



API - 5L Steel Line Pipe



BBJ PIPE
INDUSTRIES (PVT) LTD

Working for a better tomorrow



API LINE PIPES



BBJ Pipe is a well known and prestigious manufacturing unit in Oil & Gas sector having accreditation of American Petroleum Institute API-5L along with ISO 9001:2008 certification. BBJ Pipe Japanese design Pipe mills are equipped with Solid-State/High Frequency Welders. The steel line pipe is manufactured in accordance with the specification of API-5L latest edition, ASTM A-53 (2002) and BS standards etc. The steel line pipe is available from ½" to 12" diameter, with wall thickness upto 9.0 mm.

MANUFACTURING PROCESS

Slitting

High quality coils are slitted to the required dimensions.

End Shearing & Welding

Both ends of strip are sheared and welded into a single endless piece and then stored in the looper/hoop cage

Uncoiler/Storage Section

Slitted strips are uncoiled to enter in hoop cage/looper for the continuous running of ERW mill through the forming rolls.

Forming

Strip is formed into a cylindrical shape using a number of breakdown, cluster and fine pass rolls.

Welding

The edges of the cylindrically shaped strip are rapidly heated with a high frequency ERW Welders and then completely press welded with a set of squeeze rolls.



Heat Treatment

In order to ensure best quality in compliance with the API-5L specifications the weld seam and entire heat affected zone is heat treated. BBJ Pipe is processed and heat treated through on-line Seam Annealer so that no untempered martensite develops on the weld seam or heat effected zone.

Non destructive Inspection (NDI)

Eddy current is the most modern technology to detect weld defects. Eddy Current method has ability to detect imperfections in the weld seam of steel pipes.

Sizing

Before cutting off required pipe length, the welded pipe passes through the set of rollers to give it the desired accurate outside diameter.

Cutting Off

Pipes are cut into required length by the pipe cutter.

Facing/Beveling & Threading

The pipe ends are accurately faced/beveled and threaded by the end facing and threading machines.

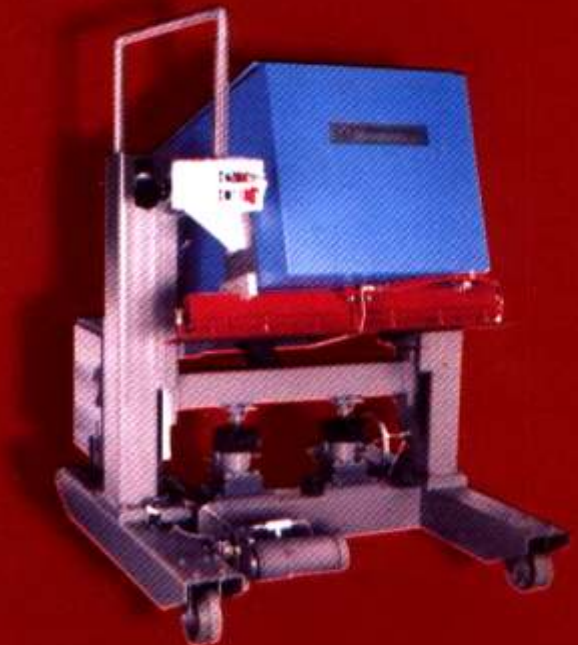
Galvanizing

Galvanizing is done through a latest process called hot dip method on an automatic plant. Galvanizing Extends the life of the pipe to a great extent, thereby making it useable for various applications.

Quality Control

We ensure that the raw materials used in the production process are superior and stringently tested on different quality parameters right from the initial stage to the final inspection and testing methods which include the following:-

- Testing of Chemical Composition
- Testing of Mechanical Properties
- Metallographic Examination
- NDI (Eddy Current Flaw Detection)
- Hydrostatics Tests 100%
- Dimensional checks
- Visual Examination





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