

This flow diagram is a standard process of Chita Works 6in. mill.

Steel strip in coil, which has been slit into the required width from wide strip, is shaped by a series of forming rolls into a round shape. Longitudinal edges are then continuously joined by high

frequency induction welding.

The weld of the pipe is then heat treated electrically, sized and cut off to specified lengths by a flying cut-off machine. The cut pipe is straightened and followed by non-destructive inspection and hydrostatic testing.

Location		Capacity (t./yr.)	Size Range		
			OD	WT	Length
Chita	6in mill	190,000	2.382~6.626in. (60.5~168.3mm)	0.071~0.5in (1.8~12.7mm)	13~52ft (4~16m)
	3in mill		1.315~3.004in. (33.4~76.3mm)	0.024~0.5in (0.6~12.7mm)	13~59ft (4~18m)

■ Small-Diameter (6-in) HFW Pipe

