**Buttwelding induction bends (HFC)**

Buttwelding induction bends offered by TURUBODETAL OAO are manufactured using the following induction bending machines:

- **SRIPR 1400** (ABG Schaefer, Germany)
- **PB 1400** (JL Spelen, Netherlands)
- **620 HFC** (JenarMash, Russia)

HFC Bend Branch Specifications:
- **diameter**: 57 to 920 mm
- **bending radius**: 1.5 to 10 D
- **all thickness**: up to 5.5 mm
- **bending angle**: 10 to 90°
- **operating pressure**: up to 12 MPa

SRIPR 1400 bending machine allows for manufacturing of 10 bent products. The Company also offers various cold bent items, made at our in-house cold bending bay, fitted with 5 precision cold-bending machines: pipe diameter: 219 to 1420 mm, all thickness: up to 33.4 mm, pipe strength grade: up to K65, including products with external insulation.

**Pressured branches, tees, adapters, plugs**

Pressed pipe fittings are produced in-house in the shop no. 2, equipped with 3 test bending machines, 2 hydraulic testing production lines, 3 presses for manufacturing pipe adapters and plugs.

**Major Applications:**
- oil and gas industry
- subsea and onshore petroleum industries
- thermal and power industry
- construction, housing and utility sectors.

**Product Specifications:**
- **diameter**: up to 630 mm
- **wall thickness**: up to 30 mm
- **operating pressure**: up to 12 MPa
- **made of corrosion resistant, stainless and carbon steels**
- **fabricated from seamless and welded pipes**.

**Forge-welded bends**

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- **PB 1400** (JL Spelen, Netherlands)
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- **operating pressure**: up to 12 MPa
- **made of corrosion resistant, stainless and carbon steels**
- **fabricated from seamless and welded pipes**.

**Forge-welded tees**

Tee in-house production working areas, equipped for casting, forging, assembling, welding, testing, thermal treatment operations.

**Product Specifications:**
- **diameter**: 720 to 1420 mm
- **wall thickness**: up to 52 mm
- **operating pressure**: up to 28.45 MPa

Pressured pipe fittings are produced in-house in the shop no. 2, equipped with 3 test bending machines, 2 hydraulic testing production lines, 3 presses for manufacturing pipe adapters and plugs.

**Major Applications:**
- oil and gas industry
- subsea and onshore petroleum industries
- thermal and power industry
- construction, housing and utility sectors.

**Product Specifications:**
- **diameter**: up to 630 mm
- **wall thickness**: up to 30 mm
- **operating pressure**: up to 12 MPa
- **made of corrosion resistant, stainless and carbon steels**
- **fabricated from seamless and welded pipes**.

**Pipeline assemblies**

Trubodetal OAO uses the ISO assembling of piping systems for oil pumping stations, compressor stations, oil and gas treatment plants, etc.

ISO assembling method considerably accelerates field assembling works and ensures the quality, since the majority of welding and coating works are performed in the plant.

The Company offers various pipeline assemblies with diameters ranging from 57 to 1420 mm and operating pressure up to 28.45 MPa.

Production facilities include three production working areas: assembling and welding facilities are equipped with modern welding equipment, including:
- automatic welding machines SEMA Car-300 (Sweden);
- semiautomatic welding machines EMAL Aqua 1 (Germany);
- assembly jigs.

After having been welded all the types of pipeline assemblies are coated with anticorrosion protection coatings. The coatings are applied in one cycle, which eliminates the need for heat-shrinkable sleeves. All welded joints are 100% tested and verified using ultrasonic and Gamma-ray flow detection control methods.

**Anticorrosion coatings and thermal insulation**

The Company is widely using modern equipment for applying liquid external polyurethane-based coatings on final products.

The Company has been producing waterproof pipe fittings for both underground and on-surface pipelines since 2011.

Today Trubodetal OAO is highly demanded among industrial users, including industry giants, such as Gazprom OAO, AK Transneft OAO.

External corrosion-resistant and thermal insulation coatings may be applied on all pipeline elements, from D219 to 1420 mm diameter.

**Quality control**

Trubodetal OAO has implemented an in-house A Quality Management System, including:
- **Quality Control and Inspection (QCI)**
- **Non-Destructive Test Lab**
- **Test Center**

These audits are fitted with more than 200 units of most modern, state-of-the-art test equipment, including:
- **X-ray equipment** (Russia, Switzerland, England, Germany)
- **radiographic control chambers with ultrasonic and Gamma-ray control equipment**
- **magnetic flaw detectors**
- **ultrasonic testing equipment DOPHAR/SH-232 (Japan)**
- **hardness testers (Russia, USA)**

All the Products are manufactured under strict quality control in compliance with the applicable GOSTs, DSTs and the Technical Specifications (TU), developed by the Company in cooperation with Gazprom VNIIGAZ LLC, NII TNN LLC, Samara Technical Engineering Center LLC. The Company additionally applies Technical Specifications, approved by Gazprom OAO and AK Transneft OAO.

The list of our Technical Specifications (TU) includes the following TU for pipe fittings:
- **For the Gazprom OAO facilities, operating at pressures of 12.5 and 20.45 MPa pressure.**
- **For the AK Transneft OAO facilities, operating at pressures up to 14 MPa.**
- **For the facilities of SiburGazEco OAO.**
- **For pipe cutting and threading facilities, approved by MK Rosenstahl OAO, Gazprom Neft OAO, Lukoil OAO and other major oil companies.**

The Company has been producing waterproof pipe fittings for both underground and on-surface pipelines since 2011.

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Trubodetal OAO

Trubodetal OAO – the leading Russian manufacturer of a wide range of pipe fittings.

OMK – one of the largest Russian manufacturers of pipes, tubes, railway wheels and other steel products for power engineering, transport and other industries. OMK includes seven major metallurgical enterprises: Syktyvkar steel works (Nizhny Novgorod region), Almetyevsk pipe plant (the Republic of Tatarstan), Trubodetal (Chelyabinsk region), Casting and rolling complex (Nizhny Novgorod region), Blagoveschensk valves plant (the Republic of Bashkortostan), Chusovskoy metallurgical plant (Perm region), OMK Tube (Texas, USA).

Today Trubodetal OAO means twelve production working areas, more than 1,900 employees, production facilities capable to produce more than 10,000 of various dimension-types of pipe fittings.

OMK share in the Russian market: 
- pipes: 15% 
- railway wheels: 62% 
- pipe fittings: 21%

* as on 2012