary of the Kuwait Petroleum Corp, had conceived the partnership as a means toward a larger share of the global chemicals market. But



Photo courtesy of Radyne

Oil & Gas News

the sharp drop in crude oil prices – from midsummer highs of nearly \$150 per barrel to under \$40 in late December – has made Kuwaitis skeptical of expensive speculative undertakings.

The project, in which Kuwait was to hold a \$7.5 billion stake, had been criticized in the country as a waste of public funds, and lawmakers threatened to challenge it in parliament if it were launched. This could have meant new trouble for the prime minister, Sheik Nasser Al Mohammed Al Sabah, who had been reappointed only recently after surviving another political crisis.

■ The cancellation of K-Dow Petrochemicals, which was to be headquartered in the Detroit area, dealt a blow to Dow Chemical, which earlier in December had announced it was cutting some 11 per cent of its work force, closing 20 plants, and selling off several businesses to reduce costs in the US financial downturn. The largest US chemicals company had depended on the deal to help it repay some \$13 billion in debt and assist in the acquisition of Philadelphia-based rival Rohm & Haas, a deal that has now fallen through with both companies headed to court over breach of agreement. In a brief statement on 28 December 28, an *'extremely disappointed'* Dow said it was evaluating its options under the provisions of the joint-venture agreement with Kuwait. The company also said. *"Dow remains committed to its Middle East strategy."*

China's ambitious CNOOC Limited is expecting a busy year

China National Offshore Oil Co Limited (CNOOC Ltd) has said it expects its crude oil and natural gas production this year to rise 16 per cent to 18 per cent over 2008. The Hong Kong-listed unit of China National Offshore Oil Corp, China's largest offshore oil and gas producer, CNOOC Ltd also said it plans to boost its capital expenditure for 2009 by 19 per cent. On its website 20 January, the company posted these budget allocations: for development, \$4.38 billion; production, \$1.12 billion; exploration, \$1.11 billion.

CNOOC Ltd estimated that its net production will reach 225 million to 231 million barrels of oil equivalent (BOE) in 2009, compared with an estimated 194 million to 196 million BOE for 2008. As reported in People's Daily (Beijing), Fu Chengyu, chairman and CEO of CNOOC Ltd, said that the company has kept up a stable pace of business despite the decline in oil prices in the second half of 2008.

If its projections materialize, CNOOC Ltd will achieve a reserve replacement ratio of over 100 per cent in 2009. Eight of the ten new company projects expected to come onstream in 2009 are offshore China. The two overseas are OML130, in Nigeria, and the Tangguh liquefied national gas (LNG) project in Indonesia.

Elsewhere in oil and gas . . .

■ According to the Wall Street Journal (20 January), experts say Israel's offensive in Gaza will *'certainly have an effect'* on that country's status as an energy corridor, without construing what that effect might be. A 158-mile Israeli pipeline runs from the Mediterranean port of Ashkelon to the Red Sea port of Eilat, and holds potential as an alternate to the Suez Canal for oil transport between former Soviet Union producers and customers in Asia. The pipeline's capacity of 400,000 barrels a day is not



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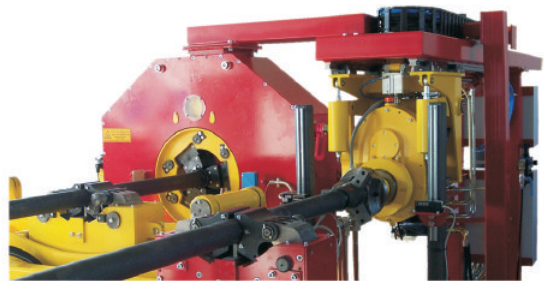


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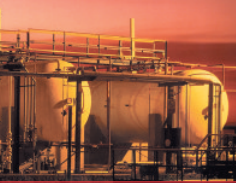
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inconsiderable, but its utility as a shipment route depends on stability in the region and the repair of strained Turkish-Israeli relations.

- President Hugo Chávez, of Venezuela, has quietly reversed course and is once again courting some of the large Western oil companies that he all but ousted from his country: nationalizing their oil fields, raiding their offices for alleged tax irregularities, and raising their royalty rates. According to energy executives and industry consultants in Venezuela, Mr Chávez, confronted by a plunge in oil prices and a decline in domestic production, has recently sent senior officials to solicit bids from companies including Royal Dutch/Shell; Total, of France; and Chevron, of the US. The inducement is, of course, access to some of the world's largest petroleum reserves.

The return of the industry giants would help Mr Chávez to shore up Petróleos de Venezuela, the state-owned oil company that contributes heavily to the national budget and to the many social welfare programs that are a strong factor in the president's popular support. For their part – given the scarcity of projects open to foreign companies in other top oil-producing nations – the Western firms may be willing to overlook the past unpleasantness and take another chance with the inconstant Mr Chávez.

- Nippon Oil Corp, subsidiary Nippon Oil Exploration Ltd, has acquired from Oil Search Ltd, of Australia, stakes in four exploration licenses for potential natural gas and oil fields in Papua New Guinea. As reported by Eric Watkins, oil diplomacy editor of Oil & Gas Journal (20 January), the Nippon unit, which will hold a 10 per cent or 20 per cent interest in each of the four licenses, envisions joint exploration with OSL over the period 2009-11, with production at some of the fields commencing as early as 2010.

The fields to be explored could help generate feedstock for a proposed liquid natural gas (LNG) facility, to be constructed near Port Moresby. The first such plant in Papua New Guinea is projected to export 6.3 million metric tons per year of LNG

starting in third-quarter 2013. According to an earlier report by OGJ Online (5 December), parent Nippon Oil and Nippon Mining Holdings Inc, faced with sluggish demand for gasoline in Japan, announced plans to merge their operations under a single holding company to be established in October 2009.

- As noted on peakoil.net, output by Petróleos Mexicanos (PEMEX), is declining at the fastest rate since World War II. The website of Swedish-based ASPO (Association for the Study of Peak Oil & Gas), reported that, as of late January, Mexico's state oil company was poised to announce its greatest drop in production since 1942. Pemex in 2008 extracted oil at a probable rate of 2.8 million barrels per day (bpd), down about 9 per cent from the 3.08 bpd pumped in 2007 and representing some \$20 billion in lost sales. For further erosion of revenue as plunging crude prices limit the cash available for exploration, costs are rising at the Cantarell field, Pemex's largest, after declining pressure reduced output over the past five years.

Mexico relies on Pemex, the world's tenth-largest oil company, for 40 per cent of its budget. The falling-off in output also threatens the supply of Pemex oil to the US, which gets more oil from Mexico than from any other country except Canada and Saudi Arabia.

- Norwegian communities and conservationists on 17 January launched a campaign to ban oil exploration and development from parts of their Arctic coast, linking up with coordinated environmental campaigns underway in Alaska and Russia. As reported by the Swiss-based WWF (World Wide Fund For Nature), the petitioners in Norway have called upon the government to protect the Lofoten and Vesteralen areas in that country. In Alaska, WWF is part of a coalition of local people and organizations opposing oil and gas exploration and development in Bristol Bay, where drilling would bring in an estimated \$7.7 billion over the 25- to 40-years' estimated life of the petroleum reserves. Working with a similar coalition in Russia, WWF is urging Moscow to suspend oil exploration and development on the west Kamchatka shelf until the most important specially protected natural areas (SPNA's) have been designated.

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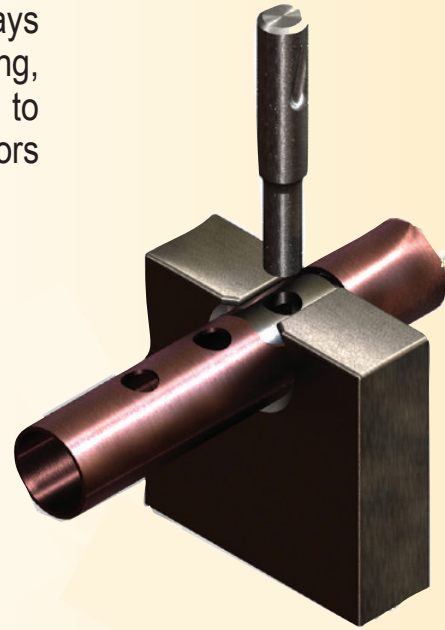
Drilling, Piercing & Punching Technology

Coverage of these areas of expertise always centres on precision: in measurement, spacing, alignment, and follow-through. It can be instructive to consider the immense number and variety of factors that go into ensuring this zero-tolerance precision.

The website of one manufacturer of tube punching machinery showcases punching tools for presses, hydraulic tube punching tools, and custom-built tube punching machines.

The units are adaptable to press brakes and power presses; or, in the hydraulic version, fitted with an integral cylinder. They can be arranged in straight lines on presses and custom-built machines; or set up to punch pre-formed tube components.

Since the necessity of punching without deformation is paramount, the equipment supplier must allow for machining by both mandrel die and stump mandrel, to ensure the integrity of the tube's inside diameter. The countersink effect must be anticipated and the remedy applied.



Carson is the manufacturer of a range of hole punching equipment, with technology based on mandrel punching (see page 84)

SMS Engineering Srl has launched a new automatic punching system that can produce round or square holes with or without deformation (see page 82)



Punching and notching must dovetail smoothly with the tube bending operation. Round tubes, square tubes, rectangular tubes, box sections – all present their individual challenge to the machine that must deliver a precision punch, every time.

A very small error in drilling, piercing, and punching will have very large consequences. The products and services reviewed here have been developed to eliminate any such concern.



Automatic punching systems for tube and profiles

BS Sas, Italy, is the manufacturer of punching systems for automatic punching of tube and profiles. In order to provide flexible and highly productive machinery and working systems, the company offers a comprehensive range of solutions for tube and profile punching processes.

The BS range of products is composed of a standard machine and other custom made solutions. The BS P80 automatic punching machine is designed for different working process options, and is easy to setup and use with high productivity.

Suitable for processing tubes with diameters of 25-80mm and 16t capacity, the BS P80 is characterized by its high flexibility, allowing punching of tubes with different sections (round, square and rectangular) and different profiles. It is the right solution for manufacturers of shelves, metal fences, safety railings, stainless steel railings and suitable for manufacturers of safety doors, as well as doors and windows in general.

The machine is extremely easy to use due to a touchscreen control system (PLC) that allows the modification of processing

parameters such as punch stroke, pliers positioning speed, processing speed, number of punching processes, distance between holes and the length of the tube to be processed.

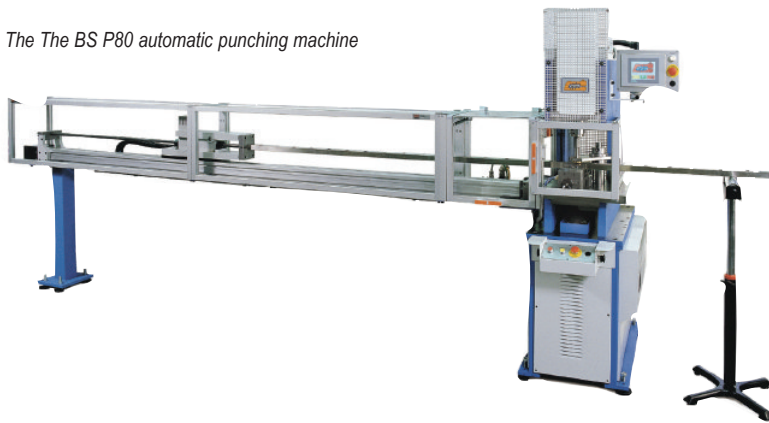
Furthermore it is possible to formulate, save and recall the most used processing programmes. The systems also assure maximum reliability due to the related service offered. Users of the machines can ask, at any time, for assistance via a remote customer care system.

BS punching systems are also available as tailor made machines for punching tubes with particular sections in order to maximize productivity. The aim is a working system that offers maximum productivity and automation and is suitable to process steel tubes.

It is possible to punch on three sides at the same time for the entire tube length. The machines can be provided with an automatic tube load/unload system and with automatic scrap evacuation.

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Fax: +39 0331 216107
Email: marketing@bssistemi.it
Website: www.bssistemi.it

⏴ The BS P80 automatic punching machine



Advanced solutions for tube piercing, punching and slotting

Multicyl Inc, Canada, is a manufacturer of complete systems for piercing, punching and slotting for use in applications including automotive stamping, metal fabricating and tube fabricating.

These mandrel punching solutions can accommodate a range of requirements

including any number of punched holes, one hole size or multiple hole sizes, one or two sides, clean or dimpled, and shaped or round. The equipment has a custom mandrel that is wire cut to match the complicated internal design of the extrusion to ensure accurate hole location.

For tube notching, the company offers standard units from its complete line of tube and pipe notching solutions. Multicyl systems allow for one side per cycle, or both sides per cycle. The company can provide tooling for like-to-like notching, notching for different diameter pipe, standard 90° notching, or custom angles.

Multicyl also provide custom pipe piercing, such as double mandrel punching stations, and complete automated tube punching machines.

The tube slotting technology from Multicyl enables punching

of a 1" slot in an 8" tube. A cantilever tooling design allows for a single station to operate with a variety of tube sizes with no tool changeover of setup time. In addition, the cycle time is fast and up to 40t of force is available. A field proven machine, it is safe and OSHA approved due to no pinch point.

At last year's Fabtech, the company introduced the MultiPunch linear rail (MLR) system. This is the ideal machine for punching applications that involve a variety of parts and multiple setups.

MLR systems are available in standard rail lengths from 2ft to 10ft. Standard 7.5t and 12.5t Multicyl punching stations are used and the simple building block concept allows users to add or remove stations as required.

The most important feature of MLR is punching versatility; different part lengths, hole sizes, hole positions, end stop positions, and even part profiles, can all be punched on a single MLR machine.

Multicyl Inc – Canada
Fax: +1 905 951 0672
Email: punch@multicyl.com
Website: www.multicyl.com

⏴ The MultiPunch linear rail (MLR) system from Multicyl





New automatic punching machine type PSA-50

SMS Engineering, Italy, has launched a new automatic punching machine, branded PSA-50. This simple machine is suitable for punching steel, stainless steel and aluminium tube and bars with round, square or rectangular section.

deformation. It is designed for shelving, radiators, ladders, bed frames and similar products. Punching can be undertaken on one side, two opposite sides or alternate opposite sides (pitch is variable).

The PSA-50 can produce round and square holes, with or without

The machine is capable of punching one or more holes every time. The main

features of this machine are pitches precision, straightness of the worked bars and fast tooling change. The operator is just required to load the piece into the machine at the right position and push the start buttons. When all operations are over, the operator has to unload the finished tube and reload the machine.

The machine is constructed from a heavy electro welded steel frame, a trolley equipped with special clamping gripper, special punching units, controlled axis to manage all tube movements, a hydraulic power pack, and an electrical cabinet supplied with control push panel and electrical installation on board.

The main technical features are a maximum tube size of 80mm, a standard length of 3m (options for 4/5/6mt), and a punching power of 3/6/10 ton.

There is also a maximum bar feeding speed of 40mt/1', a position accuracy of 0.1mm/mt, a gripper rotation of 90° for round tube, pitches and lengths settings directly from a panel board, and an optional controlled gripper rotation and automatic loader.

 The new PSA-50 punching machine from SMS Engineering



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Website: www.sms-italy.it

Drilling and punching of aluminium sections

High volume aluminium profiles, such as those used in the manufacture of luxury travel coaches, can be efficiently produced with a combined machine for drilling, milling and punching. Friedrich Petig, Germany, manufacture a range of tube punching

machines that utilise the through-punching method, and also combine drilling and milling.

Petig's machines work to punch heating holes in the profiles, with boring of sunken holes and milling of slots. The completed profiles are then matched together with assembly of the heating and air conditioning channels.

environmentally friendly emulsion thereby extending tool life.

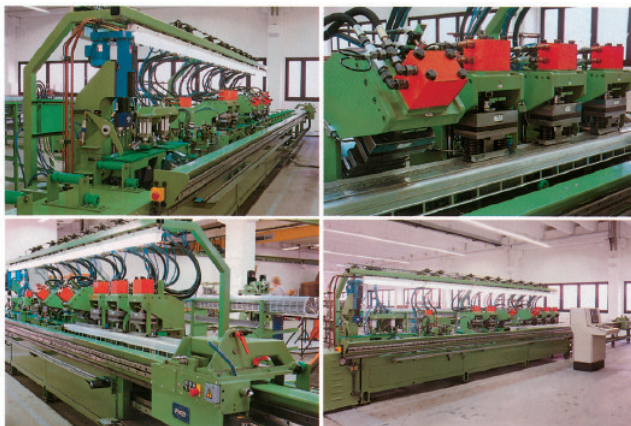
Both drilling units are fitted with a multi-spindle boring head and work with both fast and operational speeds. The high speed milling head is fitted with a hard metal tipped disc cutter.

A conveyor belt is fed by a chute to dispose of the punched cut outs and bored and milled swarf. The aluminium profiles are clamped on the head side by a collet fixing carried on the feed measuring carriage and timed from a CNC-linear feed.

As the profiles are partly anodized – and must remain entirely free of scratches – felt edged lowering rollers are fitted between the punching units. A Siemens 810T system controls the operation and storage programs for running and storage.

Friedrich Petig GmbH – Germany
Fax: +49 218 173 108
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 Friedrich Petig supply the technology for drilling, milling and punching



The hydraulic impact punch unit allows differing punching pressures between 200-315kN. Column mounted tools enable punching of non uniform shapes. At predetermined and adjustable distances, the stamped holes are sprayed with an

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Another feature of our machines is the "follow-on" jaw closing system, which mechanically ensures all 4 jaws move at the same time and permits achieving any square end size with just one type of jaw.

The Siemens operator panel, which is connected to the PLC by a loop, allows to set and control all the functions and the parameters of the machine (cycles selection, jaws opening/closing measures and speed ratio, automatic lubrication adjustment, strokes counter, recipes management, etc.)

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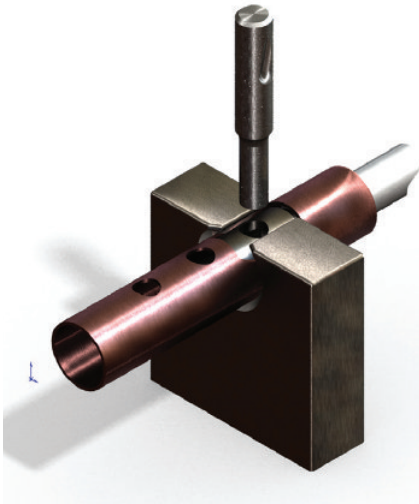


Expertise in tube punching and drilling technology

When faced with the task of producing a pattern of holes in tubing, there are many different options to consider. There are mandrel punched holes, mandrel-less punched holes, drilled holes, milled holes, pulled (or collared) holes, and others. For most applications, the best options are mandrel punched holes or drilled holes.

Mandrel punching is generally favoured over any other because it is clean, accurate, and fast. This process utilizes an internal die or mandrel, an external punch, and a tube support. When tooled properly, a mandrel punched hole is burr-

⚡ *Mandrel punching is generally favoured because it is clean, accurate, and fast*



free and creates very little distortion to the tube's original shape. As an added bonus, the waste that is produced is a slug that is easily evacuated from the point of operation and gathered for recycling.

Another advantage of the mandrel punching process is that it allows for the punching of different shapes. This ability is essential to many applications. The preferred method for producing a pattern of holes with this process is to index the tube over a fixed mandrel.

This method allows for a very accurate punch to mandrel alignment, which is essential for maintaining the quality of the punched hole.

There are situations where a mandrel punched hole is not an option. These include cases where it is impossible to insert a mandrel due to a feature of the tube and, more commonly, the case where the hole size is too near the inside size of the tube. In this case, a mandrel would be too fragile for practical use and would not allow the necessary clearance needed for slug evacuation.

When these situations arise, a drilled hole is a very good option. The main drawbacks normally associated with drilling are burrs around the hole, chips, and a reduced rate of production compared to punching. There is also the fact that a drill can produce round holes only.

With proper tooling, many of the previously mentioned problems can be eliminated or at least minimized. There are several bit profiles available that greatly reduce burrs and speed the drilling cycle. Added to this is tooling designed to stabilize and guide the bit during the drilling cycle, which leads to higher accuracy. As with the punching process, it is advantageous to index the tube under the fixed position of the drill.

Both manual and automatic equipment are produced for making accurate linear and radial indexes. Manual style punch machines rely on an operator to make the different stops at each pattern location and to cycle the punch at each stop.

A manual machine is relatively inexpensive and can be customized for a wide variety of tube materials, shapes, and sizes. Automatic machinery that is built for this process relies on a servo based positioning system that is driven by a part program to make the intended pattern stops and to cycle the punch at each stop.

While an automatic machine of this type is more expensive, it makes up for the added cost with increases in speed, accuracy, and efficiency. An automatic machine is also better suited to producing complicated patterns that contain many linear and radial locations.

Machinery for either process should be simple to set up and provide a fast, accurate method for getting from one hole to the next. A hole making machine must be rigid and provide nearly perfect, repeatable alignment between the tool and the hole – especially when mandrel punching.

The choice for machinery and tooling, and ultimately the hole making process, can be a difficult one. Punching and drilling are virtuous because they are simple processes and offer a very low cost per hole. There are limitations to each, but with a good part design that is based on the processing method, most limitations can be overcome.

Carson is the manufacturer of a line of hole punching equipment for the production of header tubes. These machines come in two basic versions, manually operated and semi-automatic. The company also offers a range of equipment for bending, end forming, end closing and other special machines.

Special robot loading device for punching lines

Apollo, Italy, has introduced a robotic loading device that works in unison with the company's Twin punching lines. The robot device can load and unload workpieces from dedicated containers to the machine and back again. This robot considerably lowers working time and labour.

The robot can simultaneously load two punching lines or take the cut material from a sawing machine coupled with an Apollo punching machine. The time for loading and unloading is approximately 6 seconds.

The punching line features remain the same, as the coupling with the robot does not involve any technical change. Apollo can provide customized solutions in order to transform all of its punching lines into fully automatic machines. Alternatively, the company can provide the robot coupled with the new punching machines.

Apollo may also be able to supply overhauled robots of the KUKA and ABB brands.

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Advanced industrial pipe drill with five axes

EH Wachs, a leader in portable cold pipe cutting and weld prep machine tools, has launched an advanced industrial drill, branded the Wachs multi-axial PowerDrill.

Designed for drilling, boring, and tapping pipes of virtually any diameter, it has extraordinary travel in five axes for incredible flexibility.

⚙️ *A highly versatile industrial drill, the Wachs PowerDrill is able to articulate in five axes*



The PowerDrill comes with either a pneumatic or hydraulic drive. Powerful enough to drill a 127mm diameter hole in high yield pipe, it features high-torque gearing, long feed travel and the ability to safely operate in many environments, including explosive and subsea.

With its rugged construction and comprehensive features and options, the multi-axial PowerDrill is a very powerful and versatile portable drilling tool. Ideal applications include tapped or beveled access holes, stud removal, gamma plugs, RT plugs, and Thermowell installation. It can also be used to add weld prep details into piping.

A PowerDrill was recently used by Jordan Nuclear to assist on the B268 MA1 Cell Refurbishment Project in Cumbria, UK. Mounted around a 1.4m and 1.7m separation vessel, access holes were drilled to monitor radiation levels within the 12mm thick stainless steel vessels.

A Wachs Trav-L-Cutter was used for cutting, as were the company's LCSF

(low clearance split frame) cutters. These powerful yet portable Wachs machine tools helped Jordan control and manage dose uptake and airborne contamination.

Wachs is best known for its famous Trav-L-Cutter, which drives itself around the OD of a pipe, cutting and beveling simultaneously while adjusting automatically for out of roundness. The company also manufactures the Wachs split frames for a lathe type finish and precision weld prep. It can machine all common sizes, wall thicknesses and materials including cast, ductile iron, stainless steel and high yield alloys.

Split frames are available in SDSF (small diameter split frame), LCSF (low clearance split frames) and the massive HDSF (heavy duty split frame). The equipment is designed for the power generation industry, pipelines, oil platforms, petrochemical plants, refineries, shipyards, pharmaceutical labs and food and beverage processing plants.

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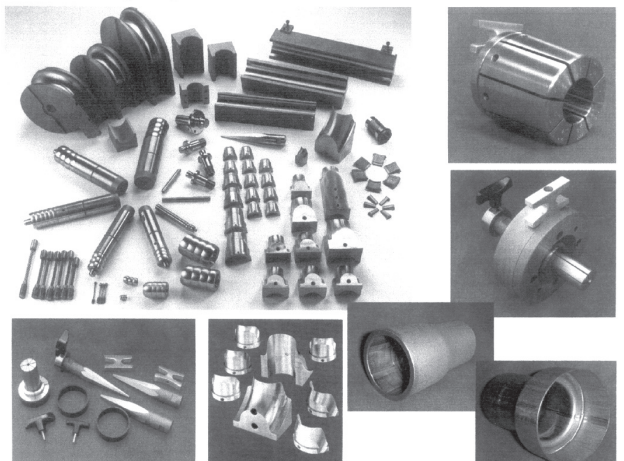
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From the AMERICAS

The US economy

Analysts try calculating the odds: Depression? Recovery? Or a period of anaemic growth?

Shortly before the inauguration of US President Barack Obama on 20 January, economic reporter Robert Gavin of the Boston Globe recalled a grim episode from the past: *"The speed of the economy's deterioration has stunned economists and led to comparisons with the Great Depression, when a financial panic dried up credit, destroyed confidence, and led to sharp declines in consumer and business spending."*

To stem the slide this time, Mr Obama has proposed enormous government outlays for tax cuts, state aid, and public works projects, in a massive stimulus package to be taken up in Congress in the new term. In the view of economists and analysts consulted by Mr Gavin, on its success or failure may depend whether the nation finds a path to recovery or spirals into a depression that could last years (*'Critical choices ahead,'* 11 January).

Christian Weller, public policy professor at the University of Massachusetts (Boston), told the Globe, *"A big stimulus has the potential to be a game changer."*

The bright scenario was sketched by Mark Zandi, chief economist at Moody's Economy.com: A quick passage of a stimulus package of \$800 billion or more; tax cuts for lower-income families; benefits extended or even increased for the unemployed, who are also likely to spend the money quickly.

What might follow on the initial lift provided by this spending was outlined by Mr Gavin: *"Hundreds of billions of dollars goes to states to avoid deep budget cuts and layoffs, and pay for public works projects that create jobs, putting a floor under the eroding labour market. Big, bold, and decisive action by the new president and Congress gives confidence to consumers and businesses that worst will soon be over."*

On this model, an economic rebound begins to take shape by the second half of the year. In expectation of a recovery in consumer spending, businesses take advantage of low interest rates to buy equipment and expand plants. Workers are retained, and more are hired. Unemployment, peaking just short of 8 per cent, starts back down.

But most of the analysts consulted by the Globe were cautious about entertaining such high hopes for the Obama initiative. Their view, as summarized by Mr Gavin, is that the stimulus package will merely keep the US economy *'in the game'*. Massive government spending will help stem the rapid deterioration; but any economic growth in the second half will not amount to much.

Allen Sinai, chief economist at Decision Economics, a Boston financial market advisory firm, was among the skeptics. He estimated the chances of a depression at 15 to 20 per cent. Not, he commented, *'a trivial possibility'*.

'A dark scenario'

During the campaign leading up to his election, Mr Obama was credited by one commentator with having a first-class temperament

as well as a first-class mind. He will need both if his economic stimulus plan is to succeed.

In the view of some economists interviewed by the Globe, failure would begin with a dickering, delaying Congress that delivers a smaller package filled with special-interest sweeteners. Their confidence shaken anew, consumers cut spending, thus hurting corporate profits and leading to more layoffs and even tighter purse-strings. The housing market plunges still further, leading to more foreclosures and undermining the already weakened financial and credit markets. Banks stop lending.

It is probably unnecessary to go further, but Mr Gavin of the Globe does. Businesses slash prices to attract buyers, who hold out for better bargains. Inventories build up; businesses cut production; more workers lose their jobs. Consumers cut spending yet again, and the cycle repeats. The downturn deepens for two more years. Employers cut 3 million jobs this year, and millions more in 2010. Unemployment hits double digits; 12, 13, 14 per cent. Nearly 20 million Americans are out of work, compared with about 11 million when Mr Obama took office.

The analysts said such a long, deep, and sustained downturn would qualify as a depression. Mr Zandi, the Moody's economist who looked first at the bright side, concurs. It is, he said, *'not hard to get to a dark scenario'*.

And yet . . .

The US has bidden goodbye to a man who is already being called the worst president in the history of the republic. In its first post-election issue, the Onion, a satirical newspaper whose coverage of fictitious events has often tripped up the mainline media, played it straight. The headline read, *'Black man given nation's worst job'*. The new president, said the Chicago-based editors, will have *"to spend four to eight years cleaning up the messes other people left behind"*.

On 18 January, New York Times op-ed columnist Frank Rich acknowledged the extent of these messes: *"enormous, bigger than Washington, bigger than race, bigger than anything most of us have ever seen"*. But cautious hope could be detected in his last piece before the inauguration of Barack Obama as the 44th president of the United States. Mr Rich wrote, some ten weeks after Election Day, *"It remains astonishing that the American people have entrusted the job to a young black man who seemed to come out of nowhere looking for that kind of work just as we most needed him."*

Automotive

The thorny issue of dealerships that decline to go quietly pits producers against their own retailers

Reporting from the North American International Auto Show on opening weekend, business writer Katie Merx of the Detroit Free Press directed her attention first to a particular set of exhibitors: the car dealers at the huge (800,000 attendees) two-week event. The dealers, she wrote, are *"at the centre of the toughest, most political – and potentially litigious – battle that Detroit's auto*



makers face in restructuring their businesses in return for billions of dollars in federal loans" (*'Urgent need to shed dealers hampered,'* 10 January).

It is the judgment of the automakers that, as new car and truck sales fall to their lowest levels in decades, fewer dealerships are needed. Industry experts concur. The dealers, understandably, want to keep their businesses. For dealers and producers to be at loggerheads is not remarkable. But positions harden quickly in the cauldron that is the US auto industry right now, and Ms Merx believes that the dealer-producer standoff holds potential for becoming one of the most complicated problems facing the industry.

In addition to their own *'gritty will'*, Ms Merx wrote on Freep.com, the dealers are fortified by state laws and individual franchise contracts that have made it difficult for the automakers to shed dealerships quickly or affordably. One of her respondents, Sheldon Sandler, founder of Bel-Air Partners (Skillman, New Jersey), a dealership brokerage, said, *"It's one thing to shrink your own business, but telling an independent business owner to close up is a whole other story. This is a real conundrum and is probably as difficult a problem as negotiating [with a union], if not more so."*

Meanwhile, under the restructuring plans presented to the federal government, the US automakers have pledged to speed up the process of shrinking their retail outlets. Neither Chrysler LLC (with 3,300 dealerships) nor Ford Motor Co (with 3,790) has disclosed a target for reductions. But General Motors Corp told Congress that it aims to reduce its dealer count by 26 per cent, from 6,375 at the end of 2008 to 4,700 by 2012.

Even if GM were to succeed in cutting its dealer body to 4,700, that might not be enough. Ms Merx wrote, *"Without shrinking the rest of the business, experts said, GM's sales per dealership would remain much lower than those of [their Japanese] competitors Toyota Motor Corp and Honda Motor Company."*

The prescriptions for shrinkage vary widely. To be competitive, one analyst said, GM should reduce its dealer count to closer to 2,000. Other experts told the Free Press that Detroit's automakers need to reduce their stores nationwide by up to 20 per cent.

On the subject of shrinkage, a New York-based automotive consultant shared an opinion with the Globe and Mail (Toronto). John Casesa, managing partner of Casesa Shapiro Partners, told the Globe's Greg Keenan (12 January), *"These [auto] companies are size 38's in size 44 suits. They have too many plants and dealers."*

➤ Assuming that the automakers must jettison dealerships or else forfeit the help from Washington, what are industry observers saying? Given the complexities of shaking off dealerships, several experts told the Free Press that it might not be possible to achieve the scope of closures and consolidations the automakers are seeking without bankruptcy or government-facilitated bankruptcy-like proceedings. These would presumably permit the automakers to void franchise contracts to achieve their aims; but at what political cost to the nascent administration of President Barack Obama?

And the question suggests itself, would the results justify such strenuous efforts? Mark Johnson, an automotive merger consultant

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in Seattle, Washington, pointed out the likely exorbitant price of getting dealerships to close. When GM announced in 2000 that it would give up its Oldsmobile brand, it took four years and \$1 billion to shutter 2,800 dealerships: largely, noted Ms Merx, "because so many dealerships sued to protect their contracts".

Elsewhere at GM . . .

➤ Also from the Detroit Free Press (10 January), the Brazilian chief of General Motors has said that the company's Latin American units have no need of government aid and would not be availing themselves of any loans that the parent company receives from Washington. Jaime Ardila, president of GM of Brazil, said 9 January in a Bloomberg News television interview, "The loans from the US government are to resolve problems that GM has in the US – not to help Brazil operations, which don't need help."

➤ General Motors Corp has filed a lawsuit against a bankrupt automotive supplier for immediate access to specialized parts and equipment, arguing that a delay would hamper the introduction of its new Chevrolet Camaro, disrupt assembly operations, and cause millions of dollars in damages. The 24 December filing, with the United States Bankruptcy Court in Delaware, said Cadence Innovation (Troy, Michigan) was 'holding hostage' parts and equipment needed by GM, and breaching the terms of a signed agreement between the two companies. A bankruptcy filing by Cadence in August became a liquidation proceeding in December.

Two of Detroit's 'big three' have already won important help from Washington, conditioned on creditworthiness

General Motors was close to running out of cash enough to stay in business before federal loans – in the vernacular, the 'bailout' – were approved by then-President George W Bush in December. In mid-January, just a week before Mr Bush left office, the company was striving to complete reorganization plans tied to the loans.

With GM's \$13.4 billion federal aid package sufficient to keep the company solvent only until the end of March, at the New Year the automaker was revolving its latest plan for cutting labour costs, restructuring debt, and reducing its complement of dealers and brands. In Detroit on 12 January, at the 2009 North American International Auto Show, GM chairman Rick Wagoner told reporters, "Those are the major pieces and they all have to add up to a business plan that meets the so-called financial viability test."

Along with Chrysler, which received a \$4 billion loan, GM was required to submit its overhaul plans to the government by 17 February. By then, Mr Obama was expected to have appointed a 'car czar' to evaluate their plans. The companies would then have until 31 March to show progress in executing the plans, or risk having the loans recalled.

Mr Wagoner said at the auto show that GM had yet to decide whether it would seek further help after that. "By 31 March, we'll be able to address whether additional funding may be forthcoming or

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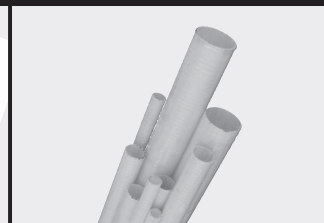
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not," he said. "We really haven't said whether we will or we won't need money after that period."

Ford Motor Co is in better shape than GM and Chrysler and did not need an emergency infusion of federal cash. But the second-largest US automaker, after GM, has asked for a multibillion-dollar backstop in the event that North American auto sales continue to collapse.

Steel

Light order books mean production curtailments at steel plants across the US

Economy measures announced by steel makers include the following:

➤ Severstal North America Inc said 8 January that it would continue the temporary 'rolling' layoffs, begun in December, that affect operations in Wheeling, West Virginia; Warren, Ohio; Sparrows Point, Maryland; and Dearborn, Michigan. The company is a subsidiary of Russia's OAO Severstal, which completed its acquisition of the former Wheeling-Pittsburgh Steel from Esmark Inc last summer, pledging a \$250 million capital investment in US operations including the strip mill at Wheeling.

➤ AK Steel Corp (West Chester, Ohio), which employs 6,000 company-wide, is laying off an undisclosed number of workers at all plants and offices. Its network of mills includes the Middletown Works and smaller plants in Mansfield, Coshocton, and Zanesville – all in Ohio; Butler, Pennsylvania; and Ashland, in Kentucky.

AK Steel in November halted production and shipping at Mansfield, and blast furnace, steel making, casting, and coating operations at Ashland. Most of the suspended workers had not been called back by early January. The company said in December that it would impose a 5 per cent pay cut on salaried workers including its CEO and other top executives. (Pittsburgh Business Times, 9 January).

➤ Roughly 1,600 workers have been laid off at US Steel's Granite City Works plant, in southern Illinois. The plant, which makes hot rolled and coated sheet steel products, is one of five integrated facilities that the Pittsburgh steel giant operates in the United States. It has annual raw steel making capability of 2.6 million tons.

Russ Saltgaver, president of the United Steelworkers local at Granite City, told the Alton (Illinois) Telegraph on 10 January that within days the plant, which had not been idled in its 130-year history, would be run by a ghost crew of about 60 people. Relating the plant's troubles to those of customers in the tube and pipe industry, the union representative said, "We need the price of gas to increase so the oil companies will start putting in more pipelines and doing exploratory drilling."

Of related interest . . .

➤ US Steel Corp, on 7 January, said it had reduced production at its plant in the eastern Slovakian town of Kosice following a halt imposed on gas deliveries from Russia via Ukraine. It was not disclosed how much production was cut at US Steel Kosice, which is rated to produce 4.5 million metric tons of pig iron a year. A company spokesman said, "[We] have adjusted our production in line with the restrictions" imposed by the Slovakian government.

A brighter outlook for steel in the second half?

As President Barack Obama works out the details of his plan for stimulating the weakest US economy in living memory, early indications are that the greater part of the government outlay will be in the form of spending on infrastructure – mass transit systems, bridges, electric power grids – rather than tax breaks. If so, steel companies would be substantially better positioned to benefit than their counterparts in the domestic automobile industry.

Despite the drum-beat of bad news from the steel industry ('Production curtailments,' see above), there are encouraging signs here and there. The Wall Street Journal, in a recent article, cited movement by steel producers around the world toward the selective opening of mills as signaling revitalization. Neil Malkin, an analyst-blogger for Zack's Investment Research, endorses the WSJ view and foresees upward momentum in iron ore and steel prices as early as the second half of this year. ('Signs steel may have bottomed,' 7 January).

If these expectations seem rosier than warranted by the stirrings of a few steelmakers, a more compelling rescue model is suggested by the Reuters headline 'Steel companies may gain if buyers restock inventories'. Stockists, having depleted their inventories to supply construction customers, will likely increase their orders for new steel as their own supplies shrink.

Bob Richard, an analyst with the equity research firm Longbow Research (Independence, Ohio), told Reuters (7 January), "I think a more timely catalyst is not necessarily the stimulus package. Service centres have pared down their inventories to an unprecedented level."

➤ This is not to say that steel producers will not be trying their luck in Washington. They will. To help revive steel demand, the US industry is pressing the Obama administration on public works plans that would reach \$1 trillion over two years. And at least some of the pressure will be couched in terms reminiscent of the George W Bush era.

Daniel DiMicco, chairman and chief executive of Nucor, the largest steel mini-mill operator in the country, told the New York Times that the steel industry in the US was asking the incoming administration to "deal with the worst economic slowdown in our lifetime through a recovery program that has in every provision a 'Buy American' clause."

➤ If the optimists are right, and steel picks up in second-half of 2009, the coal mining industry in the depressed Appalachian region of the US stands to benefit. With metallurgical coal a vital element in the making of steel, any increase in steel demand should push coal prices higher.

Oil and gas

Plunging oil prices derail a Venezuelan philanthropy in the United States

As Venezuela's oil income falls, President Hugo Chávez has ended a three-year-old program under which his country provided heating oil to low-income Americans. Citgo Petroleum, the US refining unit of the state oil company Petróleos de Venezuela SA (PDVSA),



suspended deliveries of the oil 'until further notice', Joseph P Kennedy II, president of Citizens Energy Corp (Boston), said on his company's website (5 January). Mr Kennedy is associated with a number of ecology-based and humanitarian initiatives.

Citizens Energy handled logistics for the Citgo program, credited with serving 180,000 households, 250 emergency shelters, and 37 Native American tribes over the winter of 2006-2007. The program was expanded in the winter of 2007-2008 when the price of heating oil in the US rose above \$3 a gallon.

As reported by Steven Bodzin, of Bloomberg News, Mr Chávez on 31 December reduced foreign currency allotments as a first step toward countering the effects of the decline in Venezuela's oil price, which plunged 75 per cent since reaching a record in July 2008.

Aviation

➤ Boeing Co (Chicago) said on 8 January that it delivered 375 airplanes in 2008: about 15 per cent fewer than the 441 delivered in 2007. The world's second-largest plane maker after Europe's Airbus blamed a two-month strike and other production hold-ups for delays in delivery of new jetliners. The strike by 27,000 unionized workers forced Boeing to shut its commercial aircraft plants from early September to early November, at an estimated cost to the company of \$100 million a day.

Planes put on hold included the Boeing 787 Dreamliner, designed with carbon composite parts for fuel efficiency but now two years behind schedule. One customer, Singapore Airlines, was reported to be leasing 19 A330's from Airbus as the Dreamliners it has on order will not arrive until 2011 at the earliest. Virgin Atlantic Airways expects a first installment of 15 787's in 2013 – again, at the earliest – and is also believed to be mulling the Airbus A330.

Boeing on 9 January announced it was shedding 4,500 workers from its commercial plane operations, or about 7 per cent of the unit complement, to trim costs. Most of the dismissals were said to be in 'overhead functions' not directly associated with manufacture. The jobs will mainly be cut from Boeing plants in the Seattle area, between April and June.

➤ In the first airline trial of algae as fuel, Continental Airlines on 7 January tested a mixture of algae and jatropha, a tropical shrub with an oil-bearing seed, in a two-hour flight of a Boeing 737 jetliner. The International Air Transport Association has set a goal of 10 per cent alternative fuels by 2017.

➤ New rules mandated by the US Congress require people travelling by air to the US under the visa waiver program to register online in advance. The mandatory rules (as of 12 January) cover the citizens of 35 countries who do not require a visa to enter the US. Travelers are now being asked to fill out the forms at least 72 hours in advance of travel.

Dorothy Fabian, Features Editor (USA)



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➤ Strothmann GmbH has pioneered a new handling concept called RoundTrack, designed for the movement of large diameter steel pipe (see page 98)

➤ Mink-Brushes provides delicate handling technology for small tubes (see page 102)



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Stierli Bieger system are the improvement in utilisation of floor space, tidy and compact storage within the factory, and fast and safe material handling.

In addition, downtimes of production machinery can be minimised, and safe working practices within the customer's company can be considerably improved. By using this system, the company claim to avoid the usual risks associated with the stacking and storage of stock materials.

The number of arms, width clearance, single or double construction can be individually selected. The arms can be removed easily and safely by hand. The synchronized system developed by Stierli Bieger guarantees parallel running of the arms with a loading capacity of up to 1,500kg/arm. The arms are equipped with maintenance free grooved ball bearings. Additional sheet metal channels or wood supports can prevent damage.

Stierli Bieger is the manufacturer of roll-out racks, devices for welding and dressing, and horizontal bending machines.

Stierli Bieger AG – Switzerland
Fax: +41 41 920 24 55
Website: www.stierli-bieger.com

Hex bundling system for swift packing requirements

A new hex bundling system, from Automated Solutions Inc, will soon be in production at a major US tube and pipe supplier. The system will end align tubes, build layers of tubes and stack the layers into hex bundles. It automatically straps bundles and accumulates finished bundles on a conveyor for either crane or fork truck removal.

The system will process 2" to 6" diameter tubes (2 3/8" to 6 5/8" OD), wall thicknesses of 0.109" minimum to 0.280" maximum, and lengths from 16-44ft. Dual strappers optimize cycle times, especially when operating in dual stacking mode where two shorter hex bundles (ie 16ft lengths) are stacked and processed simultaneously.

 The hex bundling system from Automated Solutions



The operator can select tube diameter, tube length, and bundle configurations from a touchscreen HMI, with size changeover being fully automatic.

Servomotors are used for their smoothness, reliability, clean appearance, and flexibility for both the horizontal carriage travel and the vertical axis travel of the stacking gantry.

Automated Solutions Inc is a global supplier of custom automated equipment, specializing in tube and pipe handling and processing equipment. All mechanical and electrical design, fabrication, assembly, and testing is accomplished at ASI's 100,000ft² facility located in Knoxville, Arkansas, USA.

Tube and pipe equipment includes automated tape bundling, end finishing, hex bundling, cap and coupling systems, specialized conveyors, and accumulation devices. Standard machines include designs for processing 1/4" diameter to 6" diameter tubes and lengths up to 80'. Layouts and system configurations are flexible to suit customer needs.

Bar code applicators, weighing systems and other peripherals can be added to compliment systems. Installation and start-up assistance is always available from Automated Solutions.

Automated Solutions Inc – USA
Fax: +1 479 885 2085
Email: sales@automatedsolutions.biz
Website: www.asideas.com

Equipment range features coilers and packaging equipment

Sema Systemtechnik, Germany, is the manufacturer of a comprehensive machinery range including packaging equipment and coilers.

The company works in close cooperation with Prestar, Czech Republic, with machines and lines manufactured and delivered to the eastern European market.

 Sema and Prestar supply a combined range of equipment – such as the 10-roll tube straightener – complete with handling and packaging solutions



Sema sells the tube grinding machines and pipe finishing lines manufactured by Prestar in western Europe.

Sema's tube and wire coilers are supplied with a feeding, cleaning, and horizontal/vertical straightening device. Designed for a coil layer width of 600mm and coil diameter of 1,600mm, the coilers incorporate a

testing device, marking, drying unit, pre-bender and coiling unit.

The company also supplies packaging lines for round, hexagonal and square bundles for tube and bars. A range of finishing lines is also available, with roller and belt transports and lifting stations.

A highlight of the Sema range are the 6- and 10-roller-straighteners for a tube diameter from 3-200mm. The company also supplies separating systems for tubes and bars (straightened or unstraightened). Other equipment includes testing lines with infeed, panel cutter with two or more saws, cross transport systems and collecting troughs, and chamfering and end-processing units for tube and bars with lengths from 1-18m.

In 2009 Sema will widen its delivery programme to include a pointer for drawing tags, a 9-roller-straightener for tubes and bars, single and multi drawing benches for tubes, and 2-roller-straightening machines for bars/shafts.

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Website: www.sema-systemtechnik.de

Prestar sro – Czech Republic
Fax: +420 533 7597 21
Email: f.horak@prestar.cz
Website: www.prestar.cz

Effective clamping devices for accurate fit-up

The Sumner® Ultra Clamp is a fast and accurate fit-up clamp that can be used for pipe-to-pipe, pipe-to-fitting, and pipe-to-flange. Three model sizes accommodate pipes from 1" to 12" in diameter.

 The Sumner® Ultra Clamp



The clamps are very lightweight and have a rugged and durable frame, while stainless steel alignment screws at all contact points hold fittings in place and allow for fine adjustment.

Smooth roller clamping action enables positive gripping and the operating handle repositions for close work. Fit-up settings can be maintained for repeat fit-ups.

The company also supplies the Fold-A-Jack, which is a handy folding jack

for professional welders and contractors. The Fold-A-Jack has up to a 2,500lb (900kg) capacity and features folding legs made from 1" square tubing and an adjustment screw made from heavy wall tubing.

In the folded position, the legs are much less susceptible to damage and occupy only one third of the space taken up by a non-folding jack. The new carrying handle is a user-friendly addition that facilitates easy transport and handling.

For safety, the Fold-A-Jack features both a quick-action lockwasher and the patented Fall Guard protection. Standard features include a 1 1/2" (38mm) Acme fine adjustment thread (the largest in the industry), a large convenient adjustment handle, and a set screw that locks jack head to the stand during transportation and provides a double margin of safety.

Five head styles are available including standard vee, ball transfer, steel wheel, rubber wheel, and bar stock. Vee and steel wheel heads are also available in stainless steel.

Sumner Manufacturing Company Inc – USA
Fax: +1 281 999 6966
Email: internationalsales@sumner.com
Website: www.sumner.com

Automatic Large-Caliber Steel Pipe Measurement Equipment



The Method and Range of Measurement

The above equipment is characterized as measuring "external diameter, roundness, straightness and length" by using its non-contact sensor.



Drawing-Bench

PIPE SIZE $\Phi 12 \sim \Phi 15$

Innovative pipe production facility runs smoothly with RoundTrack technology

W Strothmann GmbH, Germany, supplies complete handling solutions for press lines, including destackers, blank loaders and sophisticated centring stations. The company's range also includes highly dynamic stacking and destacking feeders, with suction frames and tooling systems, and control and information systems.

Strothmann, together with control systems expert H Kleinknecht & Co GmbH, has designed a special floor transport system featuring inductive power supply for the production of steel pipes weighing up to 30t at Bergrohr, a German manufacturer of large steel pipes.

At 5,000m², the Bergrohr production facility is compact, but so narrow that buffer zones for production could not be established, and material flow was often interrupted. Having extended the floor space to 15,000m², the pipe producer was free to install a modern in-house logistics system.

Many work steps lie between the processing of single heavy steel plates (which are ordered and produced especially for a given application) and the final approval of the finished large steel pipes. These stages include plate preparation, pipe forming, welding of longitudinal seams, water pressure, ultrasound and X-ray checks, and an extended check including processing of the pipe ends. The giant steel tubes are now transported to these stations on tracks.

Strothmann carts carry the pipes, which have diameters between 500mm and 2,500mm and lengths between 3,500mm and 12,000mm, from one step to the next on tracks that are set into the floor. The carts have a maximum speed of 30m/min.

Before the new production facility was built, stationary turning mechanisms were used to realign the pipes. Now, special adjustable mechanisms allow for the rotation of pipes during transportation at a maximum speed of 8m/min.

The new solution is based on Strothmann's wear-free, easy-to-clean RoundTrack® system. Made from hardened and polished steel, the rails are embedded in aluminium holding profiles that are laid in or screwed on the hall floor.

The floor rail system also includes carts with ball bearing rollers, whose 'gothic arch'-shaped profile ensures that contact with the rails is limited to two small surface areas, which minimises rolling resistance and provides high durability and smooth running.

RoundTrack technology is employed as a means of transportation and as a production system. After forming the pipe, the longitudinal seams are joined by state-of-the-art welding technology. The transfer

of the pipe into the machine is implemented with a RoundTrack base. For example, the transport cart, which rolls on tracks, turns into a component of the welding machine: the feeder cart which carries the pipes is moved into the machine and positioned there. Transponder units in the floor enable position sensing.

The RoundTrack system is insensitive to spray water during the ultrasound quality



Transport track with crossing element, which allows for quick changes of travel direction

Bergrohr's new RoundTrack-based production facility, which transports large pipes weighing up to 30t



check. Additionally, cart and RoundTrack must withstand maximum temperatures of 250°C during the heat treatment, during which pipes remain lying on the cart. An inductive supply system embedded in the floor ensures the power supply of the vehicles.

Drive units, hydraulic units and controls are supplied with energy via line conductor cables in the concrete floor and inductive pick-up systems within the cart. Data is transmitted to the carts via wireless LAN. The complete logistics system, all electrical connections and the higher-level controller were implemented by Strothmann's cooperation partner, H Kleinknecht.

The RoundTracks have not only reduced the noise level in the production hall, but have also improved the plant's efficiency and working environment. "The employees no longer need to invest as much physical effort, and therefore feel less burdened," explained Bernd Berg, CEO at Bergrohr.

Since the pipes are placed on top of the carts, they are at an optimal working height for the employees. The round, grooveless upper edge of the rail protrudes only few millimetres from the ground, and persons or vehicles can pass over the tracks without any risk of accident.

After passing through the stations, the carts move freely through the facility. The



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higher-level control system either directs them to the next station or moves them to the buffer zone for a short time.

The pipes no longer have to pass through a static, fixed series of steps, as they would in a roller conveyor system, which is a great production advantage. Bergrohr can therefore easily implement future extensions, eg by integrating additional carts, stations or automation elements into

the floor transport system or by changing the sequence of the stations.

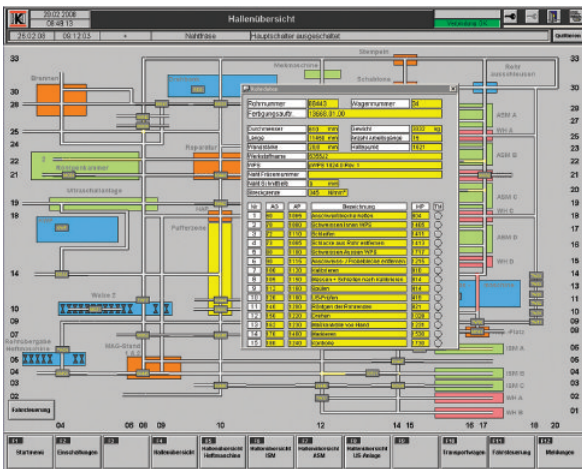
In the complex application of pipe manufacture, contact-free energy and data transfer were integrated into the RoundTrack system. Energy transmission is based on the induction principle: the primary coil is laid along the tracks in the hall floor, and the secondary coil is installed within the cart.

downtime and maintenance efforts. Induction enables contact-free transmission of electrical energy from a fixed conductor to one or more mobile consumers. Electromagnetic coupling is carried out via an air gap.

Since sparks do not occur, this contact-free energy supply method is suitable for use in hazardous environments, underwater applications or in connecting components in hermetically sealed enclosures. Induction is preferably used in applications requiring the bridging of long distances at a high speed.

The transport system can carry loads up to 30t. It has a low noise level, requires little maintenance and little downtime and ensures a high degree of efficiency. Requiring neither cables nor batteries, it is particularly suitable for flow production facilities.

Diagram of the production hall with driveways, stations and pipe data



This system is the first to allow for the wireless transmission of a large electrical output. Data is transmitted via wireless LAN, which enables users to operate the transport carts within the production line. Transponders allow the carts to be positioned with millimetre precision.

No longer equipped with conductor rails or trailing cables, the new system is designed to improve safety and reliability in energy supply and reduce

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SHANGHAI YUEYUECHAO STEEL TUBE

Established in 1994, Shanghai Yueyuechao Steel Pipe Group mainly deal with seamless steel pipe, seamless square/rectangle steel pipe, large OD LSAW manufacture. The specification for LSAW of Shanghai Yueyuechao Manufacture Tube Co.,Ltd is $\Phi 356\sim 1422 \times 8\sim 60\text{mm}$. The specification of cold drawn seamless steel tube for Jiangyin Yueyuechao Manufacture Tube Co., Ltd, ranges from $\Phi 6\sim 426 \times 1\sim 20\text{mm}$, hot expanded tube specification ranges from $\Phi 168\sim 630 \times 4\sim 50\text{mm}$. Quality standards are API/ASTM/GB/ISO/DNV/JIS.



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Electric multi-directional sideloader for optimising storage capacity

Hubtex GmbH & Co KG, Germany, is the manufacturer of customised industrial trucks, sideloaders and special devices for heavy and bulky goods.

The company's equipment is used by manufacturing and commercial enterprises in the narrowest aisles for efficient material flow and movement of goods.

The vehicles are precisely adjusted to the conditions of the company or the warehouse, but are also designed for flexible and multi-functional applications.

The company's electric multi-directional sideloaders are manoeuvrable and space-saving industrial trucks. Featuring multi-directional steering, the trucks can drive in all directions from a standing position.

In comparison to four way sideloaders, diagonal drive is also possible, which is an advantage during the loading and unloading of trucks. Another advantage is the lateral transport of the load.

Narrow gates and aisles can be passed through without any problems, and the distance between the storage rack rows can be minimised. Space for additional storage rack rows is created, optimising storage capacity.

⬇️ Hubtex electric multi-directional sideloaders can optimise storage capacity (below right), as they are able to drive in all directions



The quiet, low-emission electric drive is not only suitable for indoor use in halls, but also for combined indoor and outdoor use.

For this purpose, Hubtex adapts the tyre equipment to the range of application. Vulkollan is mainly applied for indoor use in halls provided it is used with a good industrial floor.

Industrial trucks for use in combined indoor and outdoor applications are equipped with elastic tyres.

The two-part articulated frame compensates for uneven floor surfaces and prolongs the service life of the device components.

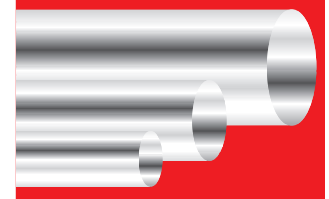
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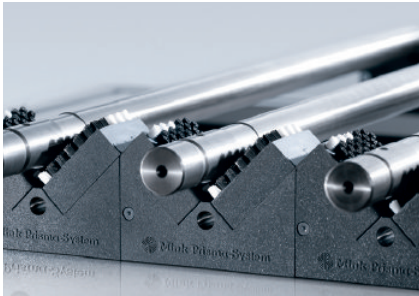


Meeting the higher demands on tube and pipe surface quality

Mink-Brushes, Germany, is a highly experienced manufacturer of high value technical brushes for protective handling, with support of many companies in the machine tool sector. The company has produced the new Mink Prisma-System® specially for internal and external transportation of tube and pipe.

Tube and pipe are high value components in machine construction and therefore high

Ⓢ The Mink Prisma-System provides an optimal and universal solution in work areas for sensitive products



quality expectations are placed upon their surface finish. Through poor handling and storage, surfaces may become damaged. Scratches and marks on polished, coated or painted surfaces can result in high scrap rates. High value stainless steel or aluminium profiles and delicate glass or ceramic tubes are in use in many sectors. These products must be handled and stored with great care.

Scrap rates for products with sensitive surfaces are often increased by the use of conventional transport racks, trolleys and stillages. Solutions for the transportation, support and storage of sensitive products do not always give the desired results. Profiled wooden or plastic bases can be covered with either carpet or soft rubber matting.

Both options can bring problems: carpet wears down in the areas where the greatest pressure is applied and then fails to act as an adequate support. On soft matting such as rubber, swarf and dirt embeds itself into the mat and can damage the surface of components. Scratches, marks and dull spots lead to increased scrap rates and slow down productivity.

The new Mink Prisma-System offers a solution to these problems. The body consists of a plastic injection moulding in the form of a prism onto which a small brush segment with a multitude of flexible bristles is clipped.

The system can simply be screwed onto an existing base. Further prisms can be placed next to one another, to increase the load bearing capacity or to increase the length of the support area. To enable precise assembly and to centre individual units, a bore hole is provided which can house a linking shaft if required.

The Prisma-System is supplied as a kit available in two different sizes, one for tubes with a diameter of 0-60mm, the other for tube diameters of 0-140mm. The user simply chooses the appropriate support segments for the tube. By changing the clip-on brush segment type, the Prisma-System is easily modified to suit a variety of tube types, with no need for tools.

The standard range consists of four differing hardness grades, each clearly identified by a colour coding on the brush surface. This allows the choice of the right system



Ⓢ The system can be quickly and simply assembled or dismantled

to be made without problem and also aids re-ordering. The system is designed to suit each individual customer's requirements.

Dirt can easily become embedded where carpet or other plastic surfaces are used, and swarf and splinters are not easily visible once they have been pressed into the body of a carpet.

Cleaning such surfaces is no easy matter, and their shelf-life as a means of effective protective support is limited. The bristled support areas of the Prisma-System can be easily cleaned and maintained, for example by washing, by use of an air gun or by individual segment replacement.

Swarf and splinters fall into the gaps between the bristles, providing a constant and reliable protection for sensitive surfaces. At the same time, the surface area with its numerous bristle tips reduces friction and enables heavy goods to be moved around with ease. Unlike a carpet, dull spots can be avoided, as products are resting on bristle tips. Durability is also greater.

The Prisma-System offers an optimal and all-round solution in areas used for supporting sensitive goods. Scrap rates, rejects and the resulting financial and time loss are reduced to a minimum. The flexible design of the system allows simple integration into a range of handling and storage products.

Mink's technical brush solutions consist of a standard catalogue range and bespoke solutions. Catalogue products enable the customer to choose from a range of standard items that are competitively priced and are ready for shipment within seven working days. If standard options are not suitable, individual customer bespoke solutions can be considered.

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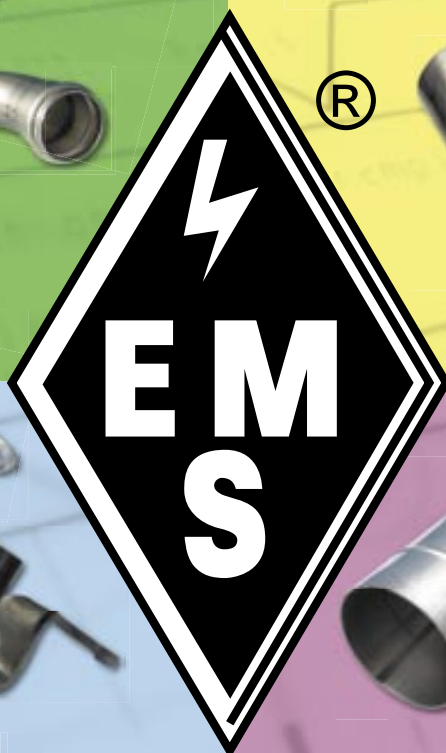
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Four-way solution for non-ferrous extrusion supplier

Atlet Limited, UK, has supplied its Forte UFS four-way reach truck to Doré Metal Services, UK, a supplier of a wide range of non-ferrous and special metal extrusions, including aluminium, brass and stainless steel. This delivery followed a period of consultation with a number of potential lift truck suppliers, including Atlet.

Doré Metal Services had recently consolidated its operations into a new 3,000m² distribution warehouse. The new building presented an opportunity to optimise handling and storage processes.

Atlet arranged for all of Doré's drivers to be trained in the use of the new trucks

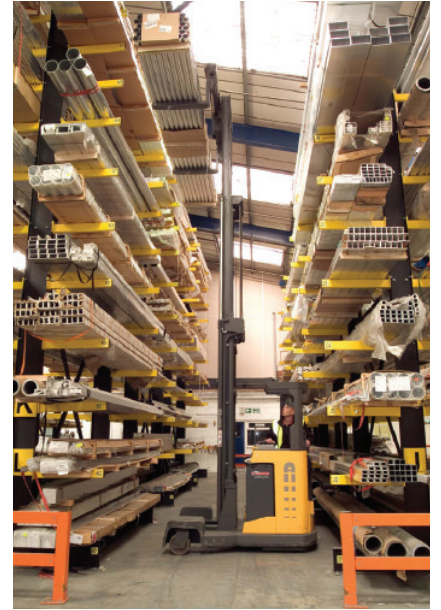


The company had been using a variety of racking in its existing buildings and wanted to configure the new warehouse with a combination of cantilever and 'A' frame racking that offered a flexible and efficient way of storing extrusions, tube, bar and billets up to 6m in length.

In the previous operation, conventional counterbalance trucks had undertaken handling. Doré recognised that this would not be practical in the new warehouse because of the racking density and aisle widths required to achieve the maximum storage capacity.

The Forte UFS four-way can be driven forwards, backwards and sideways because all three wheels can swivel. This makes it highly manoeuvrable in a confined warehouse environment, and suitable for handling long loads and different racking types.

During the selection process, Doré Metal Services had identified that a side loader truck would not offer the flexibility or performance required to support its busy operations. The company was making a



Doré selected Atlet's Forte UFS four-way reach truck for its new warehouse

six-figure investment in the racking alone, and wanted to ensure it achieved the best possible performance.

Atlet recognised that a vital issue was the configuration of the racking and the aisle widths to ensure the maximum storage capacity and efficiency from the available cube space. "Aisle widths are critical because we wanted to get more in the warehouse but with flexibility and potential for future growth," commented Mr Mike Lane, managing director of Doré Metal Services.

Doré's original plan had been to have a series of aisles running along the whole length of the building. However, Atlet suggested the inclusion of a transit aisle running across the middle of the warehouse, as this would reduce the average distance the truck would move to complete each handling task.

The aisle reduced overall storage capacity but this was more than offset by improvements in efficiency and productivity. The transit aisle also formed a convenient boundary between the cantilever racking at one end of the warehouse and the 'A' frame racking at the other.

The business relies on the ability to pick orders quickly, and the company has also decided to purchase a second truck.

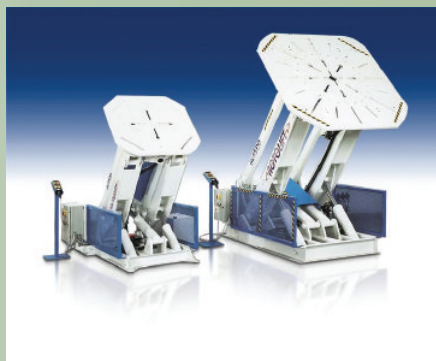
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Website: www.atlet.co.uk

New concept positioner for welding

Rotolift, from Sideros Engineering, is a hydraulic positioner and handler used for welding and assembly operations. The ergonomic machine has the capability to perform workpiece lifting and lowering, in addition to inclination and rotation.

The workpiece is securely fixed on the horizontal rotary table and handled according to the operator's needs. The machine is designed to improve operator performance and efficiency, and boost safety conditions. Sideros Engineering claims that production costs can be reduced by 60 per cent, with a consequent production increase.

Two versions of the machine are available, one with totally oleodynamic movement, and one with oleodynamic lifting and inclination and electromechanical rotation. Models are available catering to a range of loading capacity requirements. On request, the machine can be supplied with a bronze 600 or 1,500W rotary mass.



Rotolift is available in two base models, and in a range of capacities

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Advanced Technocoil 2200 automatic pipe coiler

Sica SpA, Italy, manufactures the Technocoil 2200 coiler that incorporates the latest and most advanced technology available in the field of automatic pipe coiling. The latest in safety protection, pioneered by a team of designers from the Polytechnic of Milan, provides the coiler with a truly unique look while achieving safety and ergonomics.

The equipment produces coils of flexible plastic pipe packaged with polypropylene strapping. A modular design means

excellent operational flexibility and a choice of two configurations – standard with two offloading stations, and compact with a single, central offloading station opposite the pipe infeed.

Both versions incorporate two side-by-side reels, external reel drive, one or two pneumatic strapping units, and an overhead pipe guide. The main difference between the two lies in their width and ability to offload finished coils from one or two stations. Both



 The Technocoil 2200 automatic pipe coiler

models can be configured to suit production requirements.

The Technocoil 2200 can use six or eight sector reels, with manual or centralised automatic adjustment. The pipe guide and cutter can handle smooth or corrugated pipe and can be equipped with an on-board feed system.

The coiler comes equipped with one or two electro-pneumatic strapping units (with or without labellers) that can perform even intermediate strapping, and with provisions for fully automatic adjustment.



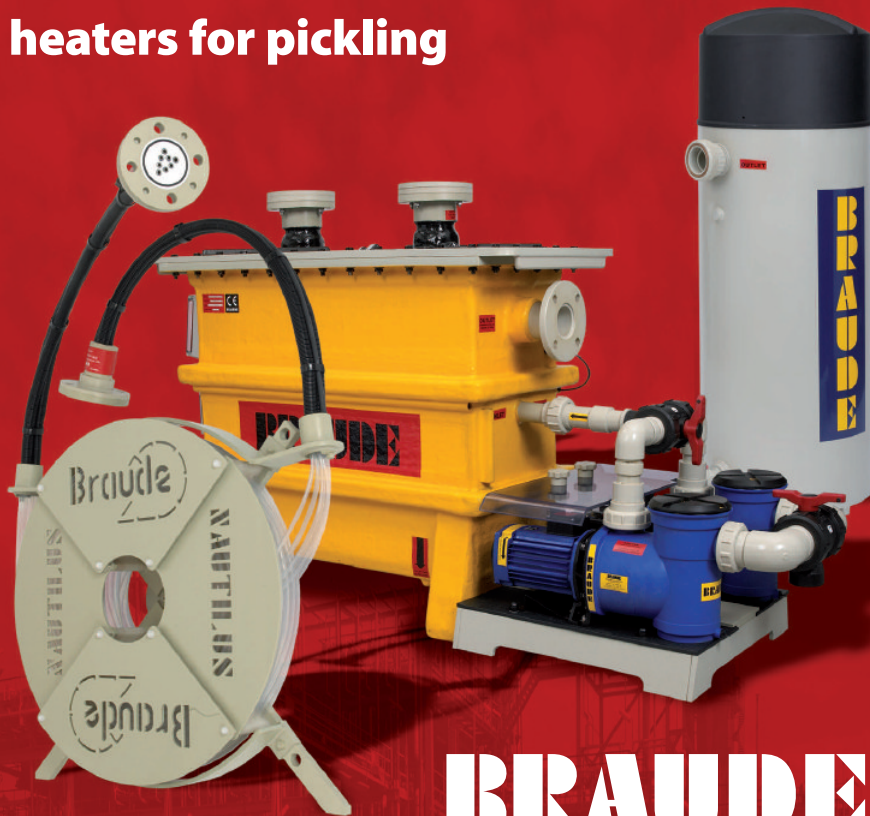
 The coiler is equipped with strapping units to secure the coil

Machines work single or double wall, flexible, corrugated, PE, PVC-U and PP pipe between 32mm and 200mm diameter, and smooth LDPE and HDPE. The maximum coil diameter is 2,200mm, with a maximum width of 720mm, and minimum internal diameter of 300mm.

With two strapping units installed, this machine can maintain a maximum output of 65 coils/hour. Advanced automation, remote control and external safety devices integrated in the machine's structure guarantee safe operation not only during automatic functioning but also during standard maintenance.

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Tube decoilers for automatic tube feeding

Ravni Technologies, France, is the manufacturer of an extensive range of regulated and motorized decoilers. These decoilers are designed to feed automatic steel tubes, copper tubes, and coated

tubes, into straightening and cutting lines with a diameter range of 1-22mm.

The weight of the coils starts from 30kg up to 3 tons. There is availability

⬇ Ravni provide an extensive range of regulated or motorized decoilers



of single or double decoilers, with horizontal or vertical axis. Double decoilers allow a double capability of decoiling as well as the change of coils at masked time.

Available as motorized or non-motorized, these uncoilers are coupled with a module of regulation. This enables regulation of the unwinding speed and compensation for shock due to the rolling-up of the product or drive exercised by the machine. The decoilers are designed to reach 200m/min.

The Ravni uncoilers are very strong and designed to resist the difficult conditions of industrial production. They are adapted to the various processes of load while guaranteeing total safety to the operator.

Ravni Technologies delivers all over the world, supplying and installing machinery and training the operators.

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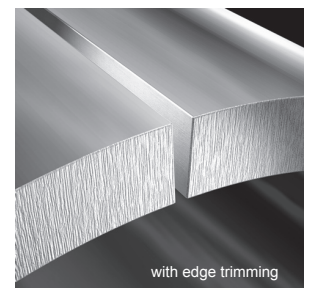
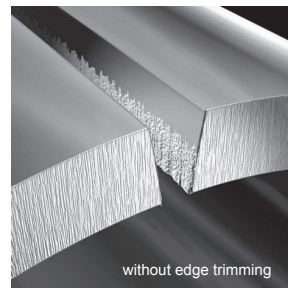
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New solutions for simulation of hot and cold tube rolling processes

Mr A Vydrin, OJSC RosNITI, Russia

Introduction

The issues of plasticity in metal working simulation have long attracted the attention of researchers. Simulations are divided into physical and mathematical, with computer simulation considered a modern form of the latter. The theoretical foundations for mathematical simulation of rolling processes were laid in the second half of the 20th century. This was the period when the majority of calculation formulas were obtained based on the fundamental laws of physics, but with a number of assumptions and simplifications to ensure analytical solutions.

The end of the 20th and the beginning of the 21st century saw the development of computer technology and the new methods of numerical mathematics. Universal application software packages were developed, including Deform, Ansys, Copra, Forge3, and Marc, that allow numerical simulations of stress-strain and temperature conditions of metal during its plastic working phase.

However, many researchers agree that the application history of this software used by technologists and laboratory staff shows its ineffectiveness in plant conditions. The reason behind it is laborious preparation of source data and long a time (up to one day or longer), required for the computing of one option, which effectively turns it into a research project.

On the other hand, the use of analytical relations for technological calculations does not always produce sufficiently reliable results that will not require further technological development in plant conditions. The two main reasons for this are as follows:

- A wide range of steel grades and sizes leads to the excessive laboriousness of technological parameter calculations for each combination of grade, type and size

Figure 1: Stress condition pattern in cylinder shaping

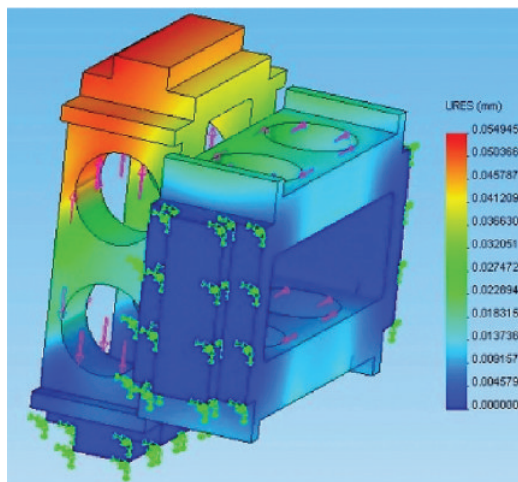
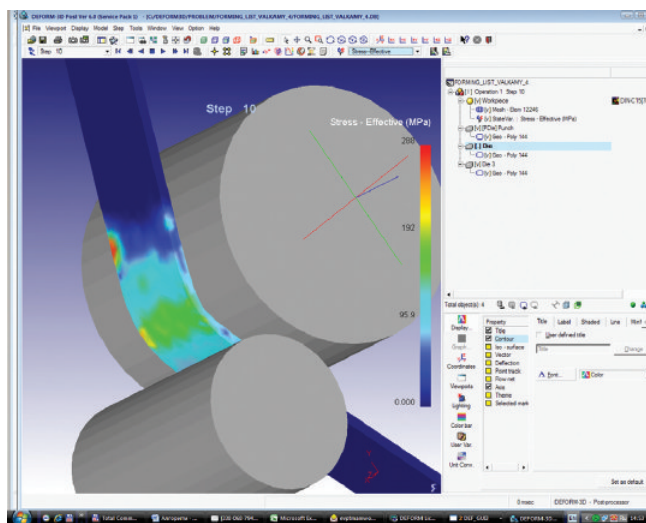


Figure 2: Stress condition pattern of the tube reducing mill of a new design

- In a comprehensive approach, the task is usually described by a set of nonlinear algebraic equations that are difficult to solve without using numerical method and computers.

Nowadays in the area of plastic metal working simulation, particularly in tube and pipe manufacturing, there are a limited amount of software tools for implementing modern calculating methods that base on analytical relations of plastic metal working processes. Currently, OJSC RosNITI is developing a comprehensive approach to the issues of simulation that will encompass virtually all research trends and types of simulation.

The use of turnkey application program packages

The solution of production problems (eg those connected with metal forming), requires dealing with a hypotheses of the physical nature, which in most cases involves correctness that can only be proved with the help of computer simulation. The software system Deform-3D is used for this purpose in cooperation with the Department of Plastic Metal Working of Yuzhno-Uralsky State University.

Defining the strained condition of the plate edge when forming helical-seam pipes is one of the tasks that can be solved with the assistance of software. The simulation results have proved the existing hypothesis on the origins of 'bamboo' flaw (figure 1) observed in the formed pipe weld seam area.

Practice has shown that the application CosmosWorks, part of the SolidWorks system, is an effective tool for simulation of structural components of the equipment working in the elastic stress zone. The use of this application is advisable for the performance analysis of complex configuration non-standard equipment when the existing analytical methods cannot be used without serious simplifications and assumptions. This software was also used to analyse strength

and toughness of the non-standard design reducing mill stand containing two pairs of working rolls separated by a minimal distance (figure 2).

The design of theoretical aspects of mathematical simulation using numerical methods

OJSC RosNITI not only uses turnkey software tools but also designs its own software products for the analysis of deformation processes in tube and pipe manufacturing. The simulation process of the stress-strain state is based on a set of continuum mechanics equations.

Despite the fact that the basic continuum mechanics equations have been developed more than a century ago, modern numerical methods require their corresponding adaptation at the stage of task description. Thus, to receive the approximate solution, the set of differential equations of continuum mechanics boundary-value problem has to be linearized.

The analysis has shown that the problem of linearization can be solved when the approximate solution is made by the finite-element method. In this case the basic set of equations is as follows:

$$\begin{cases} \left(\frac{T}{H}\right)^{(e)} \operatorname{div}(\overrightarrow{\operatorname{grad}v_x}) + \frac{\partial \sigma^{(e)}}{\partial x} = 0; \\ \left(\frac{T}{H}\right)^{(e)} \operatorname{div}(\overrightarrow{\operatorname{grad}v_y}) + \frac{\partial \sigma^{(e)}}{\partial y} = 0; \\ \left(\frac{T}{H}\right)^{(e)} \operatorname{div}(\overrightarrow{\operatorname{grad}v_z}) + \frac{\partial \sigma^{(e)}}{\partial z} = 0; \\ \operatorname{div}(\overrightarrow{v}) = 0, \end{cases}$$

Where T is shear stress intensity, determined with the help of rheological relations; H is shear deformation speed intensity; v_i is speed vector components \overrightarrow{v} ; σ is average normal strain. As the final element (e) takes a small volume, the relation T/H within its limits can be considered constant regardless of the complexity of metal rheological characteristic and it ensures linearization of continuum mechanics boundary-value problem.

It is possible to undertake theoretical analysis of the projection method algorithm of boundary-value problems. The approximate solution has shown that the generalised form of recording boundary conditions for the case under review is as follows:

$$\frac{T}{H} \cdot \frac{\partial \overrightarrow{v}}{\partial n} = G(M) \quad \forall M \in S,$$

In this case, $G(M)$ is the known function given at point at the boundary of deformation centre S . If the function $G(M)$ is selected properly, the generalized boundary condition is reduced to the known kinds of boundary conditions of plastic metal working theory [2].

The calculation accuracy of the stress-strain state in many respects depends on the accuracy of rheological description of the continuum in the numerical solution of a boundary-value problem. To linearize

the set of continuum mechanics equations, the rheological relations also need to be linearized. The accuracy of this operation, in turn, determines the correctness of the task solution.

Currently linearization is usually performed by AA Iliushin's method of variable elasticity. This method takes into consideration the physical equations of the connection between stress and strain conditions that are formulated based on the hypothesis that deviator components of strain and deformation speed tensors are directly proportional.

However, in this case the straight lines that linearize rheological relations at each step always go through a grade level which results in a sawtooth nature of linearized rheological relation in the deformation centre volume (figure 3a). For a more correct record of metal rheology, it is suggested that the formulation of the connection between stress and strain equations has to be based on the hypothesis about the linear dependence between the deviator components of strain and the deformation speed tensors. This situation is depicted in the following:

$$s_{ij} = s_{ij}^0 + ke_{ij},$$

In this instance, s_{ij} and e_{ij} are deviator components of strain and deformation speed tensors; s_{ij}^0 is a free term.

Application of this hypothesis allows the achievement of a considerably smoother rheological curve (figure 3b) and an increase in the accuracy of the boundary-value problem solution. At the same time, it is easy to notice that when setting $s_{ij}^0 = 0$ we arrive at the existing hypothesis that formed the basis of the formulating equations that show the connection between stress and strain conditions.

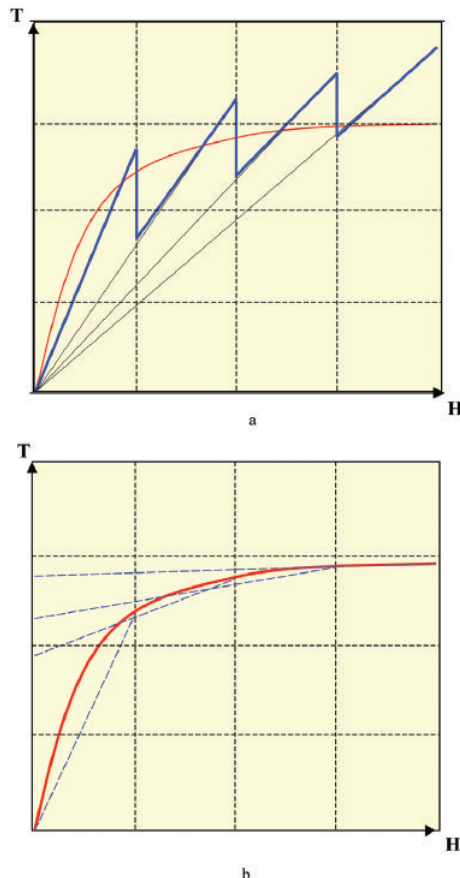


Figure 3: The ways of rheological relations linearisation

If the new hypothesis is used in the basic set of continuum mechanics equations, the multiplier $\left(\frac{T}{H}\right)^{(e)}$ will be replaced with $\left(\frac{\sqrt{3}T - \sigma_{s0}}{\sqrt{3}H}\right)^{(e)}$ where σ_{s0} is a free term of the linearized rheological equation.

A numerical simulation of the stress-strain state

On the basis of the setting problem of the refined continuum mechanics boundary-value, the object-oriented simulator and the numerical analysis software program for the hot tube reducing process were created. The use of this software is more convenient than the use of Deform, Marc and similar packages due to its comparatively narrow application.

First of all, it is connected with the program-protected grid for splitting the deformation centre into finite elements (figure 4) and the minimal primary data input volume. The programme is primarily aimed at the analysis of the tube metal forming to define, for instance, limit values of frequent deformations that do not lead to appearance of internal surface facets.

Design and application of tube deformation process models

As was previously mentioned, there is a lack of software tools for computerized calculation of manufacturing process parameters, especially with an integrated description. As a result, a number of programs have been designed in the Borland Delphi integrated environment that can be used by production managers in plant conditions.

One of these software products is a program for calculating speed behaviour as well as energy and power parameters of the hot reducing process. This software was designed for a specific reducing mill at Volzhskiy Tube Works and so its database has a maximum amount of information about this particular mill. For instance, databases that can be corrected (if required) contain information about the working stand inventory, pass parameters and reduction schedules.

Figure 4: Deformation zone diagram in the tube reducing process

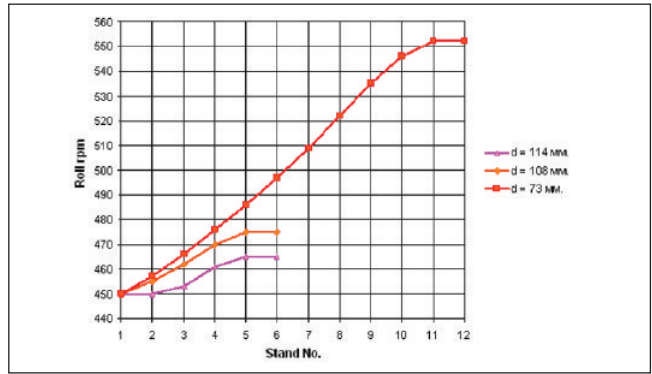
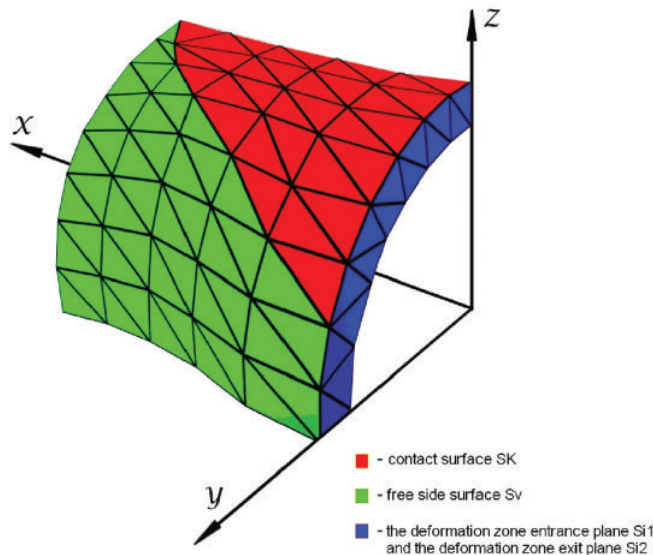


Figure 5: The dependence of the reducing mill roll rpm on the tube diameter

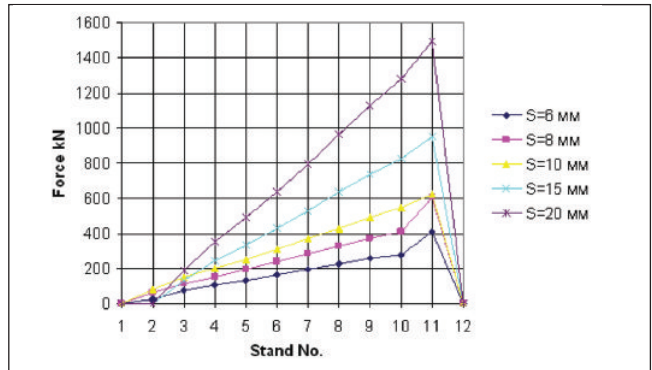
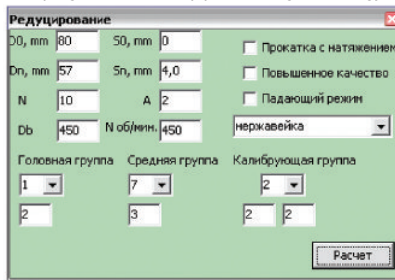


Figure 6: The dependence of the force acting on rollers on the wall thickness of reduced tubes

Due to the existence of databases for reducing speed calculations, it is enough to enter dimensions of a finished tube and rheological coefficients of the worked metal. The results can be represented both in the form of tables, which is more customary to the plant staff, and in the form of graphs. The application of this software program in the plant conditions has enabled a dramatic reduction of the number of adjusted tubes. It has also established the reasons behind the diameter of thick-walled pipes being in the positive area of the tolerance field.

Nevertheless, a significant influence of the tube diameter on speed was noticed during the simulation process (figure 5). The influence of pipe wall thickness on energy power parameters of the process were also studied (figure 6). Along with the software for the reducing mill setting, a software product for computerized development of the tube reducing technology was developed. This product is of a multipurpose nature and allows the development of reducing technology for two- and three-roll stands, with or without tension between the stands. An interface between the user and the computer is also possible and it allows the introduction of changes during the work with the program.

Figure 7: Task window of the automated design programme for the pipe reducing technology



The technological parameters necessary to receive tubes of the target size and requirements are presented in the table form. Figure 7 shows an example task window that requires a minimal quantity of initial information for the program operation.

The technological model is created for computerized development of tool designs for cold tube rolling mills of KhPT and KhPTR types. The model allows calculating of the calibration by three techniques, each of which has its ideal application area depending on plastic properties of the tube metal.

The program also includes databases that contain mechanical properties of the steel grades used as well as the information on technical reference documentation for cold worked tubes. This design was successfully tested at KhPT-32, KhPT-55 and KhPT-75 mills at Sinara Tube Works. Figure 8 shows the appearance of the information obtained.

Physical simulation of production processes

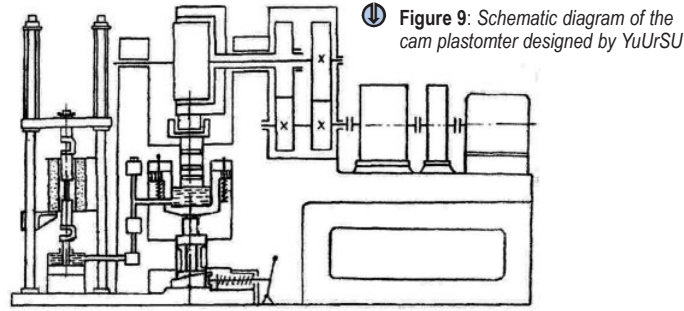
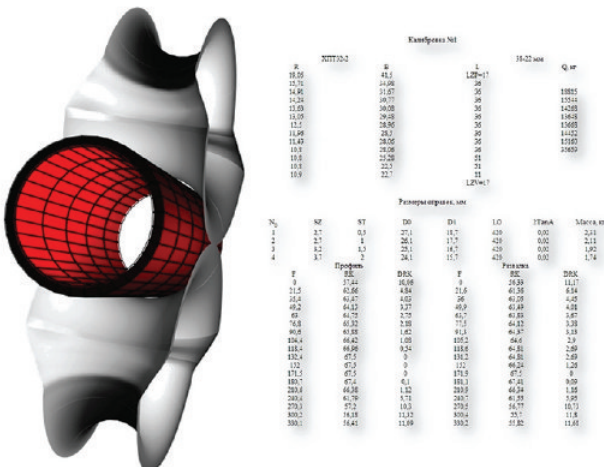
Mathematical simulation is not possible without using physical simulation results; it is only possible to obtain the information about the mechanical properties of metals and the boundary conditions of the working process with the help of physical experiments. To generate the information on the metal resistance to deformation and other physical data, OJSC RosNITI works in close cooperation with Department of Plastic Metal Working of Yuzhno-Uralsk State University, whose research laboratory is equipped with a unique cam plastometer.

The main advantage of this plastometer is the possibility to perform fractional deformation that allows the simulation of continuous tube rolling processes and the study of metal softening patterns between passes. Besides, a special container design allows the performance of simulation at a fixed specimen temperature.

Figure 9 shows the schematic diagram of the cam plastometer. The possibility of a fractional specimen loading provided by the plastometer allows the development and successful implementation of the experimental research procedure of the resistance of metals and alloys to deformation. It also reveals plastic deformation during experiments excluding errors due to the contact friction during plastic deformation. Furthermore, the process of physical simulation is facilitated with the help of the computerized system for collecting, converting and computer processing of data attached to the plastometer.

The equipment for isothermal compressive deformation has allowed the development of the procedure to determine friction coefficient in hot and cold working. The method is based on the known

Figure 8: The results of computerized design programme for cold tube rolling mill tool design



solution of the variational problem of cylinder yielding. The idea of the method is yielding a cylinder specimen at the plastometer at a predetermined temperature while observing the condition of the specimen contact surface with the working tool. This is undertaken by measuring the specimen contact surface diameter after yielding with the help of a toolmaker's microscope and computer processing of the obtained data using a simulator.

In order to calculate parameters of the cylindrical specimen surface stress-strain state during yielding, the solution of the variational problem of cylinder yielding was further developed. This allowed the considerable increase of the accuracy of determining metal and alloy plasticity via physical simulation using the cam plastometer.

Conclusion

The effectiveness of the simulation methods used for research and advancement of the tube rolling processes is determined by their multipurpose application. All simulation (mathematical, physical and computerized) methods shall be used to obtain reliable information.

The accuracy of setting the boundary-value problem, taking into account its end implementation, has to be ensured to receive reliable results when using mathematical simulation. In the case of computer simulation, in addition to the use of available programs it is advisable to create object-oriented programs. This is because the application of such programs is more convenient for solving practical tasks despite a somewhat limited application area.

The development of new computerized analysis procedures for the production processes based on the known analytical solutions can be recommended for an on the spot solution of specific production issues. The implementation of new research procedures for obtaining new kinds of information using the existing laboratory equipment is reliant upon the development of an advanced trend of physical simulation methods.

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