



WAENDA machine equipment technologies Co. Ltd.

Professional manufacturer for TIG stainless steel pipe production lines



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WAENDA Machine Equipment Technologies Co., Ltd was established in 1990, as one of the earliest engaged in the development and manufacture of stainless steel Pipe production lines in China. WAENDA has R&D, manufacturing, sales and service complete system, one of the few suppliers for industrial stainless steel pipe production lines with self-development capacity and integrity mastering INDUSTRIAL STAINLESS STEEL PIPE PRODUCTION LINES、IGBT BRIGHT ANNEALING DEVICE ONLINE、INSIDE WELD REMOVINE DEVICE ONLINE with the core technology of complete sets of equipment. WAENDA pays attention to the R&D of new technology, more than 20 years of development and the creation, has accumulated the rich experience of mechanical design、automation、welding、forming、rolls quenching treatment and surface hardening, pioneering reliable equipment and the best quality service.



Core Products

- Industrial stainless steel pipe making machine
- IGBT bright annealing device online
- Inside weld bead removing device online
- Rolls

Based Products

- Decorative stainless steel pipe making machine
- Round pipe polishing machine
- Square and rectangle pipe polishing machine
- Flower pipe machine
- Spiral pipe machine
- Face milling machine

All specifications mentioned on this catalogue are not to be informed specially if changes

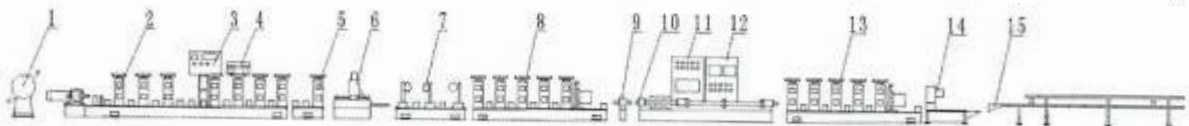
Pipe making machine

WD25-100 type specifications series stainless steel pipe making machines can produce $\Phi 4$ - $\Phi 325$ variety of round, square, and profiled pipe.



Model	WD25	WD40	WD40 Strong	WD40 Strong Enlarge	WD50	WD60	WD90
Machine dimensions	15.38×1.27×1.70	20.26×1.41×1.76	20.26×1.41×1.76	20.26×1.41×1.76	21.52×1.55×1.86	23.33×1.66×1.90	27.20×3.42×2.00
Host size(m)	5.12×0.83×1.70	8.65×1.24×1.76	8.65×1.24×1.76	8.65×1.24×1.76	9.87×1.30×1.86	11.25×1.48×1.84	17.52×2.22×1.80
Machine weight(T)	≈3.2	≈6.0	≈7.0	≈7.0	≈9.0	≈11.5	≈28
Main drive motor power (kw)	4	4/5.5	7.5/7.5	11/7.5	7.5/7.5	11/15	18.5/22
pipe making range(mm)	Φ8-Φ20	Φ12.7-Φ50.8	Φ12.7-Φ50.8	Φ12.7-Φ76.2	Φ38.1-Φ76.2	Φ50.8-Φ114	Φ114-Φ219
Pipe thickness (mm)	0.2-0.8	0.3-2.0	0.3-2.50	0.3-2.50	0.5-2.5	0.7-3.0	1.5-5.0
Welding speed(M/Min)	4-15	0.8-12	0.8-12	0.8-10	0.6-10	0.5-6	0.4-5

The schematic diagram Stainless steel pipe production line equipped with inside weld bead removing device and IGBT bright annealing device online



Con Code Name:

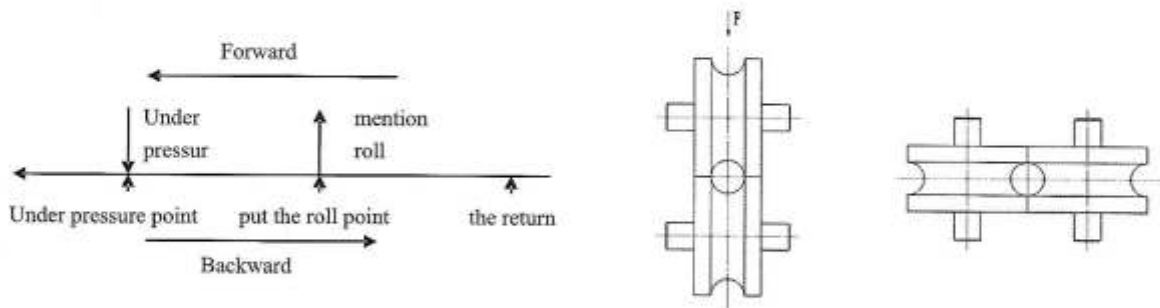
1. Pay Off / Coiler
2. Forming units
3. Welding machine
4. Electric control box
5. Welded seat
6. Inside weld bead removing device
7. Outside weld bead grinding head
8. Preliminary sizing unit
9. Pipe surface cleaning device
10. Bright annealing device online
11. Electrical control system for annealing device
12. IGBT power supply cabinet
13. Final sizing and straightening unit
14. Automatic cut-off system

Inside weld removing device online



The internal and external weld excess height of the Stainless steel TIG pipe would be removed while pipe has been rolled by the horizontal rolls and rolled into a horizontal oval cross-section, the mandrel is stuck in the pipe to move along the pipe after rolled by the vertical rolls pipe cross-section changed into a perfect circle, the mandrel will be separated from the pipe and returned back to a proper position through the air cylinder pull, at the same time the rolls stands is also returned back to a proper position through the cylinder pull, and then starting a second rolling cycle.

Its reciprocating motion trajectory is as follows:



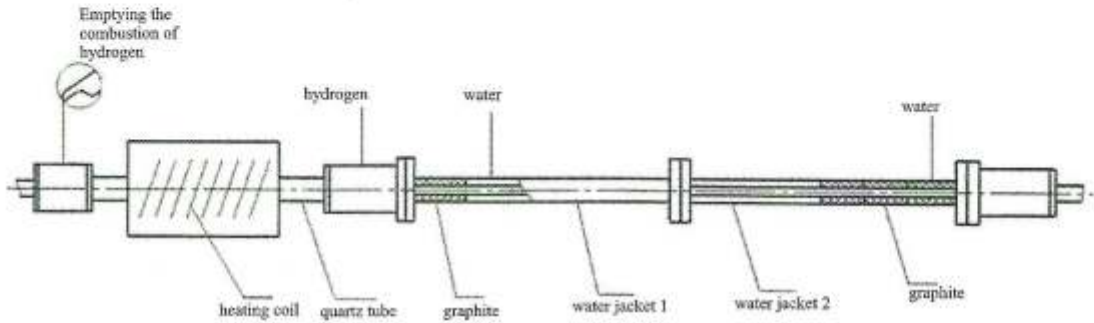
IGBT bright annealing device online



The stainless steel pipe is heated by induction heating to the annealing temperature (SUS304 1040 °C) and annealing in a sealing device which is full of hydrogen gas as protective gas to improve the structure of the weld stress relief and to enhance the anti-corrosion performance; hydrogen as protective gas pipe can be bright and cool the pipe faster during annealing treatment.

To and fast cooling when the stainless steel pipe has been heated to the annealing temperature

The schematic diagram about the process of heating and cooling for the pipe in



Stainless steel profile die (rolls)

Rolls material used in all High-quality mold steel Cr12MoV or D2 steel is used as raw material and precision machining (CAD / CAM) and special handling, ensuring high precision and long life.

Rolls Size: $\Phi 4$ anges to $\Phi 325$ mm range from a variety of pipe, round pipe, rectangular pipe and shaped tubes mold.

Flower pipe machine

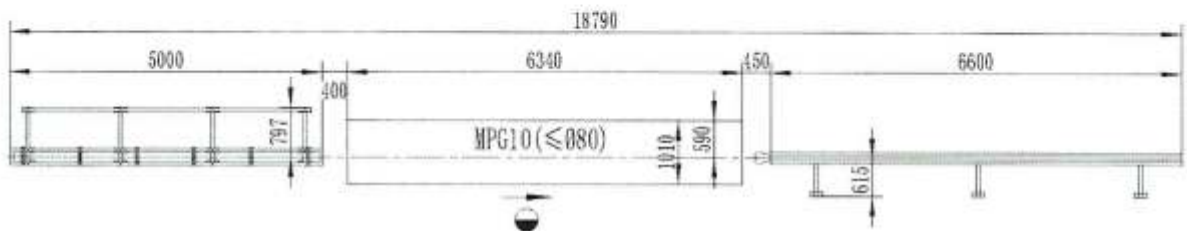
Stainless steel flower pipe machine known as gourd pipe, stainless steel decorative profiles indispensable accessories.

Paramater	Model	HG25	HG51	HG76	HG114
Die size (mm)		35×300×55	50×300×75	70×400×60	90×650×70
processing range (mm)		$\Phi 12$ – $\Phi 25$	$\Phi 12$ – $\Phi 51$	$\Phi 25$ – $\Phi 76$	$\Phi 38$ – $\Phi 114$
the wall thickness (mm)		0.25–0.5	0.3–1.2	0.7–1.5	0.7–1.5
the formation length (mm)		290	290	260	600
the formation time (s)		3–12	3–12	8–30	10–40
reducing wedge stroke (mm)		180	200	250	450
the amount of mold opening and closing (mm)		28	30	40	50
the main motor (KW)		3	4	7.5	11
spindle speed (rpm)		300	200	200	200
the spindle center height (mm)		800	800	800	900

Round pipe polishing machine

This machine used for polishing the outer surface of stainless steel round pipe, take 8 or 10 heads grinding by dry grinding polishing, the pipe surface roughness after polishing upto Ra0.8 μ m.

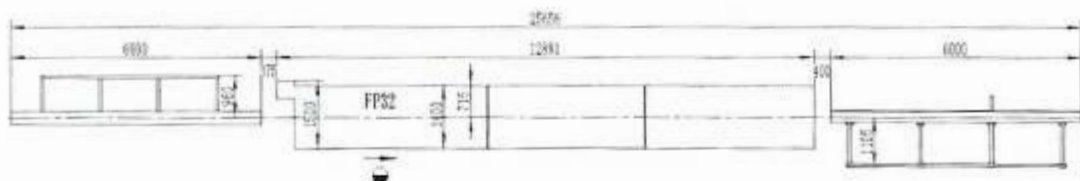
The machine can be used for polishing the outer surface of the round pipe of other metal materials.



POLISH MACHINE	Round polishing machine		
	PG 10	MPG10	LPG10
MODEL	PG 10	MPG10	LPG10
MACHINE DIMENSIONS(mm)	18.80×1.42×1.33	18.80×1.42×1.33	19.10×1.52×1.40
Host size(m)	6.34×1.10×1.33	6.34×1.10×1.33	6.34×1.45×1.40
Driving motor/output (KW)	2.2	2.2	2.2
Polishing head motor/output (KW)	5.5(10 PCs)	5.5(10 PCs)	5.5(10 PCs)
Spindle shaft diameter(mm)	Φ25	Φ36	Φ36
Capabilities of Manufacturing			
Max. OD in MM	50.8	80	114.0
Min. OD in MM	12.0	31.8	50.8
Max Thickness in mm	2.0	3.0	3.0
Min. Thickness in mm	0.3	0.3	0.6
Max length in meters	6.0	6.0	6.0
Min length in meters	4.0	4.0	4.0
Speed(m/min about)	18-24	18-24	18-24
machine weight (KG)	≈3.5	≈4.0	≈6.0

Square and rectangular pipe polishing machine

This machine used for polishing the outer surface of stainless steel Square and rectangular pipe and divided into 16,24,28,32,36,40 heads,the main polishing way by dry polishing without water.



POLISH MACHINE	Square polishing machine	Square polishing machine	Square polishing machine	Square polishing machine
MODEL NUMBER	FP16	FP24	FP32	FP36
MACHINE DIMENTIONS(mm)	19.84×2.07×1.72	22.84×2.07×1.72	25.67×2.07×1.72	27.33×2.07×1.72
Host size(m)	7.06×1.51×1.72	10.06×1.51×1.72	13.08×1.51×1.72	14.56×1.51×1.72
Driving motor/power (KW)	4	4	4	4
Polishing head motor/power(KW)	5.5(16PCS)	5.5(32PCS)	5.5(32PCS)	5.5(36PCS)
Spindle shaft diameter(mm)	Φ36			
Capabilities of Manufacturing				
Max. OD in MM	—	100×100	100×100	100×100
Min. OD in MM	10×10	10×10	10×10	10×10
Max Thickness in mm	3	3	3	3
Min. Thickness in mm	0.3	0.3	0.3	0.3
Max length in meters	6	6	6	6
Min length in meters	3	3	3	3
Speed(m/min)	18-24	18-24	18-24	18-24
machine weight (kg)	≈6000	≈9300	≈12300	≈138000

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