



Fully Operational

Seamless Pipe Mill in Poland

Capacity of 60,000 Ton/Year

UNIQUE OPPORTUNITY

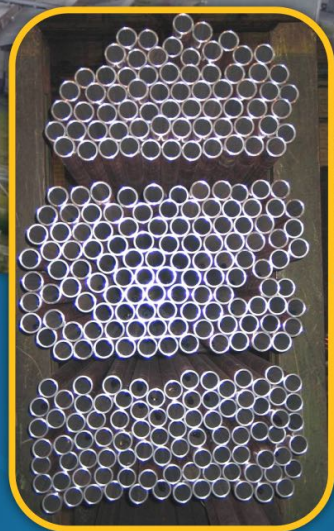
for companies looking to expand their production capabilities in **Europe** and **beyond**.

Seamless pipe mill for sale in **Poland** with a production capacity of **60,000 Ton/Year**.

Producing **hot-rolled seamless steel pipes** for various industries.

Ø 21.3mm to Ø 114.3mm, wall thickness: **2.0mm** to **10.0mm**

The facility is **fully operational** and **certified**.



Description of the Sale

We are pleased to offer a **seamless pipe mill** in Poland, with a longstanding history, specializing in manufacturing small-diameter steel pipes.

Products: **Hot-Rolled Seamless Pipes**

Location: **Poland**

Annual Production Capacity: **60 000 Ton/year**

Employees: **460**

Outside Diameters **Ø 21,3 to Ø 114,3 mm**

Wall Thickness: **2,0 to 10,0 mm**

Length: **Random: 4÷12 m (over 12 m upon agreement)**

Limited +300/-0 mm

Exact - With Max. Deviation:

+10/-0 mm length < 6 m,

+15/-0 mm length 6÷12 m,

+(Upon Agreement)/-0 dla Length > 12 m;

Multiple With Allowance for Every Cutting

Grades: **Carbon Steel and Low-Alloy Steel**

Max Grade: **Max 10CrMo9-10**

Certificates: **PED, AD 2000-Merkblatt W0/W4, Spec.**

API 5L-0983, DNV, UDT, BV, LR, PRS

For more detailed specifications, certifications, and equipment lists, please get in touch:

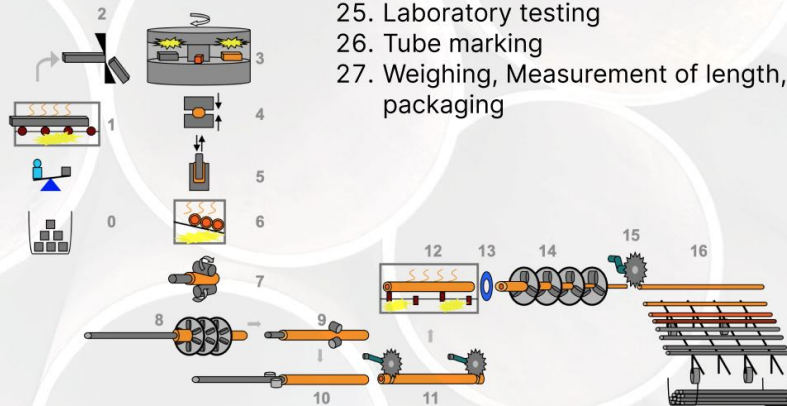
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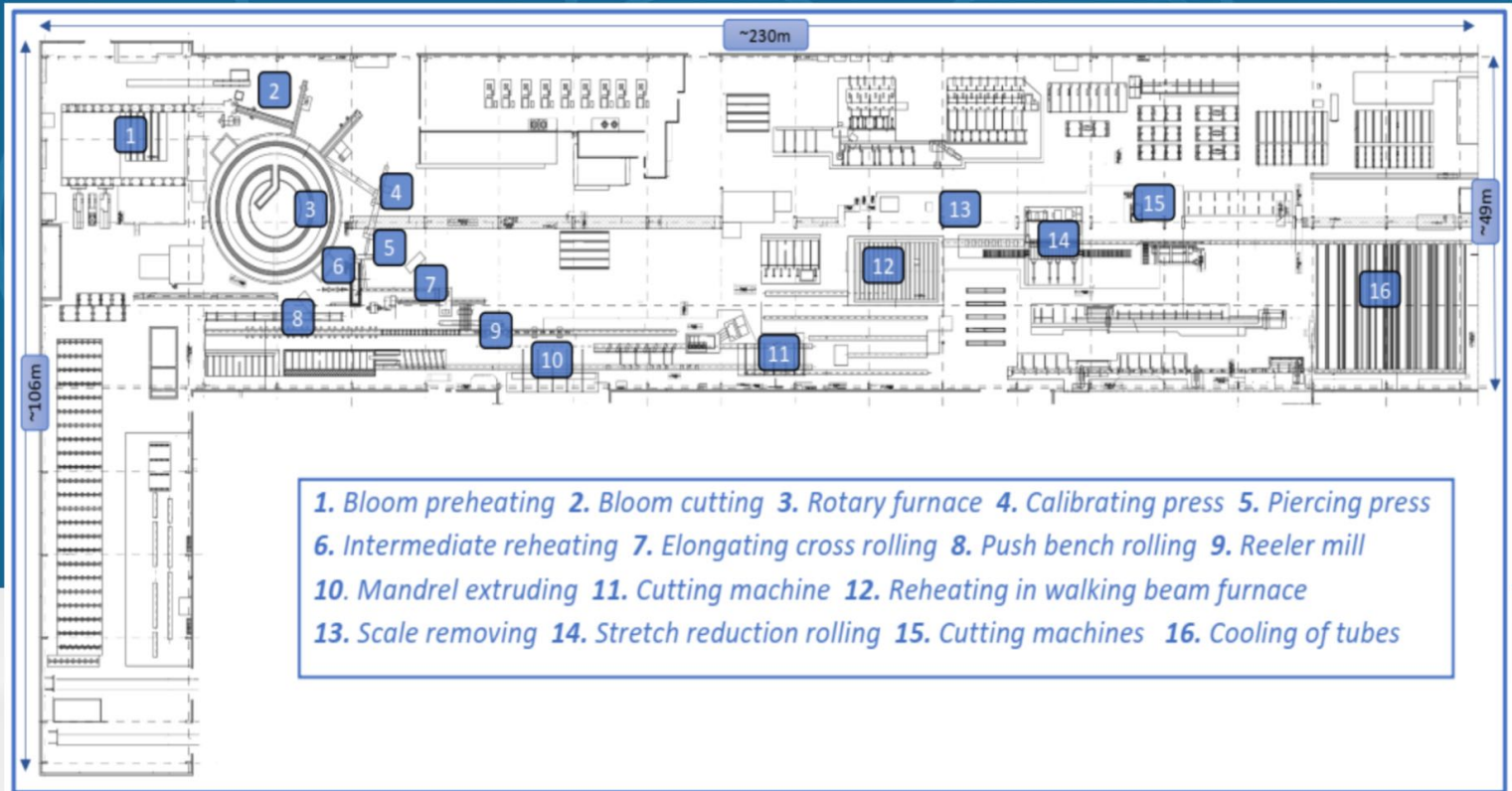
Manufacturing process of seamless steel tubes

1. Bloom preheating
2. Bloom cutting
3. Heating in rotary furnace
4. Calibrating press
5. Piercing press
6. Intermediate reheating
7. Elongating cross rolling
8. Push bench rolling
9. Reeler mill
10. Mandrel drawing
11. Bottom and end cutting
12. Reheating in walking beam furnace
13. Scale removing
14. Stretch reduction rolling
15. Hot-sawing of tubes
16. Cooling of tubes
17. Straightening
18. Cut to exact length
19. End finishing
20. Tube heat treatment
21. Hydrostatic test
22. NDT – Eddy Current
23. NDT – Ultrasonic
24. Inspection of surface and dimensions
25. Laboratory testing
26. Tube marking
27. Weighing, Measurement of length, packaging



For more information, please visit www.krudoind.com

Pilgrim Rolling Mill Layout





Manufacturer: **General Karol | Swierczewski Steelworks**

Model: - | YoM: **1977** | Overhaul: -

Utilities: **Natural Gas and Compressed Air**

Drive: **Electric Motor 100 kW 900 rpm**

Furnace Capacity: **50 Billets**

Dimensions: **9,000 × 8,600 mm**

Tilt Angle of the Pusher: **3%**

Billet Length: **2.8 to 8.2 m**

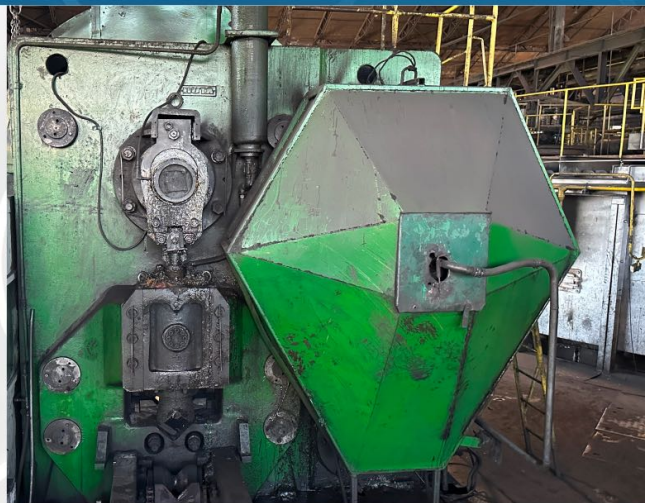
Billet Dimensions: **160 × 160 mm**

Billet Heating Temperature: **400°C**





Manufacturer: **Zygmunt Steelworks**
 Model: **FL - 1600** | YoM: **1976** | Overhaul: **1993**
 Utilities: **Compressed Air**
 Drive: **Electric Motor SZUDa 98 b**
 Power: **73 kW, 730 RPM**
 Type: **FL 1600, Pressure - 1600 tons**
 Cutting Frequency: **8 cuts/min**
 Max. Cross-Section: **up to 220x220 mm**
 Length of the Cut Material: **2.8-8.3 m**



Manufacturer: **Bowim**
 Model: - | YoM: **1965** | Overhaul: **2006**
 Utilities: **Natural gas, Water, and Compressed air**
 Drive: **Electric Drive - 2x 15 kW Motors, 1400 RPM**
 Effective Shell Area: **104 m²**
 Rotary Shell Dimensions: **15800/2700 mm**
 Charging Temperature: **1250°C**
 Fuel Consumption: **1000 m³/h**



Manufacturer: **Zygmunt Steelworks**

Model: - | YoM: **1979** | Overhaul: **2008**

Utilities: **Water**

Pressure Force: **246 Mg (megagrams)**

Working Pressure: **10 MPa (megapascals)**

Diameter of Main Piston: **560 mm**

Diameter of Side Piston: **172 mm**

Clearance: **220 mm**





Manufacturer: **Zygmunt Steelworks**

Model: **PHGD 500** | YoM: **1972** | Overhaul: **2008**

Utilities: **Water**

Type: **PHGD 500, Pressure - 500 tons**

Main Punch Diameter: **560 mm**

Side Punch Diameter: **172 mm**

Operating Water Pressure: **19.6 Mpa**





Manufacturer: **B.P.B.P.P Bytom**

Model: - | YoM: **1965** | Overhaul: **2014**

Utilities: **Natural Gas and Water Compressed Air**

Core Size: **1250/3800mm**

Thermal Power: **3 X 400kw**

Max. Working Temperature: **1300 C**

Stem Angle: **13°**

Capacity: **approx. 17 pcs.**





Manufacturer: **Zygmunt Steelworks**

Model: - | YoM: **1965** | Overhaul: -

Utilities: **Water and Compressed Air**

Engine Power: **1000 kW**

Roller Arrangement: **Inclined**

Roller Speed: **104-208 RPM**

Exit Sleeve Diameter: **115-155 mm**





Manufacturer: **Zygmunt Steelworks**

Model: - | YoM: **1965** | Overhaul: **2008**

Utilities: **Water and Compressed Air**

Drive: **Electric motor - 2 x Power - 900 kW**

Rack Stroke: **31,900 mm**

Rack Speed: **6 m/s**

Length of the Loader: **1,830 mm**



Manufacturer: **Zygmunt Steelworks**

Model: - | YoM: **1984** | Overhaul: **1993**

Utilities: **Water and Compressed Air**

Drive: **Electric motor - 1 × 200 kW**

Roll Pressure: **600 kN**

Roll Diameter: **300 mm**

Speed: **500-1000 RPM**



Mandrel Extruding & Bottom and End Cutting



Manufacturer: **Zygmunt Steelworks**

Model: - | YoM: **1965** | Overhaul: -

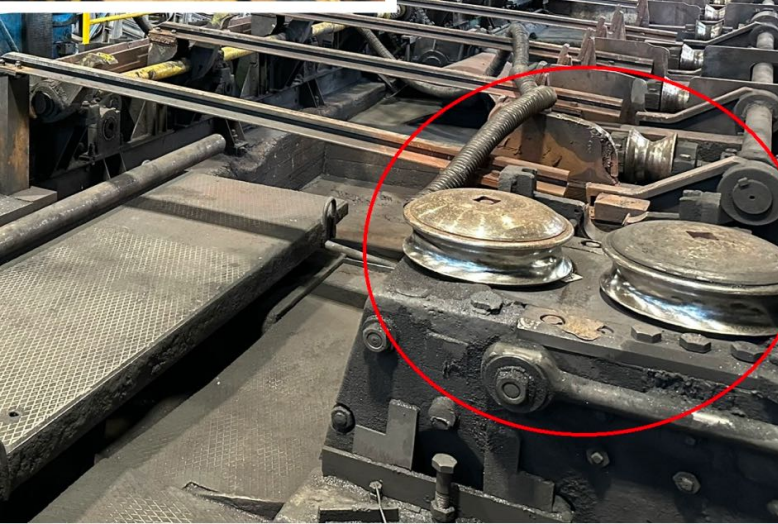
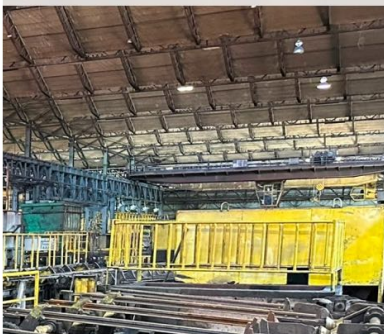
Utilities: **Hydraulic Oil**

Drive: **Electric**

Power: **75 kW**

Roller Pressure: **16.5 tons**

Speed: **3 m/s**



Manufacturer: **Zygmunt Steelworks**

Model: - | YoM: **1965** | Overhaul: **2010**

Utilities: **Hydraulic Oil and Compressed Air**

Drive: **Electric Motor - 2 x 30 kW, 1400 RPM**

Motor Power: **20 kW**

Motor Speed: **980 RPM**

Cutting Disc Diameter: **950 mm**





Manufacturer: **Zygmunt Steelworks**

Model: - | YoM: **1984** | Overhaul: **1993**

Utilities: **Water and Compressed air**

Drive: **Electric Motor - 1 × 200 kW**

Roll pressure: **600 kN**

Roll diameter: **300 mm**

Speed: **500-1000 RPM**

Scale Removing



Stretch Reduction Rolling



Manufacturer: **Mannesmann**

Model: **SRW 275 I** | YoM: **1999** | Overhaul: -

Utilities: **Water and Compressed Air**

Drive: **Electric - Motors**

2× 600 kW

2× 250 kW

1× 150 kW



Cutting Machines



Manufacturer: **Mannesmann**

Model: **PSV 1100** | YoM: **1999** | Overhaul: -

Utilities: **Compressed Air**

Arm Drive: **Electric Motor 1 × 220 kW**

Disc Motor: **30 kW**

Cutting at Max Pipe Speed: **7.5 m/s**

Disc Diameter: **780 mm (min. 750 mm)**



Cooling of Tubes



Manufacturer: **Zygmunt Steelworks**

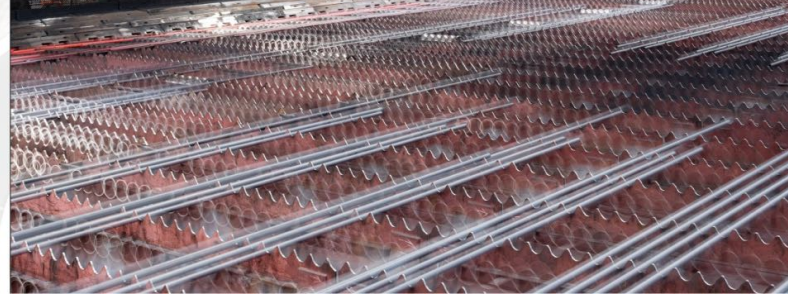
Model: - | YoM: **1965** | Overhaul: -

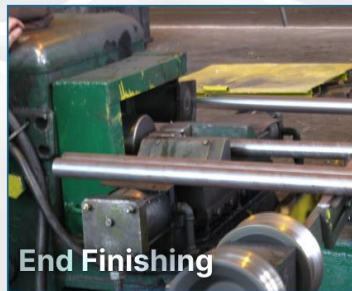
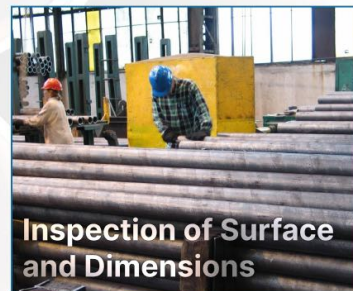
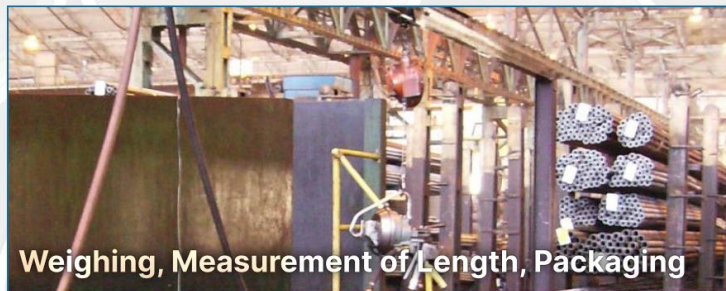
Electric Drive: **Motors 2 × 100 kW**

Dimensions: **18,450/22,900/1,800 mm**

Max. Pipe Length: **22 m**

Max. Number of Pipes in The Cooler: **104 pcs**



**Straightening****Cut to Exact Length****End Finishing****Tube Heat Treatment****Hydrostatic Test****NDT - Eddy Current****NDT - Ultrasonic****Inspection of Surface and Dimensions****Laboratory Testing****Tube Marking****Weighing, Measurement of Length, Packaging**

Line, Structural and General Use Pipes According to European and American Standards

Norm	Grade
PN-EN ISO 3183	PSL1 (L175, L210, L245, L290, L320, L360, L390, L415) PSL2 (L245R, L290R, L245N, L290N, L320N, L360N, L390N, L415N) PSL2+zař.M (L245NE, L290NE, L360NE, L415NE)
PN-EN 10210 - 1, -2	S235JRH, S275J0H, S275J2H, S355J0H, S355J2H, S275NLH, S355NH, S355NLH
PN-EN 10216 - 1	P195TR1, P195TR2, P235TR1, P235TR2, P265TR1, P265TR2
DIN 2448/1629	St.37.0, St.44.0, St.52.0,
DIN 2448/1630	St.37.4, St.44.4, St.52.4
PN-EN 10216 - 3	P275NL1, P275NL2, P355N, P355NH, P355NL1, P355NL2,
PN-EN 10216 - 4	P215NL, P265NL
PN-EN 10297	E235, E275, E315, E355, E275K2, E355K2, C22E, C35E, C45E, C10E, C15E, C15R
PN-EN 10255	S195T
PN-EN 10224	L235, L275, L355
PN-EN 10216-2	P195GH, P235GH, P265GH, 16Mo3, 13CrMo4-5, 10CrMo9-10
DIN 17175	St.35.8 I, St.45.8 I, St.35.8 III, St.45.8 III, 15Mo3, 13CrMo44, 10CrMo910
ASTM - A53	Grade A, Grade B
ASTM - A106	Grade A, Grade B, Grade C
ASTM - A333	Grade 1, Grade 6
ASTM - A192	A192
ASTM - A210	Grade A1, Grade C
ASTM - A213	Grade T12, Grade T22
ASTM - A334	Grade 1, Grade 6
ASTM - A335	Grade P12, Grade P22
API Spec. 5L-0983	PSL1: 175 (A25), L175P (A25P), L210 (A), L245 (B), L290 (X42), L320 (X46), L360 (X52), L390 (X56) PSL2: L245R (BR), L245N (BN), L290R (X42R), L290N (X42N), L320N (X46N), L360N (X52N), L390N (X56N)

Dimensional Range

Kg/m	Wall Thickness														
	2.0	3.2	2.6	2.9	3.2	3.6	4.0	4.5	5.0	5.6	6.3	7.1	8.0	8.8	10.0
21.3	0.95	1.08	1.20	1.32	1.43	1.57	1.71								
25.0		1.29	1.44	1.58	1.72	1.90	2.07	2.28	2.47						
26.9		1.40	1.56	1.72	1.87	2.07	2.26	2.49	2.70	2.94					
30.0			1.76	1.94	2.11	2.34	2.56	2.83	3.08	3.27	3.68				
31.8			1.87	2.07	2.26	2.50	2.74	3.03	3.30	3.62	3.96	4.32			
33.7			1.99	2.20	2.41	2.67	2.93	3.24	3.54	3.88	4.26	4.66			
38.0			2.27	2.51	2.75	3.05	3.35	3.72	4.07	4.47	4.93	5.41	5.92		
42.4			2.55	2.82	3.09	3.44	3.79	4.21	4.61	5.08	5.61	6.18	6.79	7.29	
44.5			2.69	2.98	3.26	3.63	4.00	4.44	4.87	5.37	5.94	6.55	7.20	7.75	8.51
48.3			2.93	3.25	3.56	3.97	4.37	4.86	5.34	5.90	6.53	7.21	7.95	8.57	9.46
51.0			3.10	3.44	3.77	4.21	4.64	5.16	5.67	6.27	6.94	7.69	8.46	9.16	10.10
54.0			3.30	3.65	4.01	4.47	4.93	5.49	6.04	6.68	7.41	8.21	9.06	9.81	10.90
57.0				3.87	4.25	4.74	5.23	5.83	6.41	7.10	7.88	8.74	9.67	10.50	11.60
60.3				4.11	4.51	5.03	5.55	6.19	6.82	7.55	8.39	9.32	10.30	11.20	12.40
63.5				4.33	4.76	5.32	5.87	6.55	7.21	8.00	8.89	9.88	10.90	11.90	13.20
70.0				4.80	5.27	5.90	6.51	7.27	8.01	8.89	9.90	11.00	12.20	13.30	14.80
73.0				5.01	5.51	6.16	6.81	7.60	8.38	9.31	10.40	11.50	12.80	13.90	15.50
76.1				5.24	5.75	6.44	7.11	7.95	8.77	9.74	10.80	12.10	13.40	14.60	16.30
82.5				6.26	7.00	7.74	8.66	9.66	10.80	11.80	13.20	14.70	16.00	17.50	
88.9				6.76	7.57	8.38	9.37	10.30	11.50	12.80	14.30	16.00	17.40	19.50	
101.6					8.70	9.63	10.80	11.90	13.30	14.80	16.50	18.50	20.10	22.60	
108.0					9.27	10.30	11.50	12.70	14.10	15.80	17.70	19.70	21.50	24.30	
114.3					9.83	10.90	12.20	13.50	15.00	16.80	18.80	21.00	23.90	26.70	

Certifications

Inspection Company	Standard / Regulation
TUV Nord	ISO 9001, ISO 14001, ISO 45001, ISO 50001
TUV Nord	PED (2014/68/EU), AD 2000-Merkblatt WO/TRD 100
UDT	Technical Inspection Office
ZETOM Katowice	„B” i „CE”.
API	License API 5L-0983

Inspection Company	Regulations
DNV	PART 2 chapter 2 sec. 5
LR	PART II chapter 6 sec. 2
PRS	PART IX chapter 10
BV	BV MODE II SCHEME