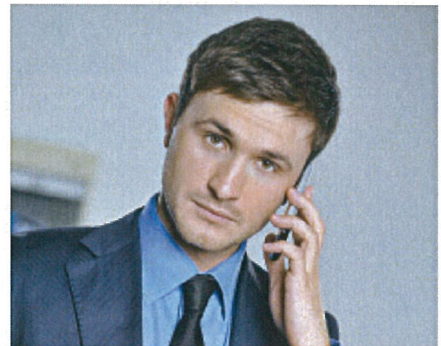
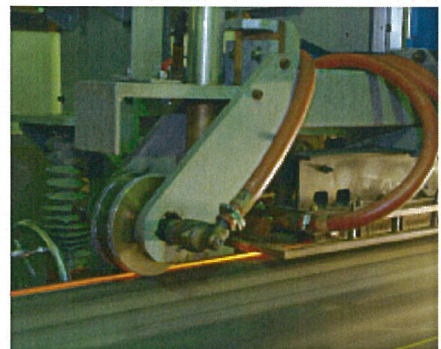
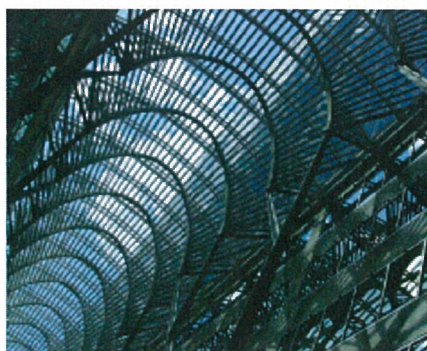




Pipes for industrial application



Expert solutions for general engineering



1**SEAMLESS PIPES**

GOST 8731-74, GOST 8732-78
GOST 8733-74, GOST 8734-75
GOST 30563-98, DSTU 3666-97

Hot-rolled seamless steel tubes

Cold-formed seamless steel tubes

Seamless cold-worked tubes of carbon and alloy-steel with special properties

GOST 30564-98, DSTU 3667-97

Seamless hot-worked tubes of carbon and alloy-free steel with special properties

TU 14-3-1128-2000, TU 14-3-1128:2005

Steel seamless hot-worked tubes for gas pipelines of gas-lifting systems and natural gas-field facilities construction

API Spec 5

Pipes for pipelines

DIN 2440

Medium-weight threaded steel tubes

DIN 2441

Heavy-weight threaded steel tubes

DIN EN 10255

Unalloyed steel tubes suitable for welding and threading

NF A 49-112

Plain-end hot-rolled seamless tubes with specified room temperature properties and special delivery conditions

NF A 49-115

Hot finished seamless steel tubes suitable for threading

EN 10297-1, EN 10220

Circular steel tubes for mechanical structures and general machine-building

EN 10210-1, EN 10210-2

Hot finished structural hollow sections of non-alloy and fine-grain steels

DIN 1629, EN 10220 DIN 1630, EN 10220 7

Seamless circular unalloyed steel tubes subject to special requirements

High-performance seamless circular unalloyed steel pipes

2**SEAMLESS STEEL TUBES FOR OPERATING UNDER PRESSURE**

EN 10216-1, EN 10220

Unalloyed steel tubes with specified room temperature properties

ASTM A 106/A106M, ANSI/ASME B36.10M

Seamless carbon steel pipes for high-temperature service tools

3**WELDED PIPES**

GOST 10705-80, GOST 10704-91	ERW longitudinally welded steel tubes
GOST 10706-76, GOST 10704-91	SAW longitudinally welded steel tubes
GOST 8639-82, GOST 13663-86	Square section steel tubes
GOST 8645-68, GOST 13663-86	Rectangular section steel tubes
GOST 3262-75	Water and gas line steel pipes
GOST 20295-85	Steel welded tubes for gas and oil main pipelines
TU U 14-8-19-99	Steel welded longitudinal tubes for gas oil main pipelines
TU U 14-8-20-99	Steel welded longitudinal tubes for gas and oil main pipelines
TU 14-3-377-99	Steel welded longitudinal tubes for gas and oil main pipelines
TY Y 14-8-32-2000	Steel welded longitudinal tubes of low-alloy steel of conventional purpose
TU 14-3-1948-2000	Steel welded longitudinal tubes for gas and oil main pipelines of low-alloy steel
TY Y 27.2-05393139.10-2001	Steel electric-welded shaped tubes
API 5L	Pipes for pipelines
EN 10208-1, EN 10208-2	Welded steel pipes for oil and gas pipelines
EN 10219-1, EN 10219-2	Welded structural hollow sections for metal structures
EN 10217-1	Unalloyed steel tubes with specified room temperature properties
EN 10217-2	Unalloyed steel tubes with specified high temperature properties
ASTM A 53/A 53M, ANSI/ASME B36.10M	Hot-dipped zinc-coated and black welded and seamless pipes

4**POLYETHYLENE COATED PIPES**

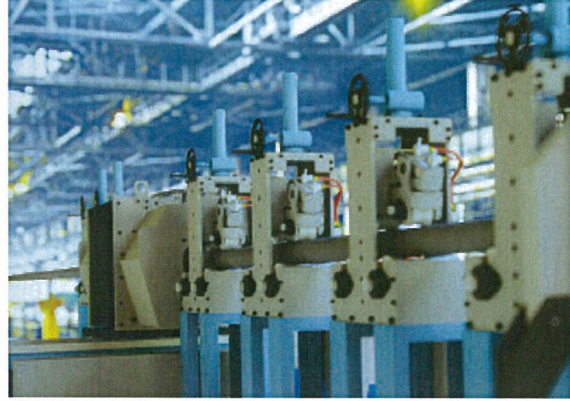
TU U 27.2-05393139-017:2008	Steel tubes of 159-530 mm in diameter with external protecting coating extrude polyethylene oriented Steel welded longitudinal tubes with a diameter 159-530 mm
TU U 27.2-05393139-018:2008	external anticorrosive polyethylene coating for main oil and gas pipeline
DIN 30670	Polyethylene coating on steel tubes and fittings

QUALITY-FOCUSED OPERATIONS

Interpipe considers quality control as a key part of the activities to manufacture products, exceeding customer needs. Quality control is implemented at all stages of production process - starting from continuous casting at the in-house mini mill and up to nondestructive testing of pipe body and pipe ends and shipping to customers.

Our commitment to quality is confirmed by:

- Pipe products certification in compliance with major international standards API 5CT, API 5L, EN (DIN), ASTM, JIS, GOST and customer specifications
- Quality management system as per ISO 9001 and API Q1
- Application of high-integrity nondestructive testing techniques to ensure body and ends' quality
- Implementation of a continuous improvement system at the Company mills
- Effectively operating customer reclamation system



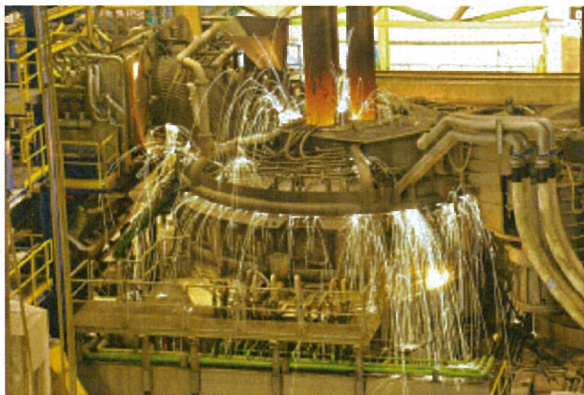
Ongoing investments program

In our business, investments play a crucial role in making decisions on the Company's future. Interpipe regularly invests in development of its production capacities, improvement of the output quality, and expansion of its product range. Currently we are carrying out a major investment program that will reinforce the Company's vertical integration, boost our capacity in production of high quality products, and enhance our operating efficiency in pipe and wheel production.

Interpipe EAF steel making plant

In 2012 Interpipe will commission a new state-of-the-art electric steel making facility, called Dneprosteel. The mill production capacity amounts to 1.32 mln. tons of round steel billets a year. When completed, this will be the largest facility of its kind in Ukraine and Eastern Europe. This new facility will provide Company's mills with high quality steel billets for the production of seamless pipes and railway wheels.

Our mini-mill employs state-of-the-art technologies, developed and supplied by Danieli Company from Italy, to provide the consistent steel production with different steel grades - from carbon to low-alloy ones.



MANUFACTURING OF SEAMLESS PIPES



1
Billet incoming inspection



2
Billet weighing



3
Billet cutting



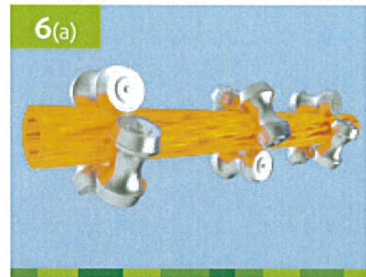
4
Heating of billet in rotary furnace



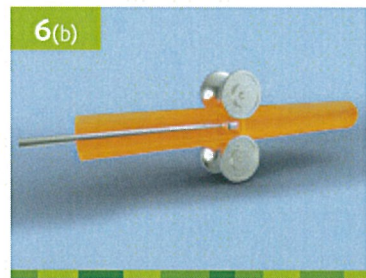
5(a)
Piercing of billet at piercing press



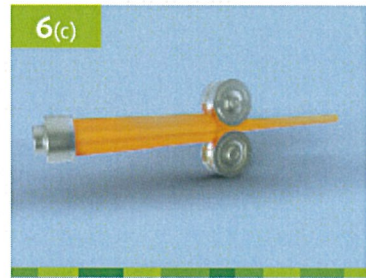
5(b)
Piercing of billet at cross-roll piercer



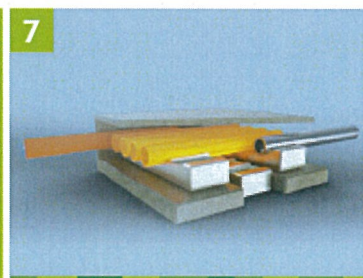
6(a)
Shell rolling at continuous rolling mill



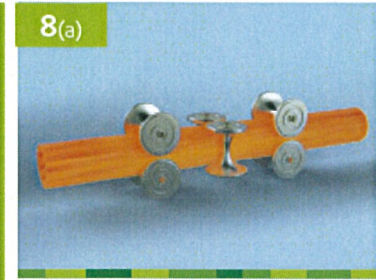
6(b)
Shell rolling at plug mill



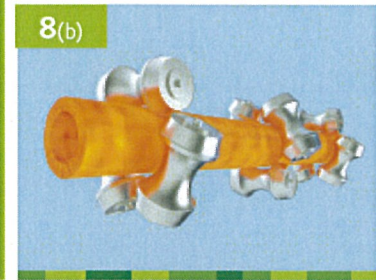
6(c)
Shell rolling at pilger mill



7
Heating of pipes



Sizing



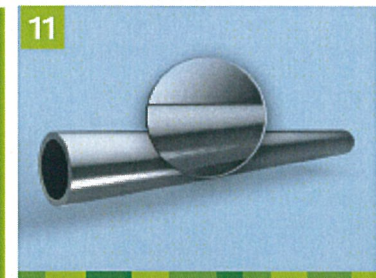
Stretch reducing



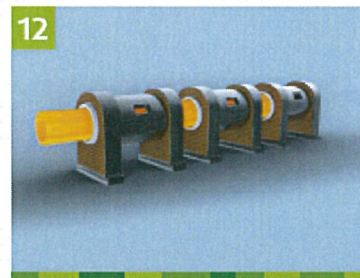
Pipes cooling



Straightening of pipes



Visual inspection



Heating of pipes for quenching



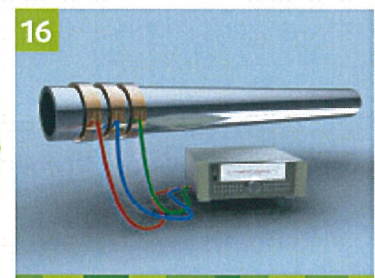
Quenching



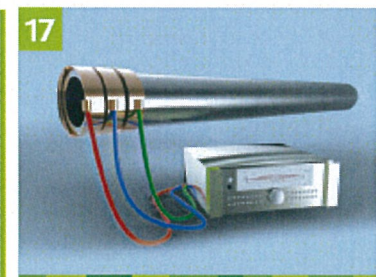
Tempering



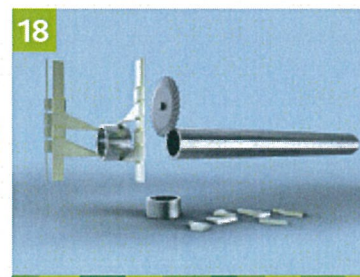
Warm straightening



Nondestructive control of pipe body



NDT of pipe ends



Sampling for mechanical tests and chemical composition analysis

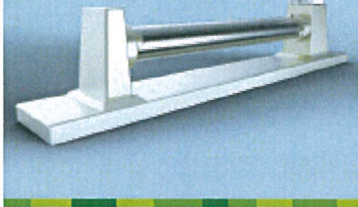
FINISHING OF PLAIN END PIPES

19



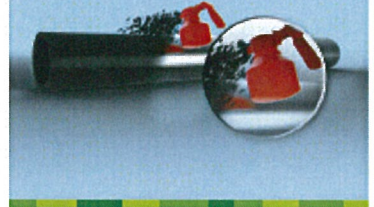
Beveling

20



Hydraulic pressure test

21



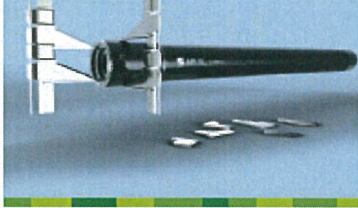
Painting of pipes

22



Marking

23



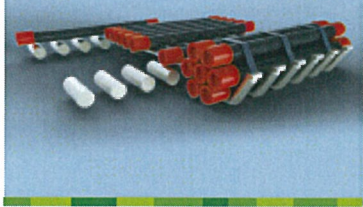
Final inspection

24



Bevel protection

25



Bundling

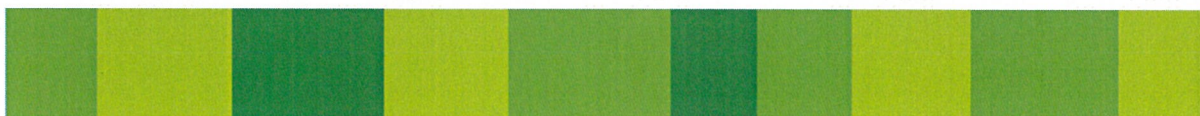
Hot-dipped zinc-coated and black welded and seamless pipes

ASTM A 53/A 53M, ANSI/ASME B36.10M

Application: for producing steam, water, gas and air pipelines.

Dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class*
	inches	mm	inches	mm	lb/ft	kg/m	
2	2.375	60,3	0.141	3,58	3.36	5,01	STD
			0.154	3,91	3.66	5,44	
3	3.500	88,9	0.125	3,18	4.51	6,72	
			0.141	3,58	5.06	7,53	
			0.156	3,96	5.58	8,29	
			0.172	4,37	6.11	9,11	
3 ½	4.000	101,6	0.125	3,18	5.17	7,72	
			0.156	3,96	6.41	9,53	
			0.172	4,37	7.03	10,48	
4	4.500	114,3	0.125	3,18	5.84	8,71	
			0.156	3,96	7.24	10,78	
			0.172	4,37	7.95	11,85	
8	8.625	219,1	0.203	5,16	18.26	27,22	
			0.219	5,56	19.66	29,28	
			0.250	6,35	22.36	33,31	
			0.277	7,04	24.70	36,81	
			0.312	7,92	27.70	41,24	
			0.322	8,18	28.55	42,55	
10	10.750	273	0.203	5,16	22.87	34,09	STD
			0.219	5,56	24.63	36,68	
			0.250	6,35	28.04	41,77	
			0.279	7,09	31.20	46,51	
			0.307	7,8	34.24	51,03	
			0.365	9,27	40.48	60,31	
12	12.750	323,8	0.219	5,56	29.31	43,65	
			0.250	6,35	33.38	49,73	
			0.281	7,14	37.42	55,77	
			0.312	7,92	41.45	61,71	
			0.330	8,38	43.77	65,2	
			0.344	8,74	45.58	67,93	
			0.375	9,53	49.56	73,88	
			0.406	10,31	53.52	79,73	
14	14.000	355,6	0.219	5,56	32.23	47,99	
			0.250	6,35	36.71	54,69	
			0.281	7,14	41.17	61,35	
			0.312	7,92	45.61	67,9	
			0.344	8,74	50.17	74,76	
			0.375	9,53	54.57	81,33	
			0.406	10,31	58.94	87,79	



Dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class*
	inches	mm	inches	mm	lb/ft	kg/m	
16	16.000	406,4	0.219	5,56	36.94	54,86	
			0.250	6,35	42.05	62,64	
			0.281	7,14	47.17	70,3	
			0.312	7,92	52.27	77,83	
			0.344	8,74	57.52	85,71	
			0.375	9,52	62.58	93,27	STD
			0.406	10,31	67.62	100,70	
20	20.000	508	0.250	6,35	52.78	78,55	
			0.281	7,14	59.23	88,19	
			0.312	7,92	65.66	97,67	
			0.344	8,74	72.28	107,60	
			0.375	9,52	78.87	117,02	STD
			0.406	10,31	84.96	126,53	

Pipes supplied are black (non-zinc-coated) and non-threaded.

* STD - standard weight class

XS - extra- standard weight class (high durability)

XXS - double extra-standard weight class (doubled durability)

Lengths supplied:

- From 20 ft up to 40 ft (from 6,0 up to 12,0 m).

Steel hardness:

Steel grades	Chemical compound according to
A, B	ASTM A53

Obligatory requirements:

- Carrying out chemical composition control;
- Carrying out hydraulic pressure or non-destructive testing;
- Carrying out hydraulic pressure testing or weld's quality non-destructive control (for welded pipes);
- Carrying out bending impact test (for pipes with nominal diameter less or equal to 2 inches);
- Carrying out flattening test (for pipes with nominal diameter more than 2 inches);
- Chamfering (for pipes with outside diameter no less than 60,3 mm and with wall thickness no less than 5 mm, unless other one is stipulated by the contract).

Upon customer's request it is possible to carry out:

- Non-destructive testing.



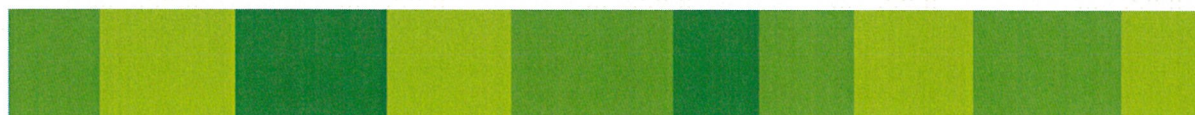
Seamless carbon steel pipes for high-temperature service tools

ASTM A 106/A106M, ANSI/ASME B36.10M

Application: for producing structures, as well as for steam, water, gas and air pipelines, and also in general machine-building and tool-making.

Dimensions and weight for Hot-rolled

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class*
	inches	mm	inches	mm	lb/ft	kg/m	
1	1.315	33,4	0.133	3,38	1.68	2,50	STD
1 ¼	1.660	42,2	0.140	3,56	2.27	3,39	STD
1 ½	1.900	48,3	0.125	3,18*	2.37	3,54	
			0.145	3,68	2.72	4,05	STD
2	2.375	60,3	0.141	3,58	3.36	5,01	
			0.154	3,91	3.66	5,44	STD
			0.172	4,37*	4.05	6,03	
			0.188	4,78*	4.39	6,54	
2 ½	2.875	73	0.218	5,54*	5.03	7,48	XS
			0.141	3,58	4.12	6,13	
			0.156	3,96	4.53	6,74	
			0.172	4,37	4.97	7,40	
			0.188	4,78	5.40	8,04	
			0.203	5,16	5.80	8,63	STD
			0.216	5,49	6.13	9,14	
3	3.500	88,9	0.250	6,35	7.01	10,44	
			0.276	7,01	7.67	11,41	XS
			0.141	3,58	5.06	7,53	
			0.156	3,96	5.58	8,29	
			0.172	4,37	6.11	9,11	
			0.188	4,78	6.66	9,92	
			0.216	5,49	7.58	11,29	STD
			0.250	6,35	8.69	12,93	
3 ½	4.000	101,6	0.281	7,14	9.67	14,40	
			0.300	7,62	10.26	15,27	XS
			0.438	11,13	14.32	21,35	
			0.600	15,24	18.60	27,68	XXS
			0.156	3,96	6.41	9,53	
			0.172	4,37	7.03	10,48	
			0.188	4,78	7.66	11,41	
4	4.500	114,3	0.226	5,74	9.12	13,57	STD
			0.250	6,35	10.02	14,92	
			0.281	7,14	11.17	16,63	
			0.318	8,08	12.52	18,63	XS
			0.156	3,96*	7.24	10,78	
			0.172	4,37	7.95	11,85	
			0.188	4,78	8.67	12,91	
			0.203	5,16	9.32	13,89	
			0.219	5,56	10.02	14,91	
			0.237	6,02	10.80	16,07	STD
0.250	6,35	11.36	16,90				
0.281	7,14	12.67	18,87				
0.337	8,56	14.98	22,32	XS			
0.438	11,13	19.00	28,32				
0.531	13,49	22.51	33,54				
0.674	17,12	27.57	41,03	XXS			



Dimensions and weight for Hot-rolled

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class*
	inches	mm	inches	mm	lb/ft	kg/m	
5	5.563	141,3	0.258	6,55	14.62	21,77	STD
			0.375	9,53	20.78	30,97	XS
			0.500	12,70	27.04	40,28	
			0.625	15,88	32.96	49,11	
			0.750	19,05	38.59	57,43	XXS
6	6.625	168,3	0.250	6,35	17.04	25,36	
			0.280	7,11	18.97	28,26	STD
			0.312	7,92	21.04	31,32	
			0.344	8,74	23.08	34,39	
			0.375	9,53	25.03	37,28	
			0.432	10,97	28.57	42,56	XS
			0.500	12,70	32.74	48,73	
			0.562	14,27	36.39	54,20	
			0.625	15,88	40.09	59,69	
			0.719	18,26	45.35	67,56	
			0.750	19,05	47.10	70,12	
0.864	21,95	53.21	79,22	XXS			
0.875	22,23	53.73	80,07				
8	8.625	219,1	0.250	6,35*	22.38	33,32	
			0.277	7,04	24.70	36,81	
			0.312	7,92	27.70	41,24	
			0.322	8,18	28.55	42,55	STD
			0.344	8,74	30.42	45,34	
			0.375	9,53	33.04	49,25	
			0.406	10,31	35.64	53,08	
			0.438	11,13	38.30	57,08	
			0.500	12,70	43.39	64,64	XS
			0.562	14,27	48.44	72,08	
			0.594	15,09	50.95	75,92	
			0.625	15,88	53.45	79,59	
			0.719	18,26	60.71	90,44	
			0.750	19,05	63.14	93,98	
			0.812	20,62	67.76	100,92	
			0.875	22,23	72.42	107,92	XXS
0.906	23,01	74.69	111,27				
10	10.750	273	0.344	8,74	38.23	56,98	
			0.365	9,27	40.48	60,31	STD
			0.438	11,13	48.28	71,88	
			0.500	12,70	54.74	81,55	XS
			0.562	14,27	61.21	91,05	
			0.594	15,09	64.43	96,01	
			0.625	15,88	67.65	100,69	
			0.719	18,26	77.03	114,70	
			0.812	20,62	86.26	128,34	
			0.844	21,44	89.29	133,09	
			0.875	22,23	92.28	137,52	
			0.938	23,83	98.30	146,48	
			1.000	25,40	104.13	155,15	XXS
1.125	28,58*	115.64	172,33				

Dimensions and weight for Hot-rolled

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class*
	inches	mm	inches	mm	lb/ft	kg/m	
12	12.750	323,8	0.344	8,74*	45.58	67,93	
			0.375	9,53	49.56	73,88	STD
			0.406	10,31	53.52	79,73	
			0.438	11,13	57.59	85,84	
			0.500	12,70	65.42	97,46	XS
			0.562	14,27	73.15	108,92	
			0.625	15,88	81.01	120,59	
			0.688	17,48	88.63	132,04	
			0.750	19,05	95.21	143,17	
			0.812	20,62	103.63	154,17	
			0.844	21,44	107.32	159,86	
			0.875	22,23	110.97	165,37	
			0.983	23,83	118.33	176,33	
			1.000	25,40	125.49	186,97	XXS
			14	14.000	355,6	0.344	8,74*
0.375	9,53	54.57				81,33	STD
0.438	11,13	63.44				94,55	
0.594	15,09	85.05				126,71	
0.750	19,05	106.13				158,10	

*Carbon steel grade pipes of thickness wall is possible to supplied upon agreement without ultrasonic control.

STD – standard weight class

XS – extra- standard weight class (high durability)

XXS – double extra-standard weight class (doubled durability)

Lengths supplied:

- From 20 ft up to 40 ft (from 6, 0 up to 12, 0);
- Without any other notation Pipes are produced:
 - Solitary (SRL) - 4, 8 – 6,7m (16-22 ft) up to 5% of pipes upon order, length 3, 7 -4, 8 m (12-16 ft);
 - Double (DRL) – not less than 6,7 m (22 ft), middle size of pipes no lees than 10,7 m (35 ft), up to 5 % of pipes upon order, length 4,8 -6,7 m (16-22 ft).

Steel hardness:

Steel grades	Chemical compound according to
A, B, C	ASTM A106/A106M

Obligatory requirements:

- Carrying out hydraulic pressure or non-destructive testing;
- Carrying out flattening test
- Chamfering (for pipes with outside diameter no less than 60,3 mm and with wall thickness no less than 5 mm), unless other one is stipulated by the contract.

Upon customer's request it is possible to carry out:

- Non-destructive testing;
- Pipes supplying without hydraulic pressure and non- destructive testing.

