



Product Attributes

Type: Pipe Mill

Pipe Material: Carbon Steel

Place of Origin: Hebei China

Brand Name: ZTZG Zhongtai

FOB Price: USD120,000-2,000,000

Dispatch Port: Tianjin

Payment Terms: L/C, T/T

Min. Order Quantity: 1SET

Brief Introduction

Pipe mills that can produce round pipe, square & rectangular tube, section steels of the corresponding size by Cold-Rolled Forming and H.F. Welding technology.

Zhongtai pipe production line is designed to manufacture pipe or tube used in metallurgy, construction, transportation, machinery and vehicle industries. It makes pipe or tube of carbon steel strip by ZTF technology, which is developed by our company on basis of the world advanced forming technology as well as our former technology and skills. Our innovative production line and each single unit of the production line are not only economical but also practical. The complete production line adopts ZTF technology, when producing round pipe, the customer may save 60% expense on tooling, limited working time and labor cost, improve production efficiency and gain more economic benefit.

The plain technical flow of the production line

Uncoiling→ Shear & butt welding→ Cage looping (Accumulating)→ Forming → HF welding→ Removing Bead → Cooling(air & water)→ Sizing→ Cutting off→ inspection → Packing → Warehousing



Main machines

1. Uncoiler
2. Shear & Butt Welder
3. Cage Loop (Accumulator)
4. Tube mill
5. Solid State H.F. welder
6. Cut-off
7. Output Rollway
8. Rollers

Technology Description

First, the coil of strip is lifted to coil car by overhead crane, the coil car with coil of steel strip is carried to uncoiler, then its oil cylinder in vertical direction to make the center of steel strip aim at center of cone of uncoiler, which can hold the coil of strip steel; When coil is held, coil car will return to the preparing position for the next time.

Secondly, drag roll of coil opener falls and impacts onto steel coil, the cone of uncoiler acts, at the same time shovel of straightener uplifts and presses close to steel coil. The end of strip steel is scooped up through oil cylinder work, as the uncoiler cone to-and-fro circumrotates slightly, which will level the strip steel head. The cone continues to round; strip steel is carried to flattener. Withdrawal rolls chimp strip steel head; gyro-withdrawal rolls carry strip steel into five-roll flattener, which will flat strip steel by to-and-fro moving. Strip steel flatted is carried into shear weld, the head and trial of strip steel is sheared to align, then is carried to weld platform and is weld via gas protection weld, strip steel weld is carried to accumulator for reserve.

Thus, the preparation for forming and sizing has been done

Forming and Sizing stage:

Steel strip should be rolled to corresponded specification tube blank (preform), then tube blank brim is heated to welding temperature (1130-1350°C) unitized Kelvin skin effect and



proximity effect of high frequency electric current, then will be squeezed and welded by squeezing roll, thereby which form close entry tube blank. A guide roll stand fixed in front of squeezing roll that is used to guide weld seam and control open-mouth angle, consequently made tube blank into squeezed roll for welding. after squeezing roll , Bead trimmer rack scrape the weld bead and Polishing stand will burnish the weld seam , then the welding pipe will enter into cooling part(air cooling and water cooling) and then get through sizing part. Round pipe is directly sized to eligible size, after which is straightened and is carried into cut-off machine. The pipe will be cut to specified length by fly saw , go through rollway platform and will be carried to platform, and then be checked, marked, separated, packed and warehoused.

Main Production Lines

Our mills include:

H.F. Straight Welded Pipe Production Line;

Abroach Cold Rolled Section Steel Production Line;

Square to Square Welded Pipe Production Line;

Multi-functional Production Line

Slitting Line;

Rolls And Other Auxiliary Equipments

1, HF-Straight Welded Pipe Production Line:

Model	Specification(mm)		Thickness (mm)	Mill Installed Capacity(kw)	Line Area(m) - programmable	Working Speed (M/min.)
	Circular	Rectangular & Square				
HG20	Φ8-Φ20	10mm×10mm -15mm×15mm	0.5-1.5	50KW	40m*3.8m	100
HG32	Φ10-Φ32	10mm×10mm -25mm×25mm	0.3-2.0	50KW	45m*4m	100
HG50	Φ20-Φ50	15mm×15mm – 40mm×40mm	0.8-3.0	65KW	50m*4m	100
HG76	Φ32-Φ76	25mm×25mm – 60mm×60mm	1.2-4.0	120KW	70m*5m	100

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HG89	Φ42-Φ89	25mm×25mm – 70mm×70mm	1.5-4.5	150KW	72m*5.5m	70
HG114	Φ48-Φ114	40mm×40mm – 90mm×90mm	1.5-4.5	160KW	78m*6m	65
HG140	Φ60-Φ140	50mm×50mm – 110mm×110mm	2-5	180KW	80m*6.5m	60
HG165	Φ76-Φ165	60mm×60mm – 130mm×130mm	2-6	220KW	85m*7m	50
HG219	Φ89-Φ219	70mm×70mm– 170mm×170mm	2-8	280KW	100m*9m	50
HG273	Φ114-Φ273	90mm×90mm – 210mm×210mm	3-10	350KW	120m*10m	45
HG325	Φ140-Φ325	90mm×90mm – 250mm×250mm	4-12.7	430KW	130m*11m	40
HG377 (355)	Φ165-Φ377 (355)	130mm×130mm– 280mm×280mm	4-14	580KW	145m*13m	35
HG406	Φ219-Φ406	170mm×170mm– 330mm×330mm	6-16	880KW	160m*16m	30
HG508	Φ273-Φ508	210mm×210mm– 400mm×400mm	6-18	1000KW	300m*30m	25
HG660	Φ325-Φ660	250mm×250mm – 520mm×520mm	6-20	1200KW	350m*35m	20

HG Φ20 Mill Line

I. Brief introduction

HGΦ20 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 8mm-20mm in OD and 0.5mm-1.5mm in wall thickness, as well as corresponding square and rectangle tube.

II. Basic Technical Information:

1. Specification of pipes

Pipe OD: 8mm-20mm Thickness: 0.5mm-1.5mm

Square & rectangle tube: 10mm×10mm -15mm×15mm, Thickness: 0.5mm-1.5mm

Length: 6-12m Length Tolerance: ±3mm



2. Raw Material:

Carbon Steel coil GB/T 700: Q235B(ASTM: GR-D(σ_s 230) / JIS: SS400)

Width: 36mm-120mm Thickness: 0.5mm-1.5mm

Coil ID: 450-520mm

Coil OD: Max 1200mm

Coil Weight: 1t

3. Tube mill:

Production Speed: 20-100 m/min

Production capacity: 10,000ton/year

Direction: left or right decided by customers.

Mill installed capacity: 50 kw

Line Area: 40m(length) × 3.8m (width)

Tube Bottom Passline (Above floor level): 800 mm

Weight: about 8t

HG Φ 32 Mill Line

I. Brief introduction

HG Φ 32 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 10mm-32mm in OD and 0.3mm-2.0mm in wall thickness, as well as corresponding square and rectangle tube.

II. Basic Technical Information:

1. Specification of pipes



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Pipe OD: 10mm-32mm Thickness: 0.3mm-2.0mm

Square & rectangle tube: 10mm×10mm -25mm×25mm, Thickness: 0.3mm-1.5mm

Length: 6-12m Length Tolerance: ±3mm

2. Raw Material:

Material: Carbon Steel coil Q235B(ASTM GR·D,σs 230)

Width: 36mm-150mm Thickness: 0.3-2.0mm

Coil ID: 450-520mm

Coil OD: Max 1200mm

Coil Weight: 1t

3. Tube mill:

Production Speed: 20-100m/min

Production capacity: 10,000ton/year

Direction: left or right decided by customers.

Mill installed capacity: 50 kw

Line Area: 45m(length) ×4m (width)

Tube Bottom Passline (Above floor level): 800 mm

Weight : about 8t

HG Φ50 Mill Line

I.Brief introduction



Tube Bottom Passline (Above floor level) : 800 mm

Weight : about 14t

HG Φ76 Mill Line

I.Brief introduction

HGΦ76 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 32mm-76mm in OD and 1.2mm-4mm in wall thickness, as well as corresponding square and rectangle tube.

II. Basic Technical Information:

1.Specification of pipes

Pipe OD: 32mm-76mm

Thickness: 1.2mm-4mm

Square & rectangle tube: 25mm×25mm – 60mm×60mm, Thickness: 1.5mm-3mm

Length: 6 -12m

Length Tolerance: ±3mm

2.Raw Material:

Material: Carbon steel coil Q235B(ASTM GR·D,σs 230)

Width: 105mm-240mm

Thickness: 1.2mm-4mm

Coil ID: 450-520mm

Coil OD: Max 1600mm

Coil Weight: 2t

3. Tube mill

Production Speed : 20-100m/min

Production capacity: 20,000ton/year



Coil Weight: 4t

3. Tube mill

Production Speed : 20-70m/min

Production capacity: 22,000ton/year

Direction : left or right decided by customers.

Capacity : 15,000ton/year

Mill installed capacity : 150 kw

Line Area : 72m(length) ×5.5m (width)

Tube Bottom Passline (Above floor level) : 800 mm

HG Φ114 Mill Line

I. Brief introduction

HGΦ114 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 48mm-114mm in OD and 1.5mm-4.5mm in wall thickness, as well as corresponding square and rectangle tube.

II. Basic Technical Information:

1. Specification of pipes

Pipe OD : 48mm-114mm

Thickness : 1.5mm-4.5mm

Square & rectangle tube : 40mm×40mm – 90mm×90mm, Thickness : 1.5mm-4mm

Length : 6 -12m

Length Tolerance : ±3mm

2. Raw Material:

Material: Carbon steel coil Q235B(ASTM GR-D,σs 230)



Width : 165mm-500mm Thickness : 1.5mm-4.5mm

Coil ID : 450-520mm

Coil OD : Max 1600mm

Coil Weight: 3t

3. Tube mill

Production Speed : 20-65 m/min

Direction : left or right decided by customers.

Capacity : 30,000ton/year

Mill installed capacity: 160kw

Line Area : 78m(length) ×6m (width)

Tube Bottom Passline (Above floor level) : 800 mm

Weight : about 34t

HG Φ140 Mill Line

I. Brief introduction

HGΦ140 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 60mm-140mm in OD and 2.0mm-5.0mm in wall thickness, as well as corresponding square and rectangle tube.

II. Basic Technical Information:

1. Specification of pipes

Pipe OD: 60mm-140mm

Thickness: 2.0mm-5.0mm

Square & rectangle tube: 50mm×50mm – 110mm×110mm, Thickness: 2.0mm-4.0mm



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Length: 6 -12m

Length Tolerance: ± 3 mm

2.Raw Material:

Material: Carbon steel coil Q235B(ASTM GR·D, σ_s 230)

Width: 195mm-500mm

Thickness: 2.0mm-5.0mm

Coil ID: 520-680mm

Coil OD: Max 1700mm

Coil Weight: 5t

3. Tube mill

Production Speed : 20-60 m/min

Direction : left or right decided by customers.

Capacity : 30,000ton/year

Mill installed capacity : 180 kw

Line Area : 80m(length) \times 6.5m (width)

Tube Bottom Passline (Above floor level) : 800 mm

Weight : about 40t

HG Φ 165 Mill Line

I.Brief introduction

HG Φ 165 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 76mm-165mm in OD and 2.0mm-6.0mm in wall thickness, as well as corresponding square and rectangle tube.

II. Basic Technical Information:



1.Specification of pipes

Pipe OD: 76mm-165mm

Thickness: 2.0mm-6.0mm

Square & rectangle tube: 60mm×60mm – 130mm×130mm, Thickness: 2.0mm-5.0mm

Length: 6 -12m

Length Tolerance: ±3mm

2.Raw Material:

Material: Carbon steel coil Q235B(ASTM GR·D,σs 230)

Width: 250mm-550mm

Thickness: 2.0mm-6.0mm

Coil ID: 580-700mm

Coil OD: Max 1800mm

Coil Weight: 6t

3. Tube mill

Production Speed : 20-50 m/min

Production capacity: 25,000ton/year

Direction : left or right decided by customers.

Mill installed capacity : 220 kw

Line Area : 85m(length) ×7m (width)

Tube Bottom Passline (Above floor level) : 850 mm

Weight : about 54t

HG Φ219 Mill Line

I.Brief introduction



HGφ219 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 89mm-219mm in OD and 2.0mm-8.0mm in wall thickness, as well as corresponding square and rectangle tube.

II. Basic Technical Information:

1. Specification of pipes

Pipe OD: 89mm-219mm

Thickness: 2.0mm-8.0mm

Square & rectangle tube: 70mm×70mm – 170mm×170mm, Thickness: 2.0mm-6.0mm

Length: 6 -12m

Length Tolerance: ±3mm

2. Raw Material:

Material: Carbon steel coil Q235B(ASTM GR·D,σs 230)

Width: 265mm-750mm

Thickness: 2.0mm-8.0mm

Coil ID:600-800mm

Coil OD: Max 2000mm

Coil Weight: 8t

3. Tube mill

Production Speed : 10-50 m/min

Production capacity: 30,000ton/year

Direction : left or right decided by customers.

Mill installed capacity : 280 kw

Line Area : 100m(length) ×9m (width)

Tube Bottom Passline (Above floor level) : 950 mm



Mill installed capacity : 350 kw

Line Area : 120m(length) ×10m (width)

Tube Bottom Passline (Above floor level) : 950 mm

HG Φ325 Mill Line

I. Brief introduction

HGΦ325 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 140mm-325mm in OD and 4.0mm-12.7mm in wall thickness, as well as corresponding square and rectangle tube.

II. Basic Technical Information:

1. Specification of pipes

Pipe OD: 140mm-325mm

Thickness: 4.0mm-12.7mm

Square & rectangle tube: 90mm×90mm – 250mm×250mm, Thickness: 4.0mm-12.0mm

Length: 6 -12m

Length Tolerance: ±3mm

2. Raw Material:

Material: Carbon steel coil Q235B(ASTM GR·D,σs 230)

Width: 360mm-1025mm

Thickness: 4.0mm-12.7mm

Coil ID:610-700mm

Coil OD: Max 2000mm

Coil Weight: 15t

3. Tube mill

Production Speed : 40m/min



3. Tube mill

Production Speed : 35 m/min

Production capacity: 120,000ton/year

Direction : left or right decided by customers.

Mill installed capacity : 580 kw

Line Area : 145m(length) ×13m (width)

Tube Bottom Passline (Above floor level) : 950 mm

HG Φ406 Mill Line

I. Brief introduction

HGΦ406 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 219mm-406mm in OD and 6.0mm-16.0mm in wall thickness.

II. Basic Technical Information:

1. Specification of pipes

Pipe OD: 219mm-406mm

Thickness: 6.0mm-16.0mm

Square & rectangle tube: 170mm×170mm – 330mm×330mm, Thickness: 6.0mm-15.0mm

Length: 6 -12m

Length Tolerance: ±3mm

2. Raw Material:

Material: Carbon steel coil

Width: 520mm-1340mm

Thickness: 6.0mm-16.0mm

Coil ID:580-760mm



Coil OD: Max 2300mm

Coil Weight: 35t

3. Tube mill

Production Speed : 30 m/min

Production capacity: 180,000ton/year

Direction : left or right decided by customers.

Mill installed capacity : 880 kw

Line Area : 160m(length) ×16m (width)

Tube Bottom Passline (Above floor level) : 1000mm

HG Φ508 Mill Line

I. Brief introduction

HGΦ508 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 273mm-508mm in OD and 6.0mm-18.0mm in wall thickness.

II. Basic Technical Information:

1. Specification of pipes

Pipe OD: 273mm-508mm

Thickness: 6.0mm-18.0mm

Length: 6 -12m

Length Tolerance: ±3mm

2. Raw Material:

Material: Carbon steel coil

Width: 680mm-1600mm

Thickness: 6.0mm-18.0mm



Coil ID:580-760mm

Coil OD: Max 2300mm

Coil Weight: 35t

3. Tube mill

Production Speed : 25 m/min

Production capacity:

Direction : left or right decided by customers.

Capacity : 140,000ton/year

Mill installed capacity : 1000 kw

Line Area : 300m(length) ×30m (width)

Tube Bottom Passline (Above floor level) : 1000 mm

HG Φ660 Mill Line

I.Brief introduction

HGΦ660 high frequency longitudinal welded pipe production line / pipe making machine / tube forming machine is designed to produce welded pipes of 325mm-660mm in OD and 6.0mm-20.0mm in wall thickness.

II. Basic Technical Information:

1.Specification of pipes

Pipe OD: 325mm-660mm

Thickness: 6.0mm-20.0mm

Length: 6 -12m

Length Tolerance: ±3mm

2.Raw Material:



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Material: Carbon steel coil Q235B(ASTM GR·D,σs 230)

Width: 860mm-2000mm Thickness: 6.0mm-20.0mm

Coil ID:580-760mm

Coil OD: Max 2300mm

Coil Weight: 40t

3. Tube mill

Production Speed : 20 m/min

Production capacity: 150,000ton/year

Direction : left or right decided by customers.

Mill installed capacity : 1200 kw

Line Area : 350m(length) ×35m (width)

Tube Bottom Passline (Above floor level) : 1000 mm

2, Abroach Cold Rolled Section Steel Production Line

It is specialized for cold rolled section steel with wide spread uses. It takes steel strip as raw material, produces cold rolled section steel by cold rolled section forming technology according to relevant request. This kind of technology is advanced and reliable, **PROFIBUS** technology is also adopted to the control system. All of these ensured highly synchronization accuracy and best product quality. All the indicators and operational costs are controlled at the lowest level, which is greatly rewarded by the pipe producers.

No.	Model	Size	Thickness	Roll	Forming	Installed
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			(mm)	Weight(mm)	Speed (m/min)	Capacity(kw)
1	LW200	20x20-50x50	1-3	5	20-80	900
2	LW600	60x60-150x150	2-7	10	20-60	1400
3	LW800	80x80-200x200	2.5-10	15	20-40	1600
4	LW1050	100x100-250x250	3-12.7	20	15-30	2600
5	LW1250	120x120-300x300	3-14	30	10-25	3200
6	LW1400	150x150-350x350	4-14	30	8-20	3600
7	LW1600	200x200-400x400	4-16	30	8-15	3900
8	LW2000	250x250-500x500	4-20	40	8-15	4200

3, Square to Square Welded Pipe Production Line

It is directly roll the steel strip and bend it to square & rectangular shape, then weld it to finish the formation.

Characteristics and Advantages:

- 1) Compared with round to square forming technology, square to square technology can make better shapes of angles for cross section, smaller semidiameter of inner arcis, flatter brim, regular outlooks
- 2) Ease more burden of the whole production line, especially for the sizing section.
- 3) 2.4-3% strip width shrinkage than round square forming method, so saving more raw materials
- 4) By advance multi-point bending, avoiding the axial force and side abrasion, reducing the forming step and ensuring the quality, meanwhile reducing power wastage and roll abrasion.



5) By combined rolls, one set mould can be used to produce lots of square and rectangular pipes for different specifications. This can decrease the storage of rolls, save 80% roll costs, fasten the bankroll turnover, shorten developing time for new lines.

No.	Model	Products Range	Thickness(mm)	Speed(m/min)	Installed capacity
1	LW600	60x60-150x150 70x50-200x100	1.5-8	20-70	900KW
2	LW800	70x70-200x200 90x50-250x150	2-10	20-60	1000KW
3	LW1000	90x90-250x250 120x60-300x200	3-12.7	15-50	1200KW
4	LW1200	120x120-300x300 140x100-400x200	4-14	10-40	1500KW
5	LW1600	170x170-400x400 200x150-500x300	4-16	10-30	1600KW
6	LW2000	200x200-500x500 250x150-600x400	4-20	8-20	2200KW

4, Multi-functional Production Line

This kind of mill can produce round pipe, square and rectangular pipe (direct to square or round to square) and some of abroad cold rolled section steel

1) ZTF Forming Technology Used In Produce Round Pipe

- Save 60% tooling cost



- Before the closed pore, one set of rolls can be used to produce lots of sized round pipe within the range. All the rolls before this section can be shared use and no need to change.
- Limite production time and labor cost
- Easy to restore rolls
- Convenient to restore and adjust.

2) Directly Square Forming Technics In Produce Square&Rectangular Pipe

- Compared with ared with round to square forming technology, square to square technology can make better shapes of angles for cross section, smaller semidiameter of inner arcis, flatter brim, regular outlooks.
- Ease more burden of the whole production line, especially for the sizing section.
- 2.4-3% strip width shrinkage than round square forming method, so saving more raw materials
- By advance multi-point bending, avoiding the axial force and side abrasion, reducing the forming step and ensuring the quality, meanwhile reducing power wastage and roll abrasion.
- By combined rolls, one set mould can be used to produce lots of square and rectangular pipes for different specifications. This can decrease the storage of rolls, save 80% roll costs, fasten the bankroll turnover, shorten developing time for new lines.

3) Produce Parts Of Abroach Cold Rolled Section Steel



Simple abroad cold rolled section steel such as directly formed channel steel, C shaped steel, Z shaped steel. The rolls can be basically shared with directly square forming technology.

5, Slitting Line

Slitting line is mainly used to slit kinds of wide steel strip into certain width, then recoil them to meet the request of various procedure for welded pipe and cold rolled section steel.

No.	Model	Roll Width(mm)	Thickness(mm)	Cutting Speed(m/min)	Installed Capacity(kw)
1	ZJ100	500-1000	0.18-1.5	80-100	100
2	ZJ125	900-1250	0.5-2	50-90	150
3	ZJ150	1000-1500	1.8-4	40-80	175
4	ZJ160	1000-1600	2-6	30-70	200
5	ZJ160A	1000-1600	4-10	20-70	480
6	ZJ160B	1000-1600	4-12.7	20-60	550
7	ZJ180C	1000-1800	5-14	15-60	600
8	ZJ200	1200-2000	6-16	12-50	650

6, Rolls And Other Auxiliary Equipments