Spiral welded pipe machine

160 – 3250 mm diameter · 2 – 10 mm wall · inner and outer welders · flying tracking cut-off

Published specification

Parameter	Value
Pipe diameter range	**160 – 3250 mm**
Wall thickness range	**2 – 10 mm**
Materials	Galvanized sheet, carbon steel coil
Coil handling	Decoiler with leveling rollers stressed by hydraulic cylinders
Coil end joining	Cutting edge and welder system with loading car
Edge trimming	Disc shearing with waste edge scrap boxes (1 shear, 2 scrap boxes)
Forming	Roll forming machine with stabilizer and rear / front axle devices
Welding	Inner and outside welders
Cut-off	Flying tracking cutting car (non-plasma cutting)
Foundation	Buried parts foundation supplied with the machine

Diameter and thickness are the published ranges. Strip width, forming angle, line speed and welding procedure for a given pipe size are worked out from the buyer's specification and confirmed at quotation.

How the pipe is made

Decoiling; removing the unneat and unstraight part at the start of the coil; feeding the coil in; vertical rollers hold the strip while the coil end is welded to the previous coil; leveling and edge shearing; pre-bending sets the curvature; the strip enters the forming section at the spiral angle; the seam is welded inside and outside; the flying tracking car cuts the pipe to length.

Principal elements, as listed on the machine page

Group	Elements
Coil handling	Double head decoiler, shovel head device, coil feeder with vertical roller system, coil delivery system
Edge preparation	Cutting edge and welder system with loading car, disc shearing with waste edge scrap boxes
Forming	Pre-bending system, entrance guide, entrance roller, roll forming machine, stabilizer, rear and front axle devices
Welding	Inner and outside welders
Cut-off and support	Flying tracking cutting car (non-plasma), swing and supporting rollers
Services	Hydraulic system, electrical system, foundation for buried parts

The machine page carries the full 20-element list; the groups above are that list rearranged, not additional equipment.

Where spiral pipe is used

- Transmission piping for high-intensity petroleum and natural gas, to the API line pipe standard as stated on the machine page.
- Low-pressure fluid transfer, city gas and drainage pipelines.
- Pile driving tube for construction projects.
- Steel tube for industrial structures.

What to specify

- **Pipe size range** — minimum and maximum outside diameter, and the wall range you actually sell.
- **Coil** — strip width, thickness and coil weight, which set the decoiler and the forming angle for each pipe size.
- **Service** — oil and gas transmission, water, piling or structure — since the weld procedure and inspection follow from it.

Machine pages and further reading

- Spiral welded pipe machine — full specification — steelpipemachines.com/posts/spiral-welded-tube-machine
- Coil processing lines — steelpipemachines.com/category/coil-processing-line