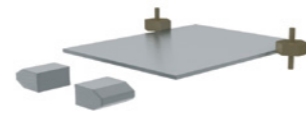


Longitudinal Process Flowchart 20" - 56" / 508 - 1422 mm/

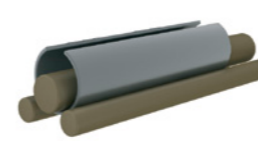
1. Infeed of plates Identity check



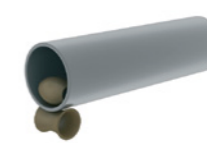
2. Milling of longitudinal plate edges



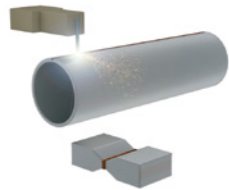
3. Forming by the 3-roll bending process



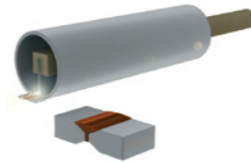
4. Post-bending of the longitudinal plate edges



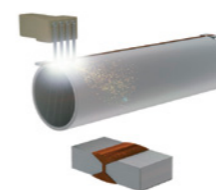
5. Tack welding



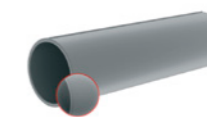
6. Inside welding



7. Outside welding



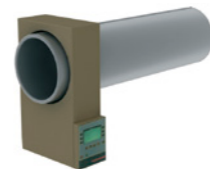
8. Visual control



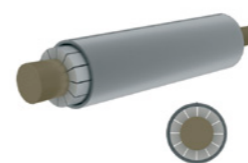
9. US testing of weld



10. X-ray testing of weld seam



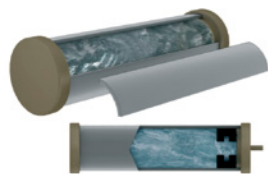
11. Mechanical expanding



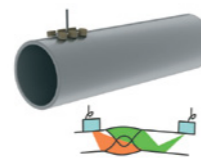
12. Grinding of weld at pipe ends and beveling



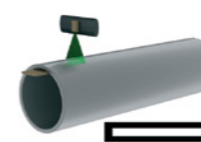
13. Hydrostatic testing



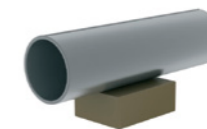
14. US testing of weld seam



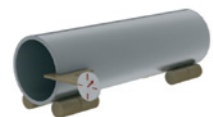
15. X-ray testing of weld seam and pipe ends



16. Magnetic particle and ultrasonic inspection of both pipe ends



17. Inspection, weighing, marking, stamping



18. Storage

