HG series — model comparison

HG32 · HG50 · HG76 · HG127 · HG165 · 10 – 168 mm round pipe · 0.4 – 5.0 mm wall

The five models, published side by side

Model	Round pipe	Square / rectangle	Wall	Line speed	Main motor	HF welder
HG32	10 – 45 mm	7.8×7.8 – 35×35 rect 7×7 – 10×60	0.4 – 2.5 mm	30 – 90 m/min	30 kW	—
HG50	Ø10 – Ø60 mm	10×10 – 60×60 rect 20×40 – 40×60	0.5 – 3.0 mm	30 – 90 m/min	55 kW	—
HG76	Φ10 – Φ76 mm	see model pages	0.4 – 3.0 mm	40 – 50 m/min	—	200 kW
HG127	Φ76 – Φ127 mm	30×30 – 100×100 rect 20×40 – 120×80	1.5 – 5.0 mm	30 – 60 m/min	—	—
HG165	Φ76 – Φ168 mm	60×60 – 125×125 rect 80×40 – 100×50	2.0 – 5.0 mm	—	—	GGP 400 kW

A dash means the value is not published for that model on this site — it is settled with the line specification at quotation rather than assumed here. For HG76 the minimum diameter depends on the roll set: the HG76 tube mill page publishes 10 mm, the carbon steel variant page publishes 20 mm, both to the same 76 mm maximum.

Cut length and tolerance, where published

Model	Pipe length	Length tolerance
HG50	6 – 12 m	0 – 6 mm
HG76	customise, max 12 m	—
HG127	6.0 – 12.0 m	0 – 6 mm
HG165	6.0 – 12.0 m	—

How the model is actually chosen

The diameter band decides first, and it is the **smallest** diameter you must run every week that usually settles it, not the largest: a mill sized for 76 mm will not run 10 mm strip comfortably, while a 32 mm mill cannot be stretched to 168 mm. Where the product range straddles two models, the wider one run slower on small sizes is normally cheaper than two lines — unless the small sizes are high volume.

Wall thickness decides second. The published wall ranges above are what the forming section is built for; running a heavier wall than published is a roll-load question, not a setting.

Speed decides third, and it is a consequence rather than a target: a 30–90 m/min line is a different machine from a 30–60 m/min line, and the HF welder power has to match the speed and wall you intend to run. Ask for the speed at your wall, not the maximum in the table.

Where to go next

- Every figure above is traceable to a machine page; open the model page for the full equipment list, roll configuration and coil data.
- Square and rectangular sections have their own datasheet, including the standards hollow sections are bought to.
- If the section you need is outside every band, send the drawing — a mixed square / rectangle / oval list usually still fits one of these mills.

Machine pages and further reading

- ERW & HF welded round steel pipe — steelpipemachines.com/downloads/ZTRFM-ERW-HF-Welded-Round-Steel-Pipe.pdf
- Square & rectangular hollow sections — steelpipemachines.com/downloads/ZTRFM-Square-and-Rectangular-Hollow-Sections.pdf
- HG machine group — steelpipemachines.com/category/hf-pipe-welding-machine