



# PIPE LINE CORPORATION

*An ISO 9001: 2015 COMPANY*

<https://pipelinecorporation.in/pipes.html>

**Manufacturer of Fittings**



**Stockiest of Plate**



**Stockiest of Pipe**



# Company Introduction

Pipe Line Corporation is an ISO 9001:2015 certified Company.

We are leading stockiest of Plate, Pipe & renowned manufacture of Pipe Fittings grade like Carbon Steel, Stainless Steel, Alloy Steel, High Nickel Alloy, Duplex, Super Duplex, Monel, and Inconel.

Our Manufacturing unit is managed by team member having more than 15 years of experience in manufacturing.

On average monthly 200 metric tons production Capacity

**PIPE LINE CORPORATION** is one point solution for Oil & Gas Industries. We are having in-house CNC Drilling facility for Drilling Tube sheet used in Heat Exchanger and Column, capacity of drilling holes up to 300mm thickness.

# Company Introduction

Our Drilling Capacity

MACHINERY DETAILS:

1. CNC DEEP HOLES DRILLING CUM HD MACHINE (BTA GUN DRILL)

Control: - Fanuc oi-MF Series

Job handling capacity: - X- Axis Travel 3meters Y-Axis travel 2.5 meter.

Tube Sheet OD: - 3 meters (3000 mm)

Thickness: - 800 mm (Z- Axis Travel 1000 mm)

BTA Size: -  $\emptyset$ 16.12mm,  $\emptyset$ 19.25 mm,  $\emptyset$ 25.25 mm,  $\emptyset$ 25.65 mm,  $\emptyset$  32.08 mm

Job Weight: - 15 MT

Number of machines: - 1nos

# Company Introduction

## 2. RD HMT (DRILLING MACHINE RM 65)

Control: - Manual

Job handling capacity: - Arm 2 meters, Swing- 3.6 meters

Drilling Hole Range: -  $\emptyset$  6 mm to  $\emptyset$  100 mm

Number of Machine: - 3 nos

## 3. RD HMT (DRILLING MACHINE RM 62)

Control: - Manual

Job handling capacity: - Arm 1.2 meters, Swing- 2 meters

Drilling Hole Range: -  $\emptyset$  6 mm to  $\emptyset$  75 mm

Number of Machine: - 1nos

## 4. RD HMT (DRILLING MACHINE RM 61)

Control: - Manual

Job handling capacity: - Arm 1 meters, Swing- 1.5 meters

Drilling Hole Range: -  $\emptyset$  6 mm to  $\emptyset$  50 mm

Number of Machine: - 1nos

# Company Introduction



# Manufacturing Range

Range	Size	MOC	Product
R=3D to R=15D	4" to 24"	CS,SS & Duplex	Pigable Bends as per API
R 1D to R 1.5D	1" to 24"	CS & Alloy Steel (SMLS)	Elbow, Tee ,Reducer as per B16.9
R 1D to R 1.5D	upto 12"	SS (SMLS)	Elbow, Tee ,Reducer as per B16.9
R 1D to R 1.5D	6" to upto 48"	SS ( WELDED)	Elbow, Tee ,Reducer as per B16.9
R 1D to R 1.5D	14" to 48"	C.S, Alloy Steel ( WELDED)	Elbow, Tee ,Reducer as per B16.9
R 1D to R 1.5D	upto 12"	SS, Alloy Steel	Weldolets as per MSS SP-97
	upto 2"	SS, Alloy Steel	Sockolets, Thredolets, Nipolets, Elbolets as per MSS SP-97
	Upto 2"	CS ,SS & Alloy Steel	Forged fittings ( Elbow, Tee, Union, Cap, Coupling) as per B16.11



# Elbow (SMLS) Mandrel Machine

## STEPS

### 1. Cutting

- Selecting Cutting length depends upon the size of bend we need to manufacture
- Transfer Check test number to each Cut Piece

### 2. Facing

- After cutting we need to Face both side of the pipe

### 3. Hot Forming

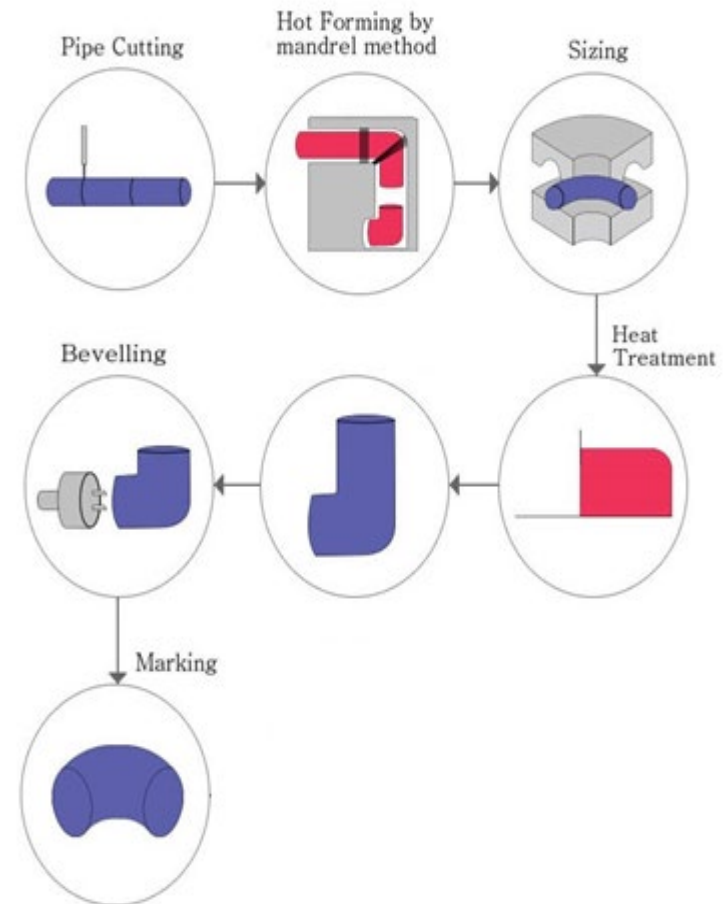
- It is done on Mandrel machine also know as Hot Induction Forming (Feed-60-100mm/min & Temperature 850°C)

### 4. Sizing

- Sizing is done in order to give final shape

### 5. Bevelling

- It is done on both side of manufactured Elbow



# Elbow (SMLS) Mandrel Machine





# Elbow (SMLS) Hot forming Process



Image 1



Image 2

In Pipe Line Corporation

When we manufacture Elbow using Hot forming process.

Firstly we heat the pipe between 620-980 °C and form under Hydraulic press machine show in “Image 1”. This process is very important in order to avoid reduction in back wall thickness. Which is major parameter for Elbow Rejection. By doing this we remove parameter of defect at initial stage.

Secondly with the help of die and punch the elbow is given desire shape show in “Image2”

# Reducers (Concentric /Eccentric)

## STEPS FOR SMLS REDUCERS

### 1. Cutting

- Selecting Cutting length depends upon the size of Reducer we need to manufacture
- Transfer Check test number to each Cut Piece

### 2. Facing

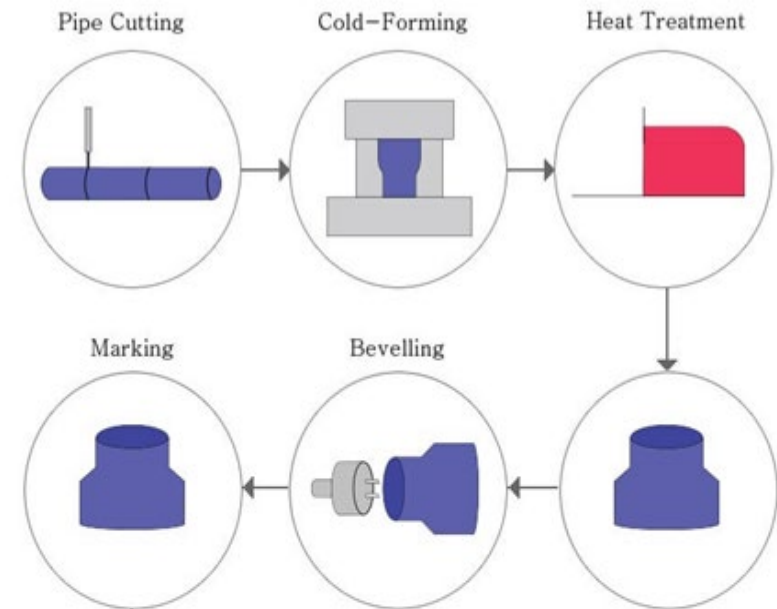
- After cutting we need to Face both side of the pipe

### 3. Cold Forming

- It is done via Hydraulic press with the help of die & punch

### 4. Beveling

- It is done on both side of manufactured Reducers



# Tee (Reducing /Equal) SMLS

## STEPS

### 1. Cutting

- Selecting Cutting length depends upon the size of Tee we need to manufacture
- Transfer Check test number to each Cut Piece

### 2. Facing

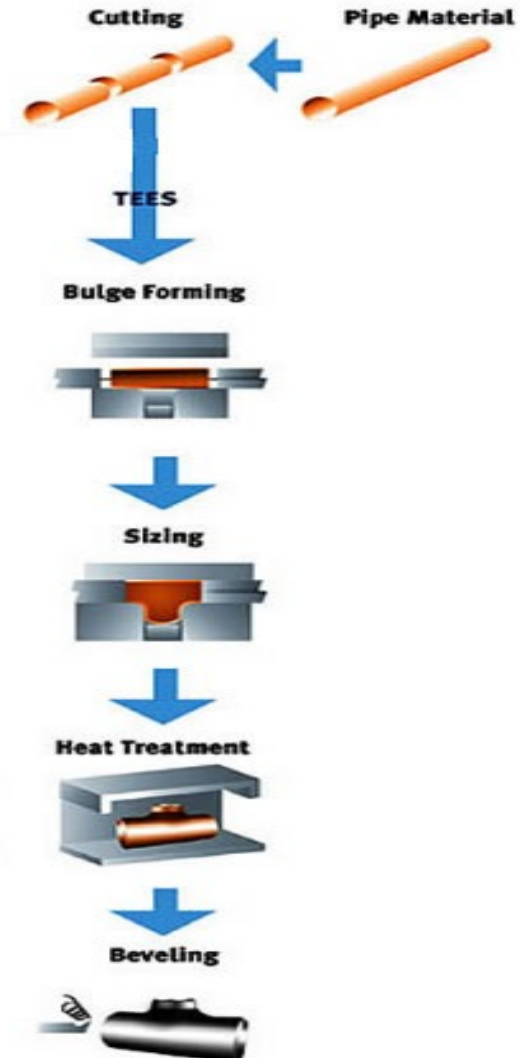
- After cutting we need to Face both side of the pipe

### 3. Hydraulic Pressing

- Bulge forming: It is done to extrude 3<sup>rd</sup> side of tee
- After Bulge forming the 3<sup>rd</sup> side of tee is cut with Gas cutter in order to proceed with orifice
- Hot Piercing: With the help of Punch required OD is extrude from 3<sup>rd</sup> side of Tee

### 4. Bevelling

- It is done on all three side of manufactured tee



# Tee (Reducing /Equal) SMLS

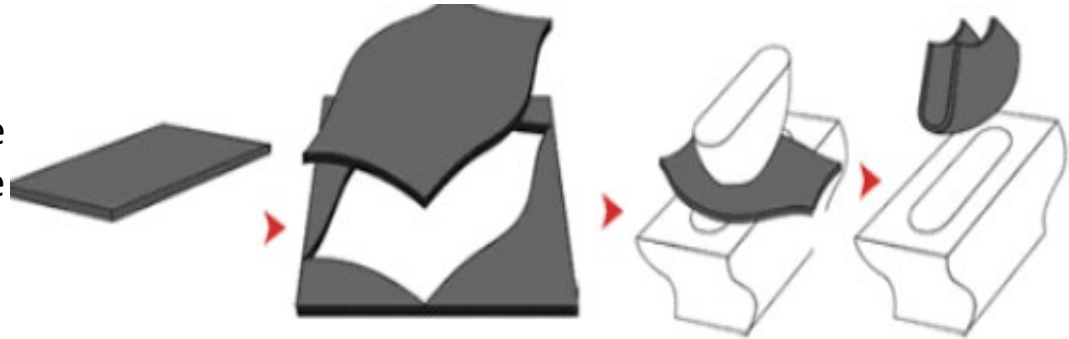


# Welded Elbow

## STEPS

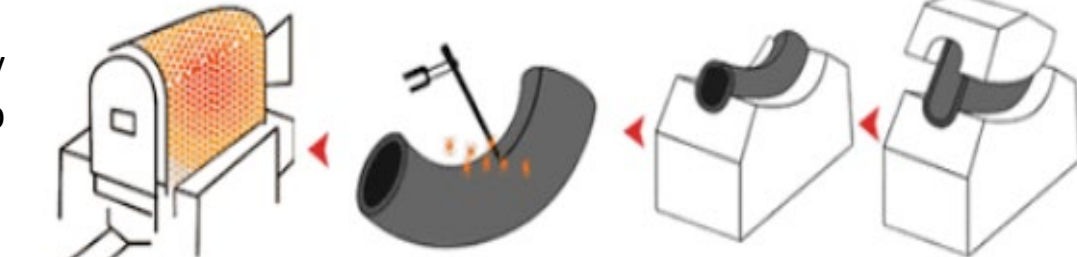
### 1. Plate Cutting

- After Raw Material Identification the first step is with the help of Template plate is cut into desire size.



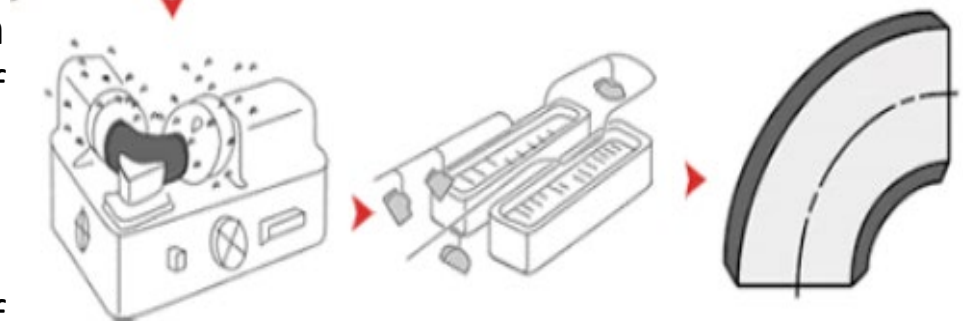
### 2. Pressing

- With the help of Hydraulic press The cut plate is given desire shape by pushing the plate into die with the help of punch. It is cold forming process.



### 3. Step up

- After pressing Gauging is done in order to proceed with Step up of Two half



### 4. Welded

- Welding is done to joint two half making it into single elbow



# Welded Elbow

## 5. Beveling

- In case of Elbow both 2 side is beveled & In case of Tee all 3 side are beveled

## 6. Radiographic Testing

- It is done to ensure defect free material manufactured from our end.

**Note :** The Same Process is use to manufacture welded TEE

# Welded Reducer

## STEPS

### 1. Plate Cutting

- After Raw Material Identification the first step is with the help of Template plate is cut into desire size.

### 2. Rolling

- With the help of Rolling machine The cut plate is made circular.

### 3. Welded

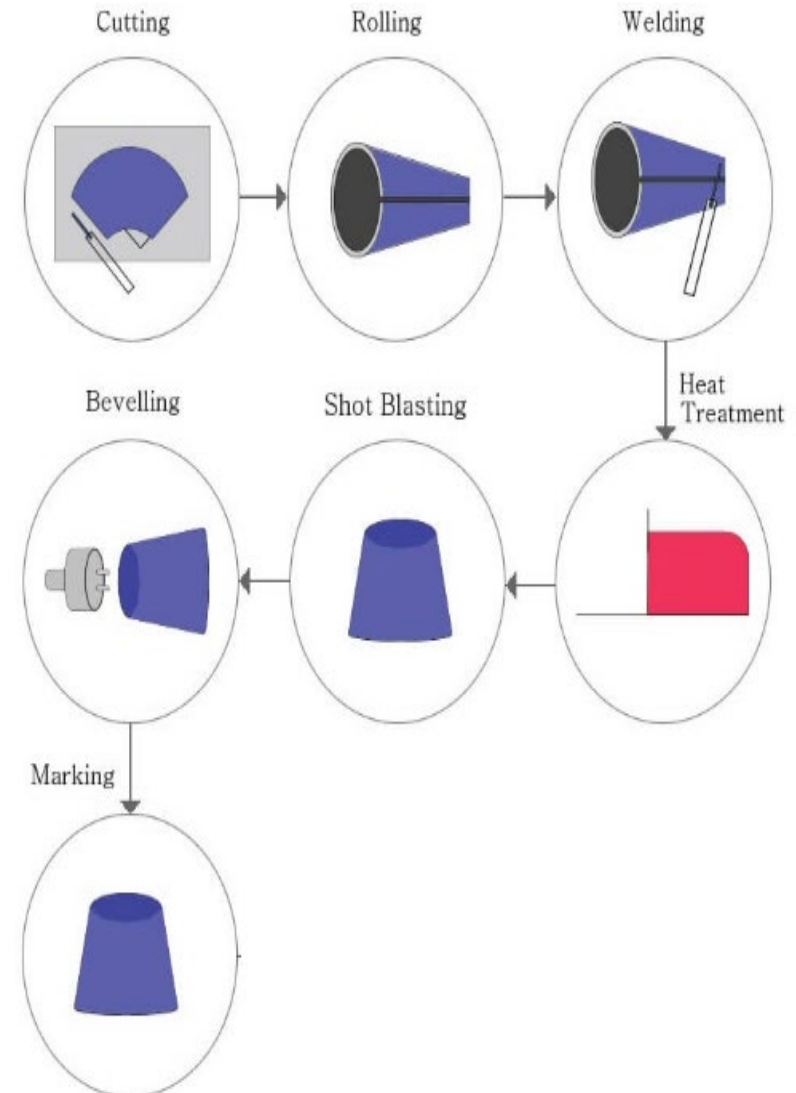
- Welding is done on two matching end of rolled plate

### 4. Re-Rolling

- To ensure proper shape of reducer or to reduce ovality

### 5. Bevelling

- Both Two side of reducer are beveled



# Two Half (Welded Fittings)



*Fig: Equal Tee*



*Fig: 90Deg. Elbow*

# Cap (B/W)

## STEPS

### 1. Plate Cutting

- Considering the desire size we need to manufacture

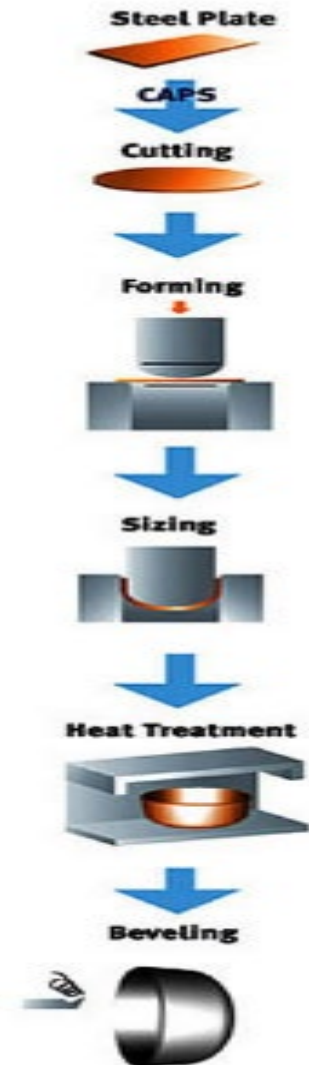
### 2. Heating

- The next step is heating the plate

### 3. Pressing

- With the help of punch the plate is push inside the die resulting in forming.

Note: We cannot mfg cap in single process it take 2-3 time pressing before obtaining the desire size.



# Forged Fittings

## STEPS:

1. The input for Forged Fittings is Round bar.
2. Cut Piece of round bar is heated
3. Forging hammer are use in the drop forging to form the metal.
4. The material is then allowed to cooled and at the end Drilling of desire bore size is made on lathe machine





# Non-destructive testing (NDT)



**Thickness Test**



**Ultrasonic Test**



**Dye Penetrant Test**



**Thickness Test**



**Positive Material Identification (PMI)**

# Machinery Photo



*Fig: Lathe m/c Total Qty 6pc*



*Fig: Bend Saw Machine qty 2pc*



# Products



# Products





# Products





# Finish Products



**Forged fittings**

# Finish Products



# Finish Products



**56" TEE MOC: SS316**



# Hot Induction Bend



# STOCK : PIPE



PIPE LINE CORPORATION is Stockiest of Pipe having Storage Capacity of Around 300MT. We stock Pipe Size between ½" to 24" OD , All Schedule.

Material Grade: Carbon Steel, Stainless Steel, Alloy Steel, Nickel Alloy.

Our Warehouse is located in Kalamboli Steel Yard , Maharashtra ,India.



# PIPE



**Pipe Stock in Rack Size Wise**



**Export**

# Stock :Plate

Pipe Line Corporation is one of the leading manufacturers and suppliers of Sheets, Plates Coils.

Grade: Stainless Steel -304, 304L, 304H, 316, 316L, 316H, 316Ti, 321, 309, 310, 347, 409, 410, 420, 430, 904L etc

Grade: IS2062 GR 250 BR, SA516 GR60/70, ALLOY STEEL GRADE

Nickel Alloys: Monel, Inconnel, HastAlloy, Nickel, Cupro Nickel, Titanium, Duplex, Super Duplex, etc.

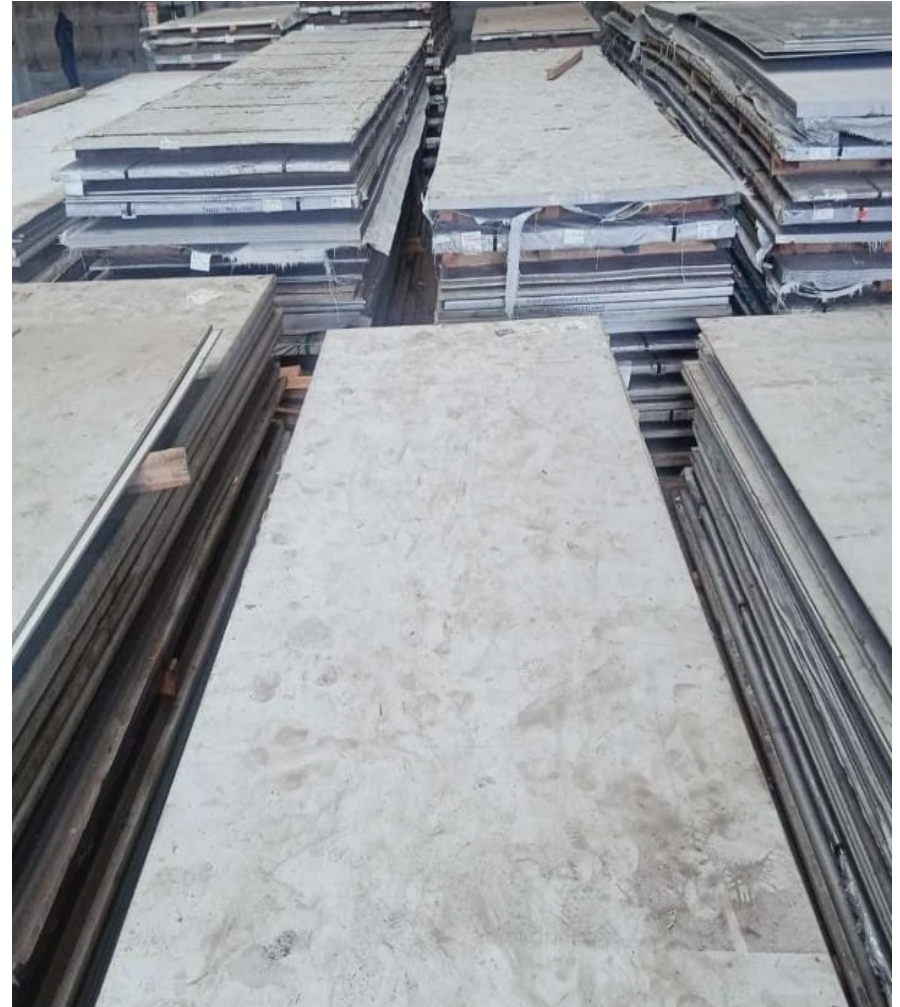
Types: Foils, Shims, Chequered Plate, Perforated Sheet, Strips, etc.

Finish: HR, CR, 2D, 2B, SATIN, MATT, PVC Coated ,etc.

Thickness: 0.1 mm to 125 mm

Size: Any Size as per customers Requirement up to 2500 mm Width

# Stock : Plate





# Stock :Plate



# Contact Information

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Thank you