

## **Multi-functional Production Line for Cold Rolled Section Steel/Welded Pipe**

One set of machine can produce round pipe, square&rectangular pipe (directly square or round to square) and parts of abroad cold rolled section steel.

### **1、 ZTF forming method in producing round pipe:**

- 1) Save 60% charge on rolls reserve;
- 2) Before the closed pore, one set of rolls can be used to produce any size of round pipe within the range. Only the rolls after closed pore need to be replaced;
- 3) Reduce production time;
- 4) Easier to restore rolls;
- 5) Convenient to restore and adjust.

### **2、 Directly square forming technology in producing square&rectangular pipes:**

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

Characteristics&Advantages:

- 1) Compared with round to square forming method, this method can make:  
better shape of angles for cross section, smaller semidiameter of inner arcs,

flatter brim, regular outlook;

- 2) Low load for the whole line, especially in the sizing part;
- 3) 2.4-3% strip width shrinkage than round square forming method, so that to save raw materials;
- 4) By advanced 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 can be used to produce lots of square&rectangular pipes with different specifications, This can decrease the storage of rolls, lower 80% roll cost, fast the bankroll turnover, shorten developing time for new lines.

### **3、 Produce parts of abroach cold rolled section steel:**

Simple abroach cold rolled section steel such as directly formed channel steel, C shape steel, Z shape steel. The rolls can be basically shared with directly square forming method.