



# LONGITUDINALLY WELDED DOUBLE SEAM PIPES

**EEW GROUP**





# LONGITUDINALLY WELDED DOUBLE SEAM (LWDS) PIPES

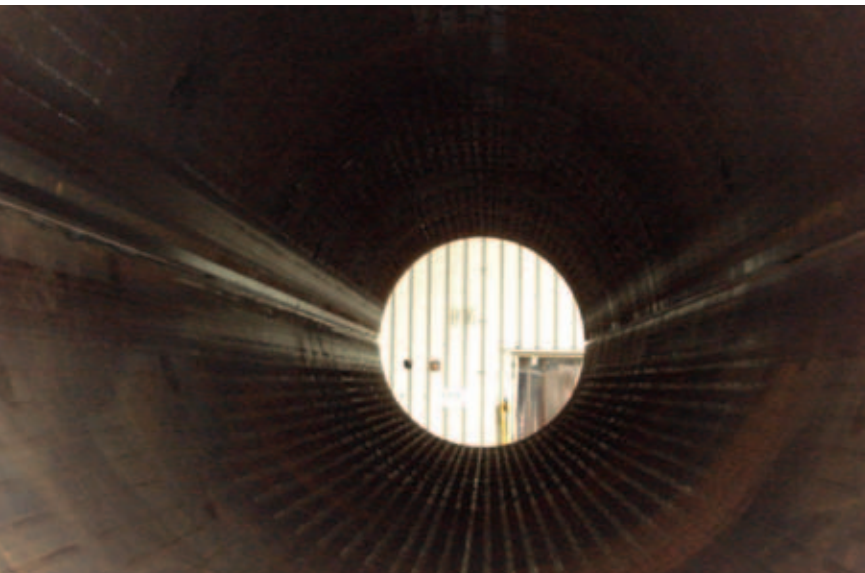
The width and weight constraints imposed upon the transportation of plate means that carbon steel pipes with one single weld seam can only be produced in double random lengths up to an outside diameter of approximately 60" (1524 mm). One alternative for larger diameters is to form the plates transverse to their rolling direction, i.e. to use the plate width as the pipe length and the plate length as the circumference of the pipe. The disadvantage of this method is that three single pipes with two circumferential welds are needed to form a double random length. Today many specifications including the API 2B and API 5L recognize the fact that multiple jointers are not always desired or commercially viable and allow for two longitudinal weld seams. Stainless steel plates are only available with a maximum width of 3800 mm which allows for the production of pipes with a single seam up to 48", but it also becomes commercially attractive to start producing stainless steel pipes > 40" (1016 mm) with two longitudinal welds.

Recognizing this fact and true to our motto "Always a length Ahead" the EEW-Group has once more invested in the production lines in Erndtebrück and is now in the position to offer our clients **longitudinally welded double seam (LWDS) pipes** in double random lengths up to 84" (2134 mm) outside diameter. OD's larger than 84" (or shorter lengths > OD 60" when required) will be manufactured at the EEW-Group's manufacturing facilities in Rostock, Korea or Malaysia.

Dependant upon material grade, **LWDS pipes** with wall thicknesses up to 30 mm are produced on the 12 metre (40 ft) production line. On this production line the first longitudinal seam is welded before the start of production to form a plate with the required width. This plate is then formed in the pyramid rolls with post forming of the plate edges to eliminate peaking adjacent to the weld seam. Further production, testing and finishing steps are exactly the same as for a pipe with a single weld seam.



Welding of the first seam to form a plate with the required width



**LWDS pipes** with wall thicknesses > 30 mm and ≤ 75 mm are produced on the 13,2 metre (43 ft) production line. On this production line the longitudinal weld edges are machined onto two plates with widths representing half of the circumference. The plate edges are preformed to the required diameter before the plates are formed into two half shells in the forming press. The two half shells are then tack welded together to form a pipe in a machine especially designed for this purpose by EEW. Again further production, testing and finishing steps on this production line are exactly the same as for a pipe with one single weld seam.

# PILES

Ø 60" ≤ 75 mm wall thickness

Ø 72" ≤ 75 mm wall thickness

Ø 84" ≤ 75 mm wall thickness

# PROCESS & LINE PIPES

Stainless: Ø ≥ 40" ≤ 84" WT 8 mm - 75 mm

Carbon: Ø ≥ 60" ≤ 84" WT 8 mm - 75 mm



LWDS Pile OD 1828 x 50 x 25000 mm (72" x 2" x 75,5') complete with internal grouting beads ready for shipment

## SURFACE TREATMENT

Pickled and passivated is the standard delivery condition for stainless steel LWDS pipes. Carbon steel LWDS pipes can be supplied with the surface bare or shot-blasted, both with or without standard mill rust protection. Other coatings can be performed upon request.

## TESTING

Visual inspection of all surfaces, dimensional control are EEW standard.

## NON-DESTRUCTIVE TESTING

Following testing possibilities are at your disposal for acceptance inspections:

- UT
- Digital radiography (as our standard, or upon request by film technique)
- MT or PT surface crack testing

## DESTRUCTIVE TESTING

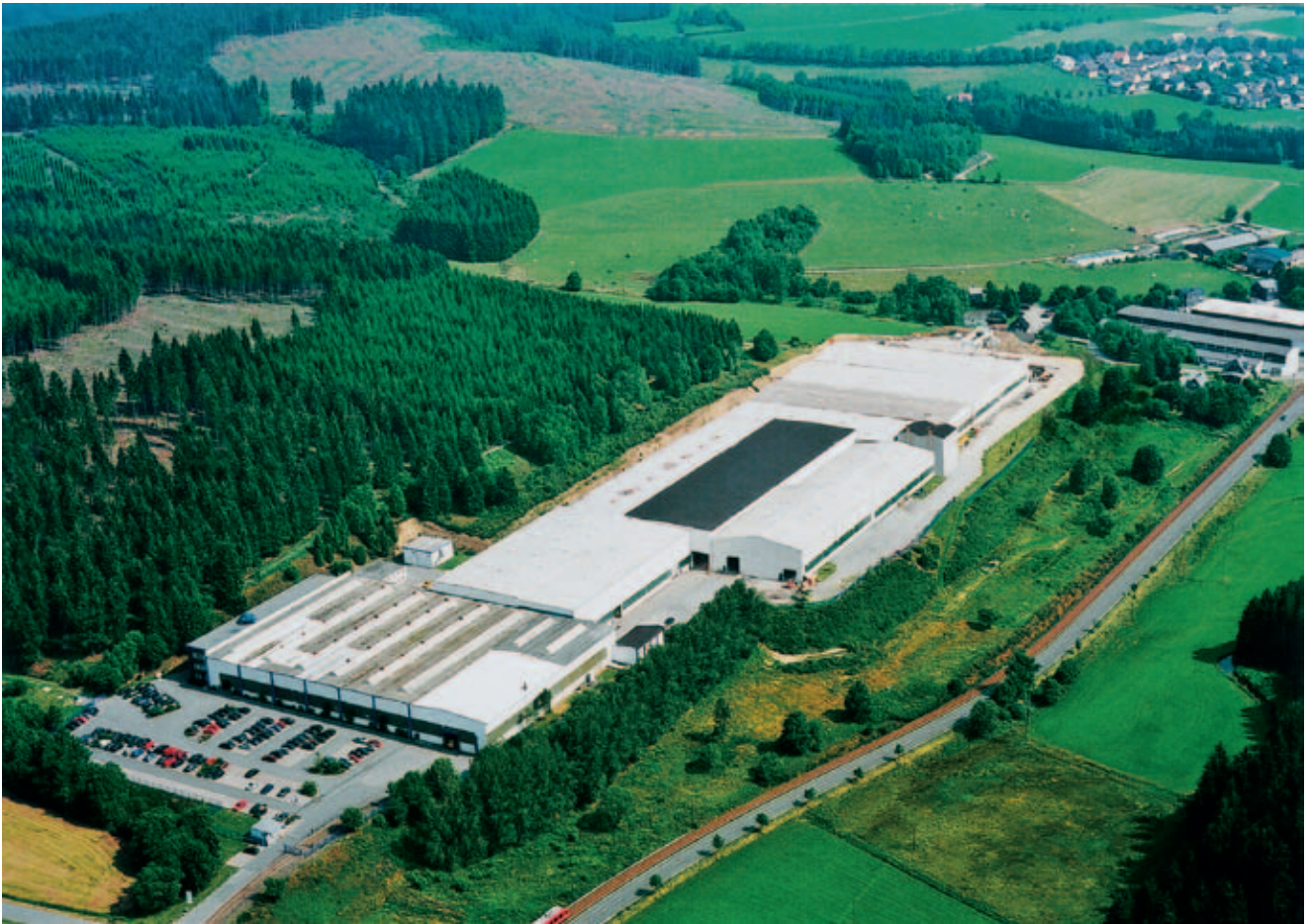
All mechanical-technological and corrosion tests are executed in independent laboratories

When fabricating **LWDS pipe**, no two longitudinal welds are spaced closer together than one pipe diameter or 5 ft whichever is greater. Normally the longitudinal weld seams are spaced 180° apart.

**LWDS pipes** can be supplied in multiple lengths up to 25 metres ex-mill and up to 120 metres ex-Rostock. In this case the longitudinal weld seams of adjoining cans are staggered at 45° - 90° unless other spacing has been agreed upon.



**ALWAYS A LENGTH AHEAD**



**YOUR COMPETENT PARTNER  
FOR LWDS PIPES**



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