

Longitudinal Process Flowchart 20" - 56" /508 - 1422 mm/

1. Infeed of plates Identity check



2. Milling of longitudinal plate edges



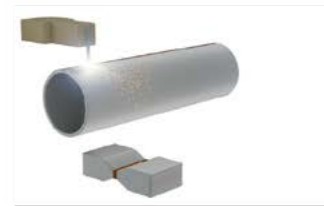
3. Forming by the 3-roll bending process



4. Post-bending of the longitudinal plate edges



5. Tack welding



6. Inside welding



7. Outside welding



8. Visual control



9. UT of weld



10. X-ray testing of weld seam



11. Mechanical expanding



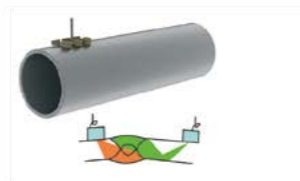
12. Grinding of weld at pipe ends and beveling



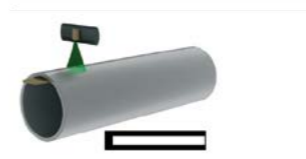
13. Hydrostatic testing



14. UT of weld seam



15. X-ray testing of weld seam and pipe ends



16. Magnetic particle and ultrasonic inspection of both pipe ends



17. Inspection, weighing, marking, stamping



18. Storage

