



UNITED
METALLURGICAL
COMPANY



Oil and gas line pipes

ERW pipes are made by Vyksa Steel Works. Pipes fully comply with requirements of international standards.

Oil and gas line pipes are made with diameters from 114 to 530mm (4½ - 20") and wall thicknesses from 4.0 to 12.7mm (0.16-0.5").

Pipes are produced by high-frequency welding from carbon and low-alloy grades: up to X70.

During production pipes undergo multi-stage non-destructive testing, acceptance mechanical tests of base metal and weld and 100% hydraulic pressure test.

All pipes are supplied pre-treated: with local heat treatment of weld or bulk heat treatment.

Pipes undergo multi-stage non-destructive testing using an eddy current flaw detector, automatic and manual ultrasonic flaw detector, mechanical and 100% hydraulic tests.

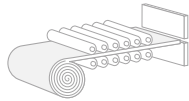
Product mix and scope of application

Standard	Outside dia., inch (mm)	Wall thickness, mm	Steel grade	Scope of application
API Spec 5L / ISO 3183:2012	8½ (219.1)	4.8–12.7	up to X70	Oil & Gas and Water transportation
	10¾ (273.0)			
	12¾ (323.9)	5.6–12.7		
	14 (355.6)			
	16 (406.4)			
	18 (457.0)			
20 (508.0)	6.3–12.7			
DIN EN 10219-1(2)	8½ (219.1)	4.5–12.5	S235 - S460	For multi-purpose structures
	10¾ (273.0)	5.0–12.5		
	12¾ (323.9)	5.6–12.5		
	14 (355.6)			
	16 (406.4)			
	18 (457.0)			
20 (508.0)	6.3–12.5			
DIN EN 10217-1, 2, 3	8½ (219.1)	4.5–12.5	P195 – P460	Multi-purpose
	10¾ (273.0)	5.0–12.5		
	12¾ (323.9)			
	14 (355.6)	5.6–12.5		
	16 (406.4)	6.3–12.5		
	18 (457.0)			
20 (508.0)				

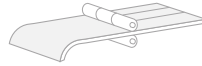
ERW line pipes manufacturing process



1. Coils examination



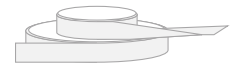
2. Uncoiling, leveling and shearing



3. Strips slitting



4. Welding



5. Looper

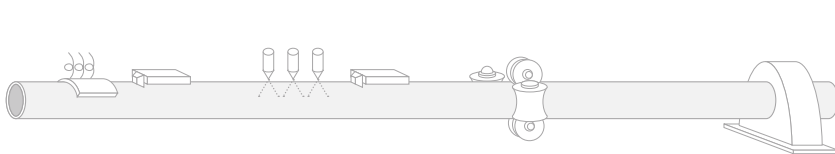


6. Edges preparation

7. Skelp forming

8. HF welding

9. Inside & Outside weld bead removal



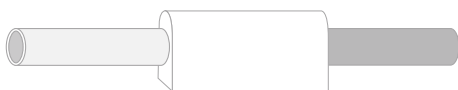
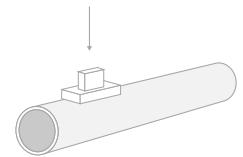
10. UT of weld

11. Seam-annealing

12. Sizing

13. Cutting-to-length

14. Marking



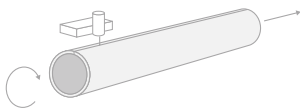
15. Entire heat treatment (upon agreement)



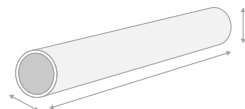
16. Facing and beveling



17. Hidrostatic test



18. AUT of body, weld & ends of pipe



19. Final inspection



20. Packaging & storage



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