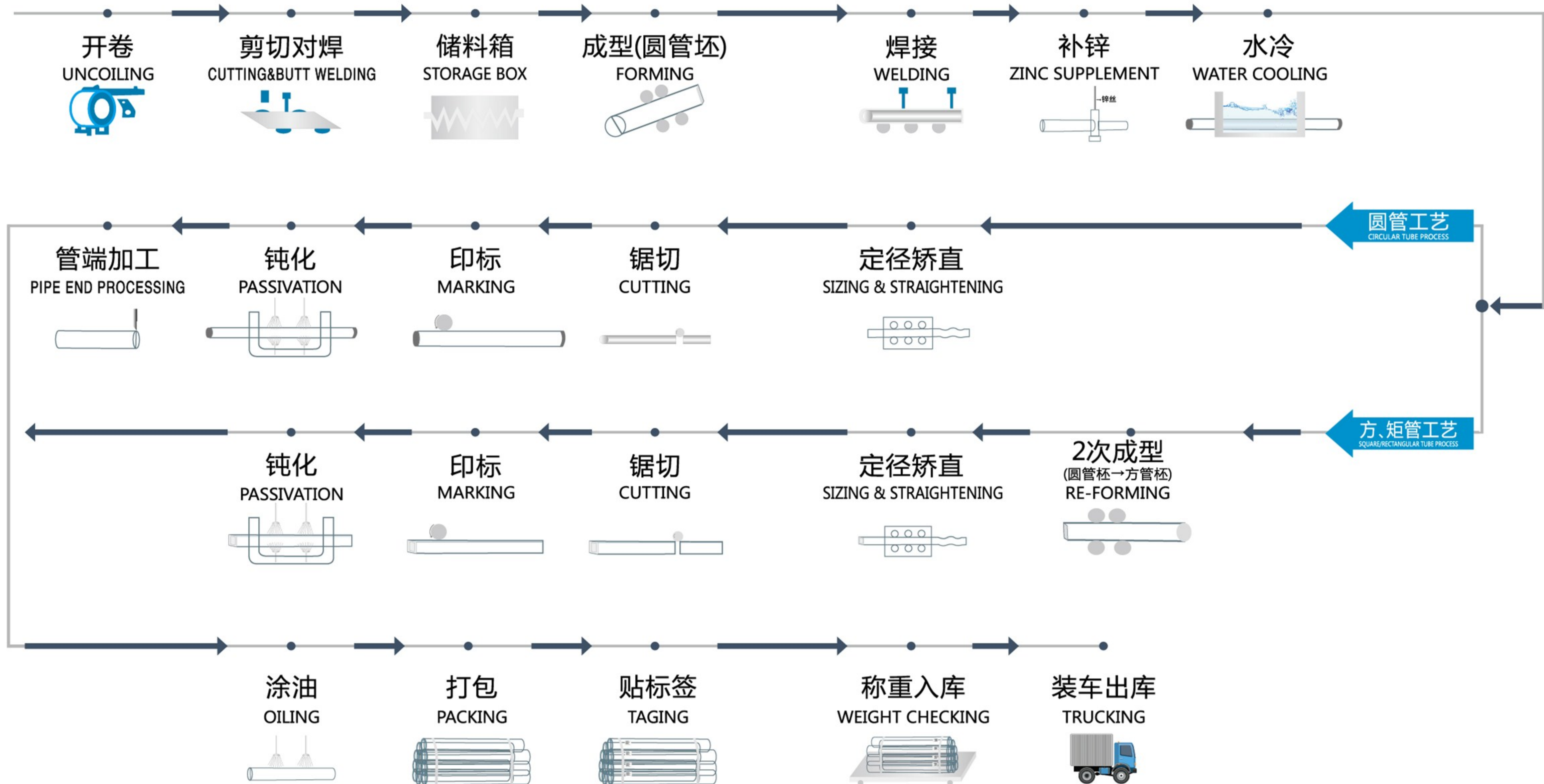


生产工艺流程 | PRODUCTION PROCESS FLOW CHART



DJJ-500金属带材对接机

DJJ-500 metal strip docking machine

核心参数及参数说明: Core parameters and parameter description:
 带材宽度 ≤500mm Strip width ≤500mm
 带材厚度: 0.5-4.0mm Strip thickness: 0.5-4.0mm
 焊接速度: 75-350mm/min Welding speed: 75-350mm / min

作用:
 焊接质量好、强度高、速度快,保障生产线连续生产

effect:
 Welding quality, high strength, speed, guarantee continuous production line



DJJ-500金属带材对接机

高频焊管机组

High Frequency Welded Pipe Unit

核心参数及参数说明: Core parameters and parameter description:
 成品管外径: 19-219mm Finished tube diameter: 19-219mm
 成品管壁厚: 0.8-12.7mm Finished wall thickness: 0.8-12.7mm
 成型速度: 20-130mm Forming speed: 20-130mm

作用:
 利用高效电流的集肤效应和邻近效应,在挤压辊挤压下进行焊合,是制管生产线的核心设备

effect:
 Efficient use of current skin effect and proximity effect, be welded in squeezing rollers squeeze under, is the core pipe production line



高频焊管机组



伺服电机锯切装置

Servo motor cutting device

核心参数及参数说明: Core parameters and parameter description:
 定尺精度: ±3mm Length accuracy: ± 3mm
 适应管速: Max130m/min Adaptation tube speed: Max130m / min

作用:
 满足顾客各种定尺长度的订单要求

effect:
 Various cut lengths to meet customer order requirements



伺服电机锯切装置

钝化液自动喷涂系统

Passivation solution automatic spraying system

核心参数及参数说明: Core parameters and parameter description:
 对钢管表面进行360度全面喷涂,达到均匀覆盖的效果
 On the steel surface 360-degree spray, to achieve uniform coverage results

作用:
 实现产品表面防腐能力的关键设备(公司已申请发明专利)

effect:
 And product surface corrosion resistance of key equipment (the company has applied for special invention)



钝化液自动喷涂系统

管端加工装置

Pipe end processing apparatus

核心参数及参数说明: Core parameters and parameter description:
 采用3块分布均匀的高合金刀头对钢端进行处理,适用于外径19-219mm高频直缝焊管
 Using three evenly distributed high-alloy steel head end processing for the outer diameter of 19-219mm ERW

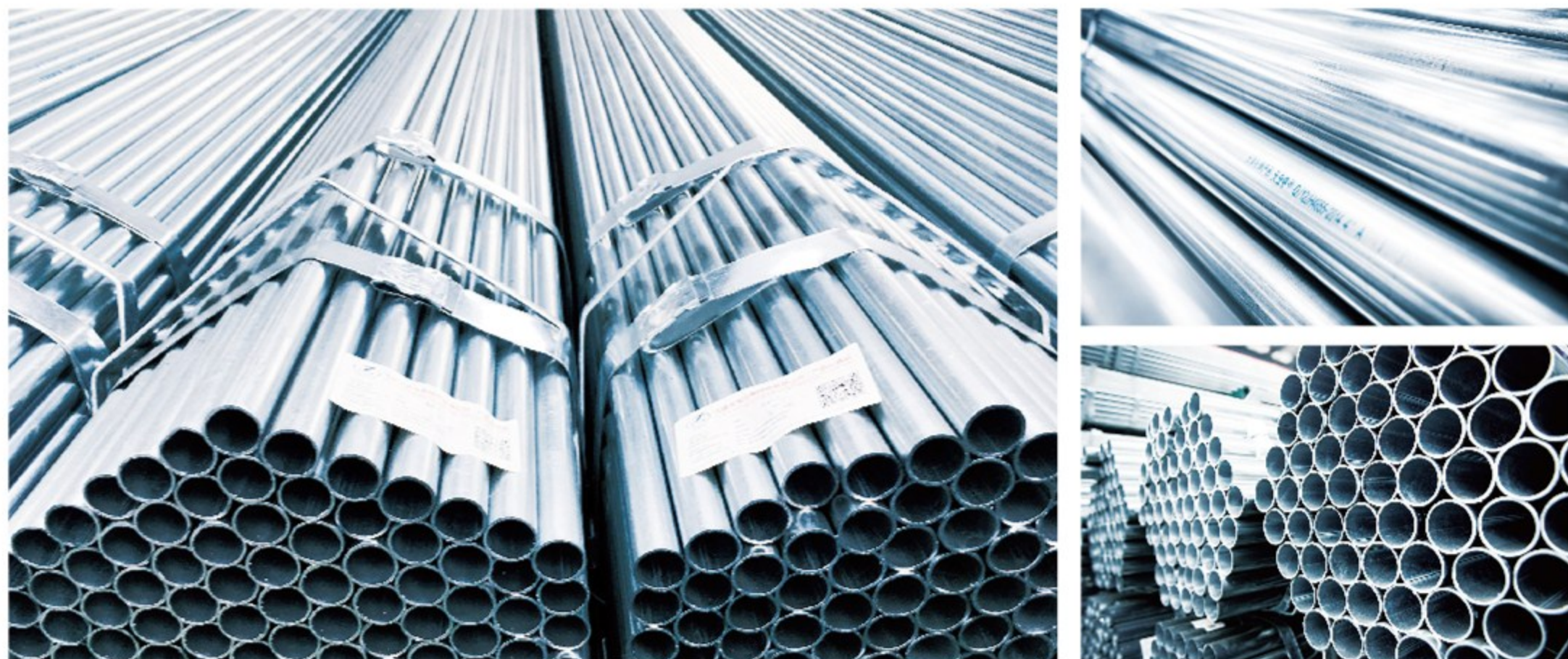
作用:
 该装置为产品后续精加工装置,可对管口进行平整、钝头、倒角处理

effect:
 The device is a follow-up product finishing device, the nozzle can be smooth, blunt, chamfered



管端加工装置

执行标准：Q/12JH4855-2014 | Executive Standard: Q / 12JH4855-2014



牌号	外径 (mm)		普通钢管 (mm)					
	公称尺寸	外径公差	壁厚	壁厚公差	圆度公差	弯曲公差	长度	长度公差
Q195 Q215 Q235	20	±0.5	0.7-2.2	±10%S	≤0.5	≤2mm/m	4000-8000	+20,-0
	25	±0.5	0.7-2.2	±10%S	≤0.5	≤2mm/m	4000-8000	+20,-0
	25.4	±0.5	0.7-2.2	±10%S	≤0.5	≤2mm/m	4000-8000	+20,-0
	32	±0.5	0.8-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	40	±0.5	0.8-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	42	±0.5	0.8-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	47	±0.5	0.9-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	48.3	±0.5	0.9-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	59	±1.0	0.9-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	60.3	±1.0	0.9-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	75	±1.0	0.9-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	87	±1.0	0.9-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0
	112	±1.0	0.9-2.3	±10%S	≤0.5	≤2mm/m	5000-10000	+20,-0

牌号	外径 (mm)		普通钢管 (mm)					
	公称尺寸	外径公差	壁厚	壁厚公差	圆度公差	弯曲公差	长度	长度公差
Q195 Q215 Q235	20	±0.3	0.7-2.2	±0.03	≤0.2	≤2mm/m	4000-8000	+10,-0
	25	±0.3	0.7-2.2	±0.03	≤0.2	≤2mm/m	4000-8000	+10,-0
	25.4	±0.3	0.7-2.2	±0.03	≤0.2	≤2mm/m	4000-8000	+10,-0
	32	±0.3	0.8-2.3	±0.03	≤0.2	≤2mm/m	5000-10000	+10,-0
	40	±0.3	0.8-2.3	±0.03	≤0.2	≤2mm/m	5000-10000	+10,-0
	42	±0.3	0.8-2.3	±0.03	≤0.2	≤2mm/m	5000-10000	+10,-0
	47	±0.3	0.9-2.3	±0.03	≤0.3	≤2mm/m	5000-10000	+10,-0
	48.3	±0.3	0.9-2.3	±0.03	≤0.3	≤2mm/m	5000-10000	+10,-0
	59	±0.5	0.9-2.3	±0.03	≤0.3	≤2mm/m	5000-10000	+10,-0
	60.3	±0.5	0.9-2.3	±0.03	≤0.3	≤2mm/m	5000-10000	+10,-0
	75	±0.5	0.9-2.3	±0.03	≤0.4	≤2mm/m	5000-10000	+10,-0
	87	±0.5	0.9-2.3	±0.03	≤0.4	≤2mm/m	5000-10000	+10,-0
	112	±0.5	0.9-2.3	±0.03	≤0.4	≤2mm/m	5000-10000	+10,-0

执行标准: Q/12JH5081-2014 | Executive Standard: Q / 12JH5081-2014



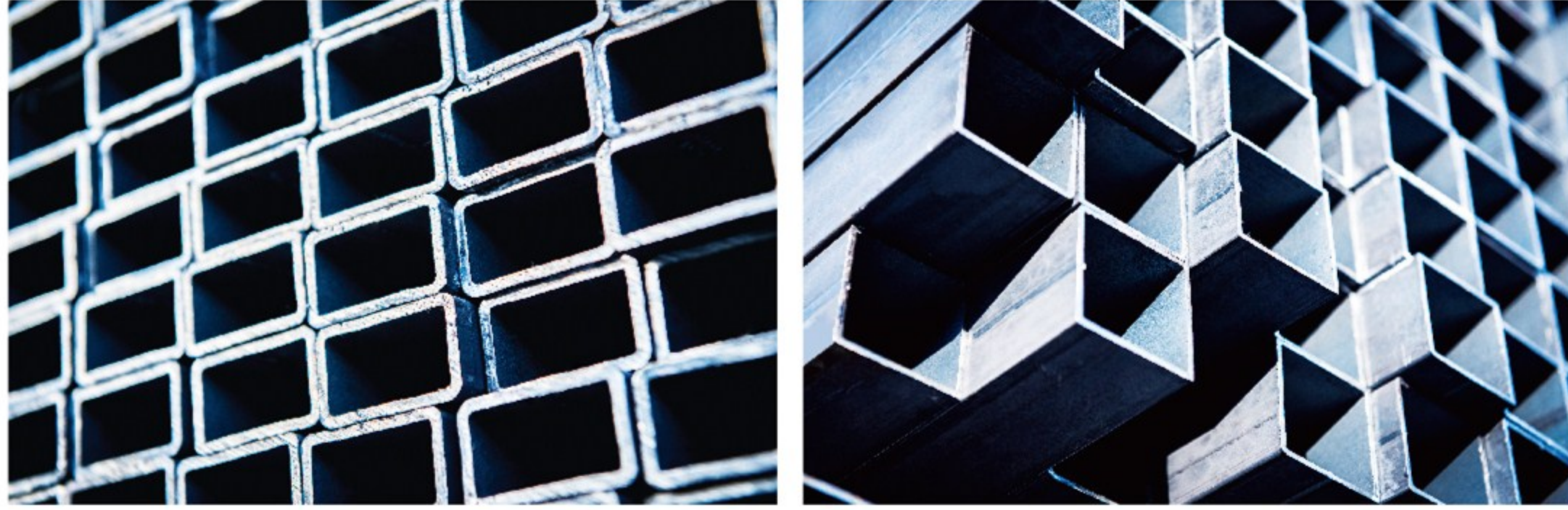
牌号	边长 (mm)		普通钢管 (mm)						
	公称尺寸	边长公差	壁厚	弯曲公差	外圆弧半径	平面凹凸度	长度	长度公差	
Q195 Q215 Q235	16	16	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	19	19	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	20	20	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	20	40	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	25	25	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	25	50	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	25	75	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	30	30	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	30	40	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	30	50	+0.4,-0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	32	32	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	35	35	±0.5	0.7-2.2	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	37	57	+0.4,-0.5	0.8-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	37	77	±0.5	0.8-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	38	38	+0.4,-0.5	0.8-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	38	75	+0.5,-0.6	1.0-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	50	75	+0.5,-0.6	1.0-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	40	40	+0.4,-0.5	0.8-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	40	60	±0.5	0.8-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
	50	50	±0.5	1.0-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0
40	80	+0.5,-0.6	1.0-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0	
50	75	+0.5,-0.6	1.0-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0	
60	60	+0.5,-0.6	1.0-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0	
50	100	±0.7	1.0-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0	
50	150	±0.8	1.0-2.3	≤2mm/m	1.0-2.5t	≤0.6%h/b	4000-10000	+20,-0	

牌号	边长 (mm)		普通钢管 (mm)						
	公称尺寸	边长公差	壁厚	弯曲公差	外圆弧半径	平面凹凸度	长度	长度公差	
Q195	16	16	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	19	19	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	20	20	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	20	40	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	25	25	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	25	50	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	25	75	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	30	30	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	30	40	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	30	50	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	32	32	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	35	35	±0.4	0.7-2.2	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	37	57	±0.4	0.8-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	37	77	±0.4	0.8-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	38	38	±0.4	0.8-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
Q215	38	75	+0.4,-0.5	1.0-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	50	75	+0.4,-0.5	1.0-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	40	40	±0.4	0.8-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	40	60	±0.4	0.8-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	50	50	±0.4	1.0-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	40	80	+0.4,-0.5	1.0-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	50	75	+0.4,-0.5	1.0-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	60	60	+0.4,-0.5	1.0-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	50	100	±0.6	1.0-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0
	50	150	±0.7	1.0-2.3	≤2mm/m	0.9-2.2t	≤0.5%h/b	4000-10000	+10,-0

冷成型焊接结构空心型材—方、矩管 | COLD FORMED WELDED STRUCTURAL HOLLOW SECTIONS - SQUARE, RECTANGULAR TUBES

执行标准：BS EN-10219-2006 GB/T6728-2002

Implementation of the standards: BS EN-10219-2006 GB / T6728-2002



牌号	规格mm		壁厚、区间	理论重量	规格mm		壁厚、区间	理论重量
	H	B	t/mm	M/(kg/m)	H	B	t/mm	M/(kg/m)
S235JRH S275J0H S275J2H S355J0H S355J2H S355K2H Q235B Q345B	20	20	1.2	0.679	20	30	1.5	1.06
			1.5	0.826			1.75	1.22
			1.75	0.941			2	1.36
			2.0	1.05			2.5	1.64
	25	25	1.2	0.867	20	40	1.5	1.30
			1.5	1.061			1.75	1.49
			1.75	1.215			2	1.68
			2.0	1.363			2.5	2.03
	30	30	1.5	1.296	25	40	1.5	1.41
			1.8	1.49			1.75	1.63
			2.0	1.677			2	1.83
			2.5	2.032			2.5	2.23
	40	40	3.0	2.361	30	40	3	2.60
			1.5	1.767			1.5	1.53
			1.75	2.039			1.75	1.77
			2.0	2.305			2	1.99
	50	50	2.5	2.817	25	50	2.5	1.42
			3.0	3.303			3	2.83
			4.0	4.198			—	—
			1.5	2.238			1.5	1.65
	60	50	1.75	2.589	30	50	1.75	1.90
			2.0	2.933			2	2.15
			2.5	3.602			2.5	2.62
			3.0	4.245			3	3.07
	80	80	4.0	5.454	40	50	—	—
			2.0	3.56			1.5	1.767
			2.5	4.387			1.75	2.039
			3.0	5.187			2	2.305
		4.0	6.71			2.5	2.817	
		5.0	8.129			3	3.303	
		2.5	5.957			1.5	2.003	
		3.0	7.071			1.75	2.314	
		4.0	9.222			2	2.619	
		5.0	11.269			3	3.775	
		—	—			4	4.826	
		—	—			—	—	

牌号	规格mm		壁厚、区间	理论重量	规格mm		壁厚、区间	理论重量
	H	B	t/mm	M/(kg/m)	H	B	t/mm	M/(kg/m)
S235JRH S275J0H S275J2H S355J0H S355J2H S355K2H Q235B Q345B	90	90	3.0	8.013	30	60	2	2.620
			4.0	10.478			2.5	3.209
			5.0	12.839			3	3.774
			6.0	15.097			4	4.826
	100	100	4.0	11.734	40	60	2	2.934
			5.0	14.409			2.5	3.602
			6.0	16.981			3	4.245
			—	—			4	5.451
	120	120	4.0	14.246	50	70	2	3.562
			5.0	17.549			3	5.187
			6.0	20.749			4	6.710
			8.0	26.84			5	8.129
	150	150	4.0	18.014	40	80	2	3.561
			5.0	22.26			2.5	4.387
			6.0	26.402			3	5.187
			8.0	33.945			4	6.710
	180	180	—	—	50	100	5	8.129
			4.0	21.800			3	6.690
			5.0	27.000			4	8.594
			6.0	32.100			5	10.484
	200	200	8.0	41.500	60	120	—	—
			4.0	24.30			3	8.013
			5.0	30.10			4	10.478
			6.0	35.80			5	12.839
	250	250	8.0	46.50	100	150	6	15.097
			10.0	57.00			—	—
			5.0	38.00			4	14.874
			6.0	45.20			5	18.334
300	300	8.0	59.10	150	200	6	21.691	
		10.0	72.70			8	28.096	
		12.0	84.80			—	—	
		6.0	54.70			4	21.2	
		8.0	71.60			5	26.2	
		10.0	88.40			6	31.1	
		12.0	104.00			8	40.2	
		—	—			—	—	

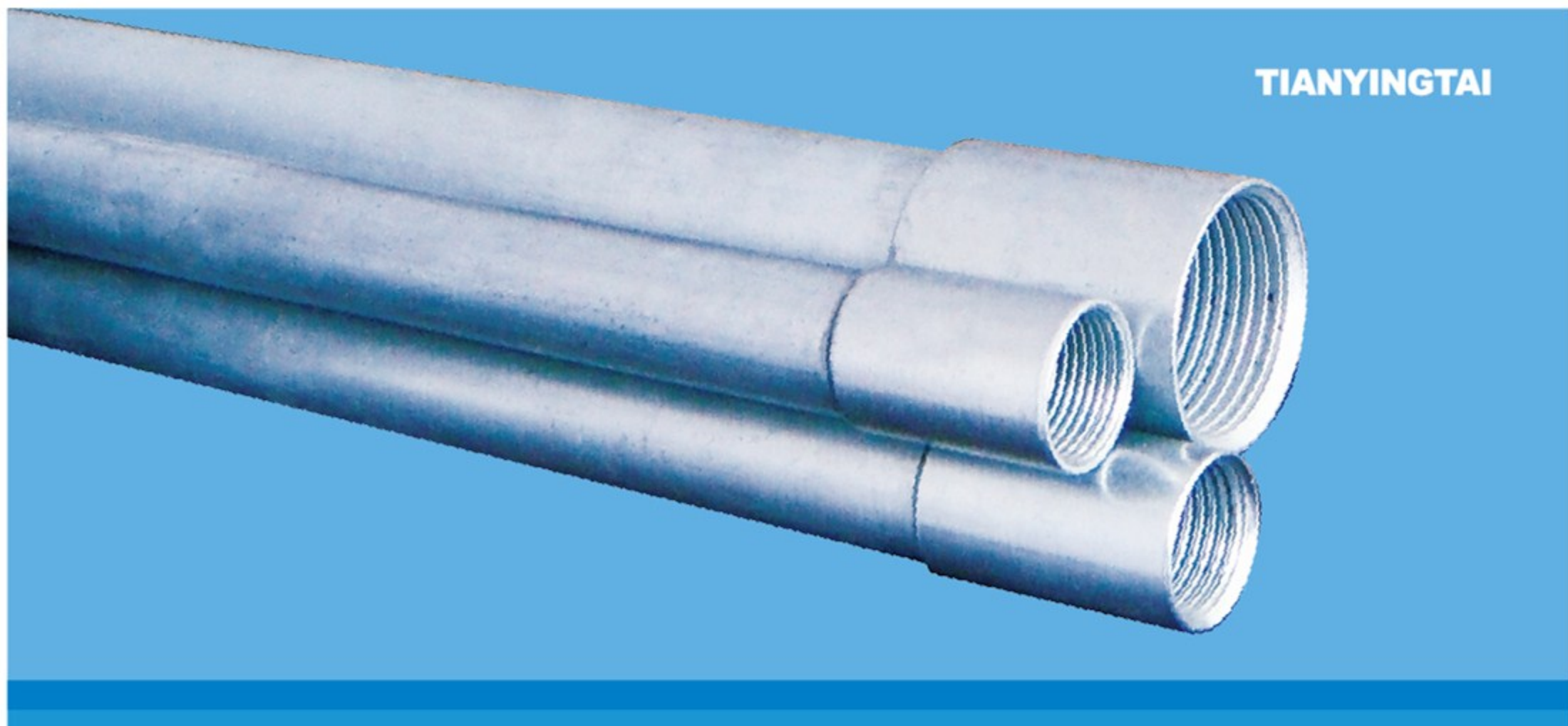
执行标准: ASTM A53/A53M-2012 | Executive Standard: ASTM A53 / A53M-2012



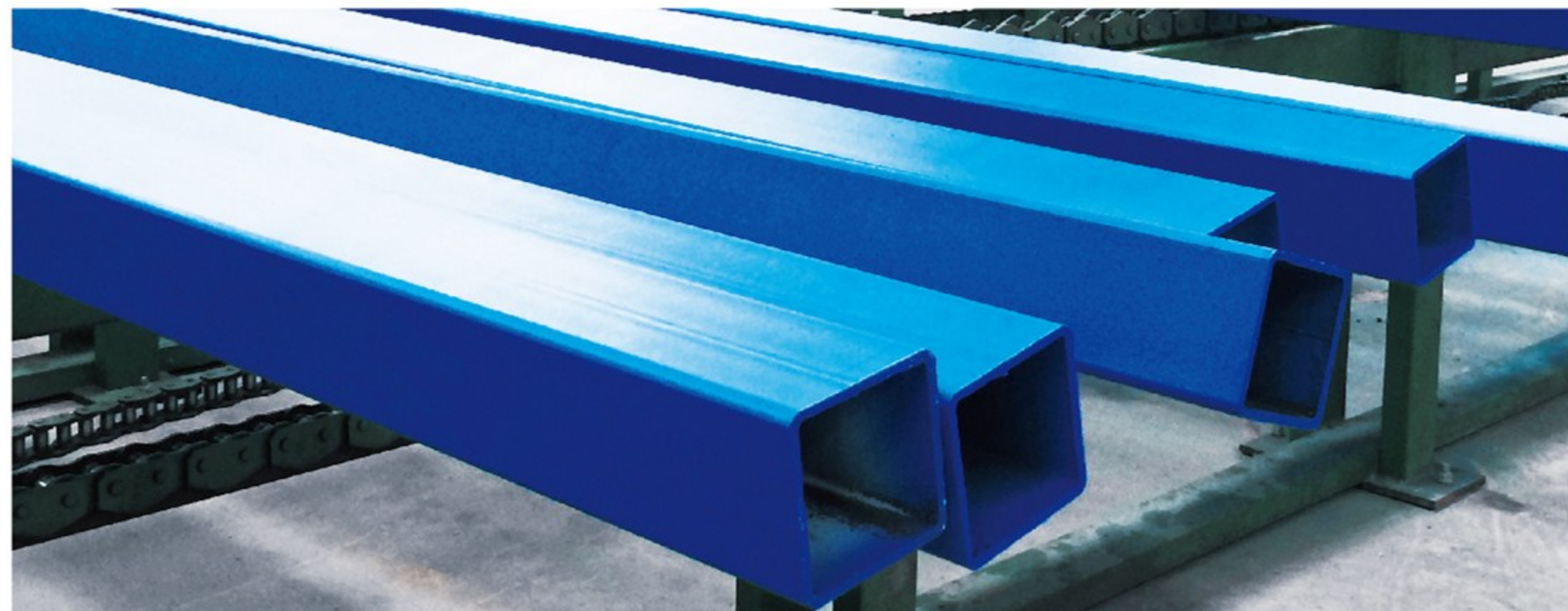
NPS	DN	外径 mm	壁厚 mm	公称重量 lb/ft(kg/m)	重量偏差	试验压力kpa	
						A级	B级
1/2	15	21.3	2.77	1.27	±10%	4900	4900
			3.73	1.62	±10%	6000	6000
3/4	20	26.7	2.87	1.69	±10%	4900	4900
			3.91	2.20	±10%	6000	6000
1	25	33.4	3.38	2.50	±10%	4900	4900
			4.55	3.24	±10%	6000	6000
1-1/2	32	42.2	3.56	3.39	±10%	8400	9100
			4.85	4.47	±10%	12500	13200
1-1/4	40	48.3	3.68	4.05	±10%	8400	9100
			5.08	5.41	±10%	12500	13200
2	50	60.3	3.91	5.44	±10%	16000	17300
			5.54	7.48	±10%	17300	17300
2-1/2	65	73.0	5.16	8.63	±10%	17300	17300
			7.01	11.41	±10%	17300	17300
3	80	88.9	3.18	6.72	±10%	9000	1100
			3.96	8.29	±10%	11100	13000
			4.78	9.92	±10%	13430	15700
			5.49	11.29	±10%	15400	17300
			6.35	12.93	±10%	17300	17300
			7.14	14.40	±10%	17300	17300
			7.62	15.27	±10%	17300	17300

NPS	DN	外径 mm	壁厚 mm	公称重量 lb/ft(kg/m)	重量偏差	试验压力kpa	
						A级	B级
4	100	114.3	3.18	8.71	±10%	7000	8200
			3.96	10.78	±10%	8700	10200
			4.78	12.91	±10%	10400	12200
			5.56	14.91	±10%	12200	14200
			6.02	16.07	±10%	13200	15300
			6.35	16.90	±10%	13900	16200
			7.14	18.87	±10%	15200	18200
			7.92	20.78	±10%	17300	19400
			8.56	22.32	±10%	18700	19400
60	150	168.3	4.78	19.27	±10%	7100	8300
			5.56	22.31	±10%	8300	9700
			6.35	25.36	±10%	9500	11000
			7.11	28.26	±10%	10600	12400
			7.92	31.32	±10%	11800	13800
			8.74	34.39	±10%	13000	15100
			9.52	37.28	±10%	14200	16500
8	200	219.1	10.97	42.56	±10%	16300	19000
			4.78	25.26	±10%	5500	6400
			5.16	27.22	±10%	6000	6000
			5.56	29.28	±10%	6400	7500
			6.35	33.31	±10%	7300	8500
			7.04	36.31	±10%	7900	9400
			7.92	41.24	±10%	9100	10600
			8.18	42.55	±10%	9300	10900
			8.74	45.34	±10%	10000	11700
			9.52	49.20	±10%	10900	12700
			10.31	53.08	±10%	11800	13900
11.13	57.08	±10%	12700	14800			
12.7	64.64	±10%	14500	16900			

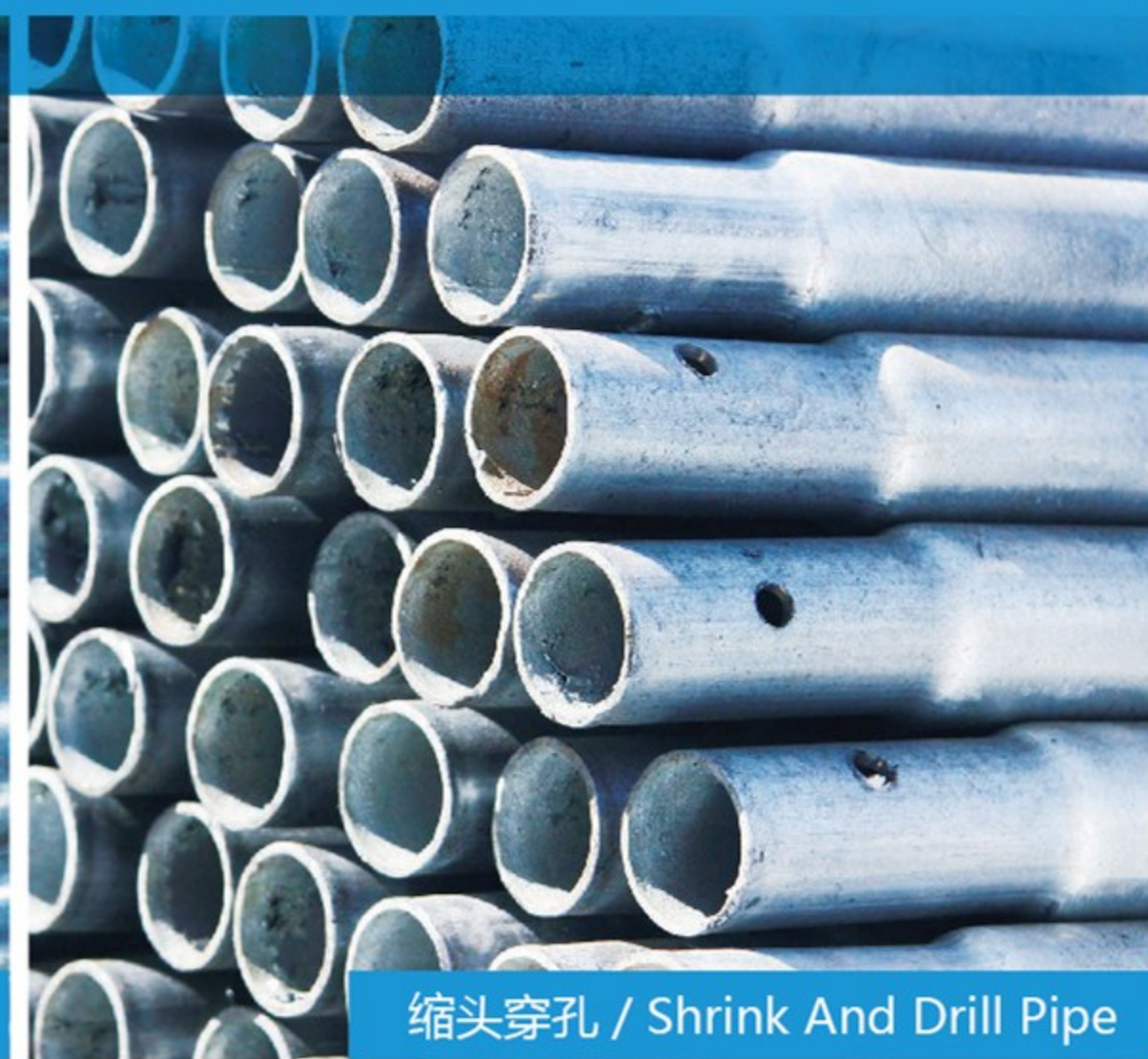
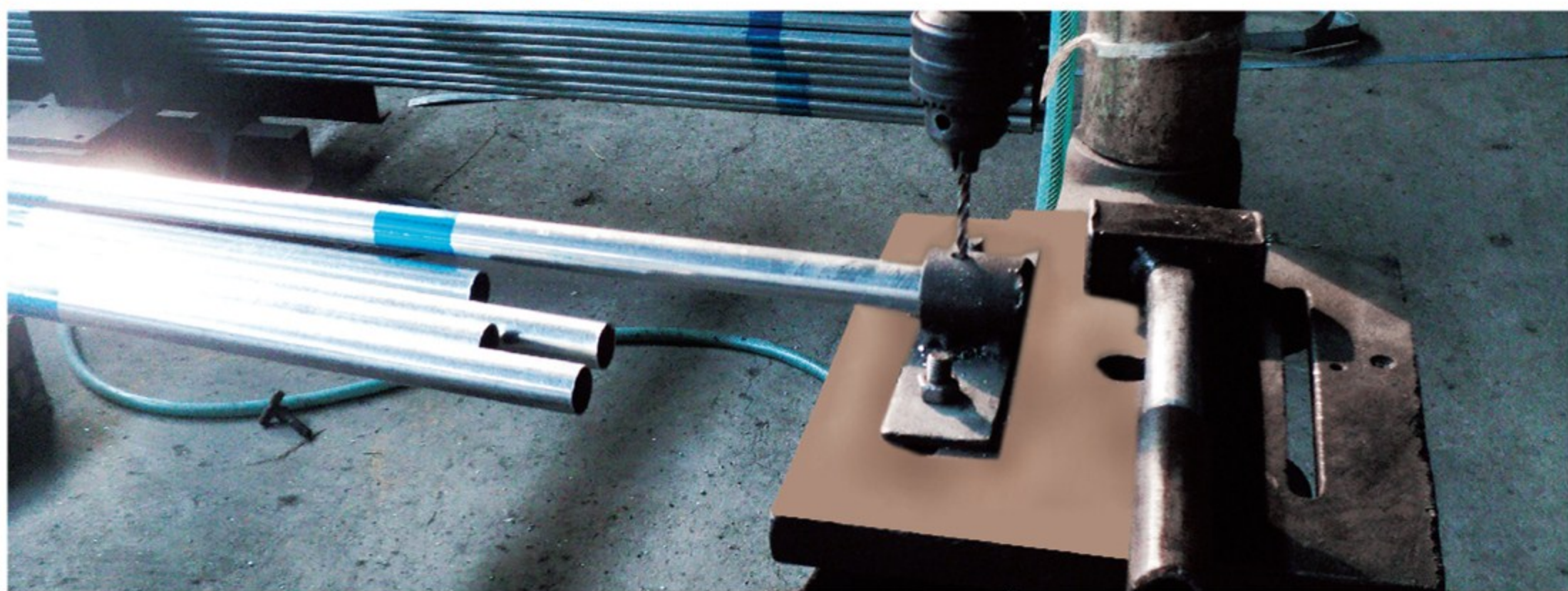
管箍套丝 / Thread Pipes



喷漆 / Painted Pipe



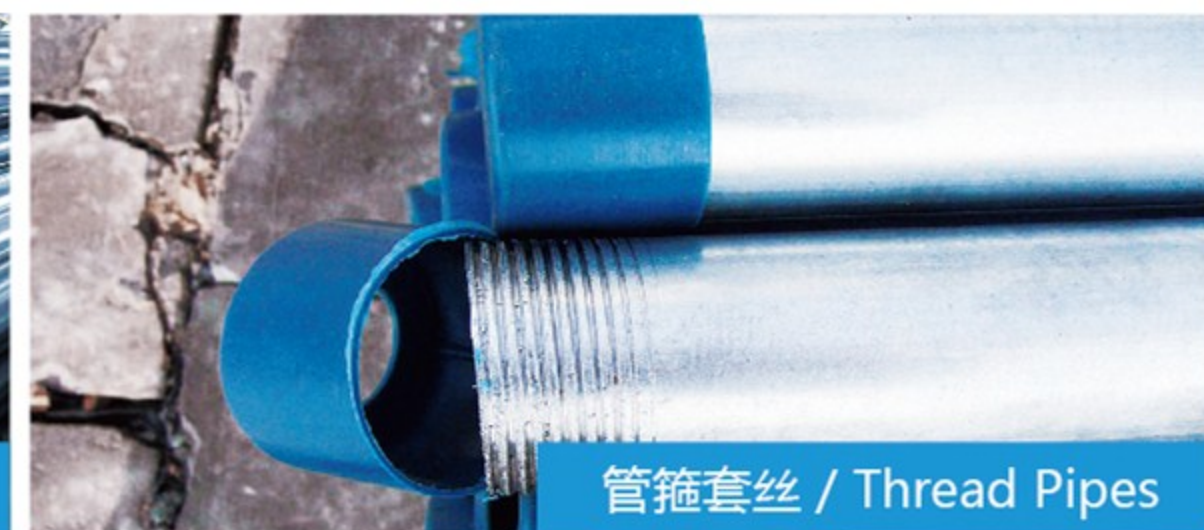
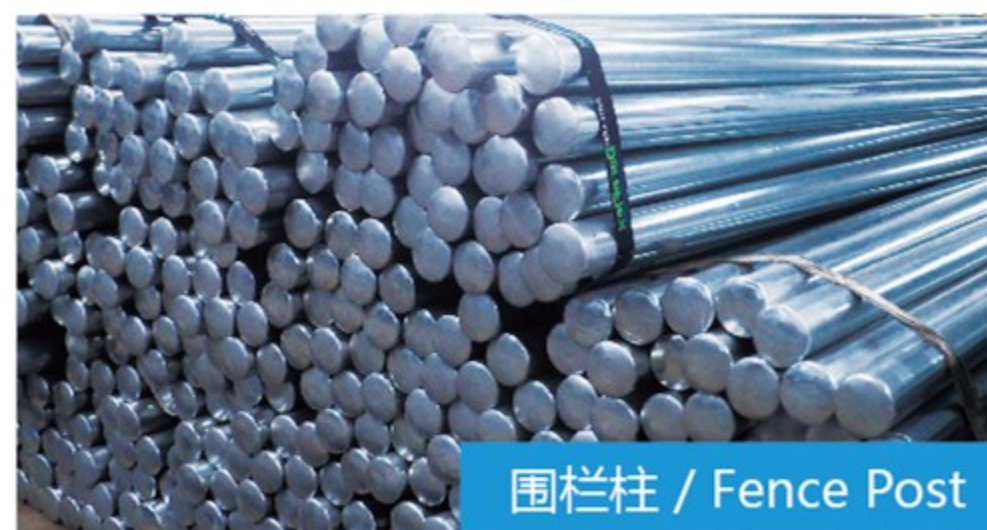
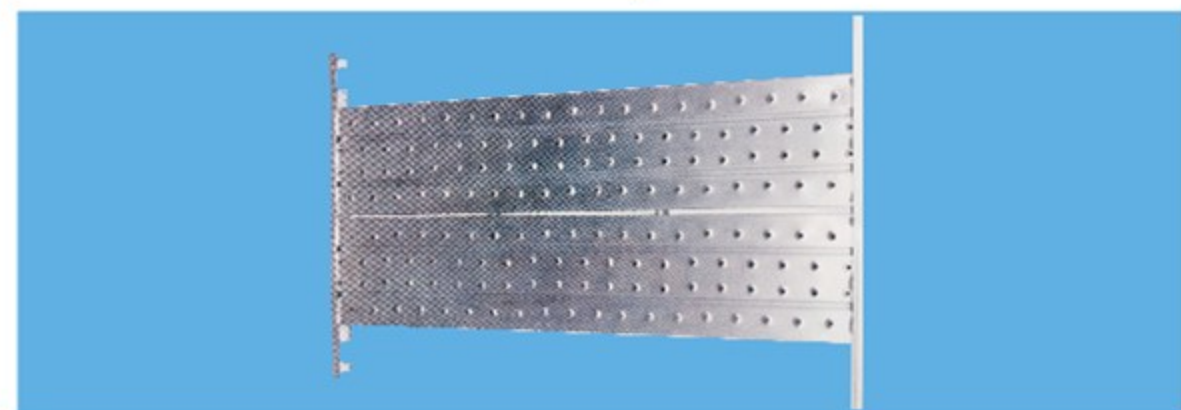
穿眼 / Drill And Blue Belt Pipe



管箍套丝 / Thread Pipes



镀锌带脚踏板 /



应用领域 | APPLICATIONS

APPLICATIONS



温室大棚建设
Greenhouse Construction

脚手架配件
Scaffolding Accessories

体育器材
Sports Equipment

光伏支架
PV Mounting

基础建筑
Building the foundation

高速围栏
High-speed rail

