

ERW & HF Welded Round Steel Pipe

Machine range, sizes, and the standards the pipe is specified to.

What this covers

Welded round steel pipe is made from coil strip. The strip is uncoiled and accumulated, roll-formed into a round section, joined by high-frequency (ERW) welding, then sized, straightened and cut to length. The table below is the round-pipe range covered by the ZT straight-seam series; the HG series covers coil-fed lines in the same size band.

Model	Round pipe OD	Wall thickness	Line speed
ZT-25	8 – 32 mm	0.4 – 1.2 mm	30 – 100 m/min
ZT-28	10 – 50.8 mm	0.5 – 1.8 mm	30 – 100 m/min
ZT-32	7 – 25 mm	0.3 – 1.0 mm	30 – 100 m/min
ZT-50	19 – 76 mm	0.7 – 2.75 mm	30 – 100 m/min
ZT-60	25 – 80 mm	1.0 – 3.25 mm	30 – 100 m/min
ZT-76	30 – 90 mm	1.0 – 4.0 mm	15 – 70 m/min
ZT-127	32 – 127 mm	1.5 – 4.0 mm	20 – 70 m/min
ZT-165	50 – 165 mm	2.0 – 5.0 mm	30 – 50 m/min

HG series — coil-fed welded pipe lines

HG76 covers $\Phi 10$ – $\Phi 76$ mm pipe on strip 40 – 160 mm wide and 0.4 – 3 mm thick, at 40 – 50 m/min. The HF ERW line covers $\Phi 16$ – $\Phi 50$ mm at 0.5 – 2.5 mm wall. HG127 covers the larger end up to $\Phi 127$ mm — see the hollow-section sheet for its square and rectangular range.

Standards the pipe is specified to

- **ASTM A53** — welded and seamless steel pipe for general service: steam, water and air lines; black or hot-dip galvanised.
- **ASTM A500** — cold-formed welded carbon steel structural tubing (round, square and rectangular shapes).
- **EN 10255** — non-alloy steel tubes suitable for welding and threading; general building services including water and gas.
- **GB/T 3091** — welded steel pipe for low-pressure liquid delivery.
- **API 5L** — line pipe for oil and gas transmission.

The applicable standard governs grade, mechanical properties and tolerances. Grade, coating class and end finish (plain, threaded, beveled, galvanised) for your order are confirmed at quotation.

What we need to quote

Pipe outside diameter and wall thickness, material grade or the standard you are working to, coil width and coil weight you can buy, required line speed or annual output, cut length and tolerance, and your power supply.

Machine pages and further reading

- ZT straight-seam pipe making line — full model comparison — steelpipemachines.com/posts/high-frequency-straight-seam-pipe-making-line
- HF pipe welding machines — all models — steelpipemachines.com/category/hf-pipe-welding-machine