

## Data Sheet

Reference No.:44195

## Tube Welding Line

Brand: DEMAG  
 Model:  
 YoM, approx.: 1988 used  
 Reconditioned:2022  
 Controls: PLC programabilno upravljanje SIEMENS



### Feedstock Steel Strip

sheet width max.:	450 mm
sheet width min.:	90 mm
sheet thickness max.:	13 mm
sheet thickness min.:	2 mm
exterior coil diameter max.:	1900 mm
exterior coil diameter min.:	1100 mm
internal coil diameter max.:	760 mm
internal coil diameter min.:	610 mm

### Product (profile, tube)

external diameter min.:	30 mm
external diameter max.:	140 mm
wall thickness min.:	2 mm
wall thickness max.:	12 mm
length min.:	4000 mm
length max.:	10000 mm

### Line Characteristics

Forming Process: rollforming  
 welding process: HF inductive  
 sawing process: travelling  
 speed max.: 65 m/min  
 feedstock transport direction: left to right

### Additional Information:

Line consists of:  
 - Strip preparation MANNESMANN (YoM 1988, Retrofit 2022, Siemens S7-1500)  
 - Blasting system GF HB-4/45-100 (YoM 1987, Retrofit 2021, Siemens S7-1200)  
 - Core unit DEMAG RN140/170-L (YoM 1987, Retrofit 2012 Siemens S7-300/1200)  
 - Roller press WINTER RATINGEN (YoM 1989)  
 - Hot saw BENTELER (YoM 1988, Retrofit 2010, Siemens S7-300)  
 - FollowUp processing MANNESMANN (YoM 1989, Siemens S5)  
 - Baling press BOECKER VOLKENBORN SR800 (YoM 1988)

Line Specifications:

- Strip types: slit strip, cold strip
- max. yield strength: 650N/mm<sup>2</sup>
- max. tensile strength: 720N/mm<sup>2</sup>
- Belt sabre: 0.6% permissible deviation in relation to belt length
- alignment: center-line

#### Strip Preparation MANNESMANN:

- Twin decoiler incl. guide, shear, submerged arc welding system, strip loop
- 2022 Retrofit control system to Siemens S7-1500

#### Blasting System GF HB-4/45-100:

- 2022 Retrofit control system to Siemens S7-1200

#### Core Unit DEMAG RN140/170-L (forming unit, welding machine and calibrating unit):

- 2013-2022 various modernizations of the electrical engineering
- 2013 Renewal of HF generator Elotherm Eloweld 700
- 2012 pre-forming frames renewed
- 2011 roll forming unit renewed
- 2009 New emulsion system with Cymatec CN-5-50 magnetic separator
- Wall thickness range:
  - s = 2.0 - 12.7 mm, s/d = 1 : 7 to 1 : 70, yield strength max. 300 N/mm<sup>2</sup>
  - s = 2.0 - 10.0 mm, s/d = 1 : 8 to 1 : 60, yield strength max. 450 N/mm<sup>2</sup>
  - s = 2.0 - 9.0 mm, s/d = 1 : 9 to 1 : 50, yield strength max. 550 N/mm<sup>2</sup>
  - s = 2.0 - 8.5 mm, s/d = 1 : 10 to 1 : 40, yield strength max. 600 N/mm<sup>2</sup>
  - s = 2.0 - 8.0 mm, s/d = 1 : 10 to 1 : 35, yield strength max. 650 N/mm<sup>2</sup>
- max. HF power: 600 kW

#### Roller Press WINTER RATINGE:

- Force: 400 kN
- Stroke: 1000 mm

#### Hot Saw BENTELER:

- 2010 New protective cabin incl. air filter
- 2008 Retrofit control system to Siemens S7-300

- incl. Standby Saw Slide (BackUp, see ph

Further processing MANNESMANN:  
 - incl. Milt chamfering system and Allweile system

- 2016 Retrofit chip shredder
- Speed of end machining heads: 135-130
- Diameter of small prism clamping basin:
- Diameter of large prism clamping basin:

### Seller:

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**Photos & Documents**

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Bandanlage Übersicht



Bandanlage Hinten



Haspel



Bandanlage Ende



Bandanlage Übersicht 2



Band Stoss schweißen