

## **Square to Square Welded Pipe Production Line**

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

Charateristics&Advantages:

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

## Technical Specifications

No.	Model.	Production Range	Thickness (mm)	Forming Speed (m/min)	Total Power (kw)
1	LW600	60x60~150x150; 70x50~200x100	1.5~8	20~70	900
2	LW800	70x70~200x200; 90x50~250x150	2~10	20~60	1000
3	LW1000	90x90~250x250; 120x60~300x200	3~12.7	15~50	1200
4	LW1200	120x120~300x300; 140x100~400x200	4~14	10~40	1500
5	LW1600	170x170~400x400; 200x150~500x300	4~16	10~30	1800
6	LW2000	200x200~500x500; 250x150~600x400	4~20	8~20	2200