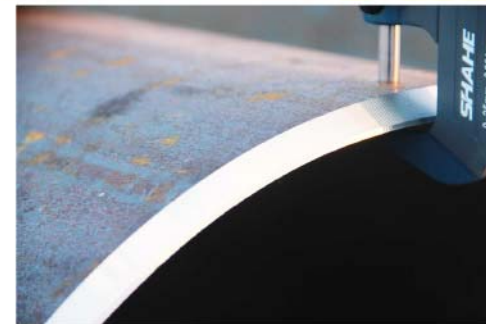


China Leading ERW/LSAW Steel Pipe Manufacturer Since 2003



LONGMA

Committed to supplying
high-quality products and services
to global pipeline projects

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河北龙马钢管制造股份有限公司
Hebei Longma Steel Pipe Manufacturing Co., Ltd



- 让我们共同前进 Let's advance together
- ● 与员工共同前进 Advancing together with employees
- ● ● 与客户共同前进 Advancing together with customers
- ● ● ● 与社会共同前进 Advancing together with society
- ● ● ● ● 与时代共同前进 Advancing together with the times

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安全健康、绿色龙马
Safety and Health、Green Longma

河北龙马钢管制造股份有限公司始建于2003年,工厂坐落于中国“管道装备之都”——河北省孟村县境内。公司总占地面积450亩,注册资金1.318亿元人民币,现有职工470人,其中技术人员120余名。2006年投资3.1亿元,兴建新厂区,占地200余亩。新厂引进德国先进JCO设备一套,在此基础上又自行研制了4套16条双面埋弧焊管生产线,拥有JCO成型机4台套,其中3000T一台,8000T一台,10000T一台,16000T一台。至2013年底,公司年产量超30万吨。

公司主要生产Φ60.3-Φ2020,壁厚6.35mm-100mm,长度可达13m的ERW/LSAW焊接钢管,执行标准(钢级):GB/T3091—2015(Q235B, Q355B/Q355D), GB/T9711-2017/ISO3183(PSL1&PSL2: L245-L555), ASTM A53(B) API 5L(PSL1&PSL2: B, X42-X80,N/M/S), ASTM A691(1Cr, 1-1/4Cr, 2-1/4Cr), ASTM A671(CC60, CC65, CC70), ASTM A672(C60, C65, C70), AS/NZS 1163(C250, C350, C450/L0), EN10219(S235JR, S355JR/S355J0/S355J2), ASTM A252 (Grade 1,2,3), ASTM A500 (Grade A, B, C)。

2004年,公司通过ISO9001/ISO14001/OHSAS18001/QSHS0001.1-2001认证,2009年,公司通过了石油协会API 5L(5L-0685)体系认证。

目前公司建立了以国内大循环为主体,国内国际双循环互相促进的新型销售格局,虽2020年全球疫情肆虐,但我公司产销量均突破历史记录。

奋斗不息的龙马人,始终秉承孜孜不倦的求索精神,以求生存,顾客为上帝的宗旨,以担当与匠心为企业理念,坚持用创新,让品牌升级!用实力,让梦想落地!用火红的青春,点燃
光辉灿烂的明天。



Hebei Longma Steel Pipe Manufacturing Co., Ltd (LONGMA) was founded in 2003. Located in Mengcun County, Hebei Province, the “capital of pipeline equipment” in China. The company covers a total area of 450 acres, with a registered capital of 131.8 million yuan. It currently has 470 employees and more than 120 technical personnel. In 2006, an investment of 310 million yuan was made to build a new factory area, covering an area of over 200 acres. The new factory has introduced a set of German JCO equipment, and on this basis, has also developed four sets of 16 double-sided submerged arc welded pipe production lines, with four sets of JCO forming machines, including one 3000T, one 8000T, one 10000T, and one 16000T. By the end of 2013, the company's annual production exceeded 300,000 tons.

LONGMA produces & exports ERW/LSAW steel pipes with diameter: 60.3mm(2inch) to 2020mm(80inch), wall thickness: 7mm to 100mm and length up to 13 meters. In accordance with the following standards & grade: GB/T3091(Q235B, Q355B/Q355D), GB/T9711-2017/ISO3183(PSL1&PSL2: L245-L555), ASTM A53(B) API 5L(PSL1&PSL2: B, X42-X80,N/M/S), ASTM A691(1Cr, 1-1/4Cr, 2-1/4Cr),ASTM A671(CC60, CC65, CC70), ASTM A672(C60, C65, C70), AS/NZS 1163(C250, C350, C450/L0), EN10219(S235JR, S355JR/S355J0/S355J2), ASTM A252 (Grade 1,2,3), ASTM A500 (Grade A, B, C).

In 2004, the company obtained the ISO9001/ISO14001/OHSAS18001/QSHS0001.1-2001 certification. in 2009, the company obtained the API 5L(5L-0685) system certification of the American Petroleum Institute.

At present, the company has established a new sales pattern with domestic circulation as the main body and domestic and international dual circulation promoting each other. Although the global epidemic ravaged in 2020, our company's production and sales have exceeded historical records.

The hardworking Longma people always adhere to the spirit of tireless exploration, the purpose of survival, and the customer as God. With responsibility and craftsmanship as the corporate philosophy, we persist in using innovation to upgrade our brand! Ignite a brilliant tomorrow with fiery youth.

API SPEC 5L (46th edition) April 2018, specifies requirements for the manufacture of two specification levels (PSL 1 and PSL 2) of welded steel pipe for use in pipeline transportation systems in the petroleum and natural gas industries. For material use in a sour service application, refer to Annex H; For offshore service application, refer to Annex J of API 5L 46th Edition.

LONGMA produces and stocks API 5L line pipes used for oil and gas transmission.

Type: ERW, LSAW, DSAW

Grade: B(L245), X42(L290), X46(L320), X52(L360), X60(L415), X65(L450), X70(L485), X80(L555)

Delivery condition: N, M, Q

Level: PSL1, PSL2

Available Specification

Out Diameter: 60.3-2,032mm(2"-80")

Wall Thickness: 7-100mm

Length: up to 13 meters

Tolerances: Outside diameter and out of roundness

Specified Outside Diameter D mm(in.)	Diameter Tolerance mm(in.)				Out-of-Roundness Tolerance mm(in.)	
	Pipe except the end (a)		Pipe end (a,b,c)		Pipe except the End (a)	Pipe End (a,b,c)
	SMLS Pipe	Welded Pipe	SMLS Pipe	Welded Pipe		
< 60.3(2.375)	-0.8(0.031) to +0.4(0.016)		-0.8(0.031) to +0.4(0.016)		1.2(0.048)	0.9(0.036)
≥ 60.3(2.375) to 168.3(6.625)	± 0.0075D		-0.4(0.016) to +1.6(0.063)		0.020D for D/t ≤ 75; by agreement for D/t > 75	0.015D for D/t ≤ 75; by agreement for D/t > 75
> 168.3(6.625) to 610(24.000)	± 0.0075D	± 0.0075D, but max of ± 3.2 (0.125)	± 0.005D, but max of ± 1.6(0.063)		0.020D	0.015D
> 610(24.000) to 1422(56.000)	± 0.01D	± 0.005D but max of ± 4.0(0.160)	± 2.0(0.079)	± 1.6(0.063)	0.015D, but max of 15(0.060) For D/t ≤ 75; By agreement for D/t ≤ 75	0.01D, but max of 13(0.500) for D/t ≤ 75; By agreement for D/t ≤ 75
> 1422(56.000)	As agreed					

*a: the pipe end includes a length of 100mm(4.0in.) at each of the pipe extremities

Tolerances: Wall thickness

Wall Thickness t mm(in.)	Tolerances (a) mm(in.)
SMLS Pipe (b)	
≤ 4.0(0.157)	+0.6(0.024) -0.5(0.020)
> 4.0(0.157) to < 25.0(0.984)	+0.150 -0.125r
≥ 25.0(0.984)	+3.7 (0.146) or +0.1r, whichever is the greater -3.0 (0.120) or -0.1r, whichever is the greater
Welded Pipe (c,d)	
≤ 5.0(0.197)	± 0.5(0.020)
> 5.0(0.197) to < 15.0(0.591)	± 0.1t
≥ 15.0(0.591)	± 1.5(0.060)

(a) If the purchase order specifies a minus tolerance for wall thickness smaller than the applicable value given in this table, the plus tolerance for wall thickness shall be increased by an amount sufficient to maintain the applicable tolerance range.

(b) For pipe with D ≥ 355.6 mm (14.000 in.) and t ≥ 25.0 mm(0.984in.), the wall thickness tolerance locally may exceed the plus tolerance for wall thickness by an additional 0.05r, provided that the plus tolerance for mass (see 9.14) is not exceeded.

(c) The plus tolerance for wall thickness does not apply to the weld area.

(d) See 9.13.2 for

Application

1. API 5L line pipe is preferred in long pipelines due to its inexpensiveness, so it is widely used in gas, water and oil transportation.
2. API 5L line pipe can resist to crack propagation, so it used to pipeline steel.
3. Line Pipe and Sour Service Line Pipes



ASTM A53/ASME SA53 covers black and hot dipped galvanized Electric Resistance Welded steel pipe. Pipe is intended for mechanical and pressure applications and is acceptable for ordinary uses in steam, water, gas and air lines. Pipe is suitable for: welding, forming, threading, flanging, grooving and bending.

LONGMA produces and stocks ASTM A53 ERW Mild Black & Galvanized Steel Pipes.

Type: ERW

Grade: B

Surface: Black, hot-dipped galvanized (HDG)

Available Specification (ASME B36.10M)

Out Diameter: 60.3-660.4mm (NPS 2 to NPS 26)

Wall Thickness: SCH5, SCH10, SCH20, SCH40, STD, SCH60, XS, SCH80, SCH160, XXS

Length: up to 13 meters

Tolerances

Outside Diameter: $\pm 1/64"$ (0.40mm) for size upto & including NPS 1-1/2"

$\pm 1\%$ of the specified O.D. for NPS 2" & above

Thickness: Minimum wall thickness 12.5% max under the specified wall thickness

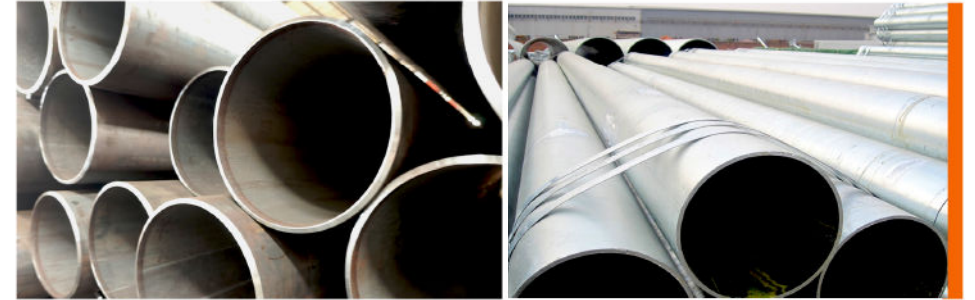
Weight: $\pm 10\%$ of specified weight

Straightness : As mutually agreed with the client

End Finish: Plain Ends (Square Cut), Bevel Ends (Angle 30°, -0°/+5°), Threaded, Roll grooved.

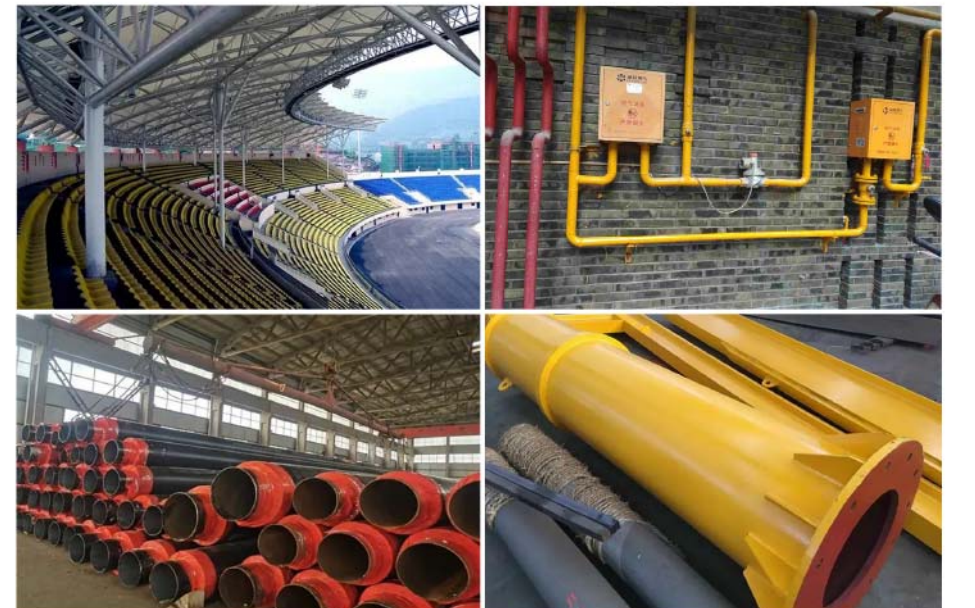
Zinc coating

The coating on the steel pipe shall meet the requirements of ASTM A153 Specification



Application

1. Construction: the pipeline underneath, the groundwater, and the hot water transportation.
2. Mechanical processing, bearing sleeves, processing machinery parts, etc.
3. Electrical: Gas delivery, Hydroelectric power fluid pipeline
4. Anti-static tubes for wind power plants, etc.



EN10219 Cold formed welded structural hollow sections of non-alloy and fine grain structural steels

Part 1: Technical delivery conditions

Part 2: Tolerance, dimensions and sectional properties

Part 3: Technical delivery conditions for high strength and weather resistant steels

LONGMA produces and stocks EN10219 Cold Formed structural hollow sections.

Type: ERW, LSAW

Grade: S235JRH, S275J0H, S275JRH, S355J0H, S355JRH, S355J2H

Surface: Natural, Varnished, Black painting, FBE, 3PE (3LPE), 3PP, FBE, HDG(Hot Dipped Galvanized)

Available Specification

Out Diameter: 114.3-1422mm (4" - 56")

Wall Thickness: 6.02-100mm

Length: up to 18 meters

Tolerances

Outside Diameter: $\pm 1.0\%$ with a min of ± 0.5 mm and a max of ± 10 mm

Thickness: $D \leq 406.4$ mm, $\pm 10\%$ for $T \leq 5$ mm; ± 0.5 mm for $T > 5$ mm

$D > 406.4$ mm, $\pm 10\%$ with a max of ± 2 mm

Weight: $\pm 6.0\%$ on individual lengths for welded pipes

Straightness : $0.20\% * L$, and 3mm over any 1m length

End Finish

Plain Ends (Square Cut), Bevel Ends, Threaded, Roll grooved

Charpy Impact Test

S235JRH/S275JRH/S355JRH: 27J/20°C

S235J0H/S275J0H/S355J0H: 27J/0°C

S235J2H/S275J2H/S355J2H: 27J/-20°C



Application

1. Industries requiring high-performance tubing solutions, such as: construction, oil & gas, automobile, etc.
2. Building structures, bridge structures, and support columns utilize these pipes.
3. Piling oil rigs, underwater pipelines, and offshore platforms.
4. Mining industries utilize these pipes for the transportation of underground water, coal, and other minerals.

Deep Processing

Cutting: plasma cutting, laser cutting, flame cutting.

Bending: hot bending, cold bending.

Welding service: girth welding..

End processing: flaring, shrinking, flange welding, thread processing, etc.



ASTM A671 EFW steel pipe

ASTM A671 specification covers electric-fusion-welded steel pipe with filler metal added, fabricated from pressure vessel quality plate of several analyses and strength levels and suitable for high-pressure service at atmospheric and lower temperatures.

LONGMA produces and stocks ASTM A671 EFW steel pipes.

Type: EFW

Grade: CA55, CB60, CB65, CB70, CC60, CC65, CC70, CD70, CD80, CF65, CF70

Class: 10, 11, 12, 13, 20, 21, 22, 23, 30, 31, 32, 33, 40, 41, 42, 43, 50, 51, 52, 53, 70, 71, 72, 73

Available Specification

Out Diameter: 406.4-1422.2mm (16" - 56")

Wall Thickness: 7.92-50.8mm

Length: 3-12.5 meters

Tolerances

Outside Diameter: $\pm 0.5\%$ of the specified outside diameter

Out of Roundness: 1% (Difference between major and minor outside diameters)

Thickness: -0.3mm(0.01 in),+(no requirement)

Length: -0,+13mm(1/2 in)

End Finish

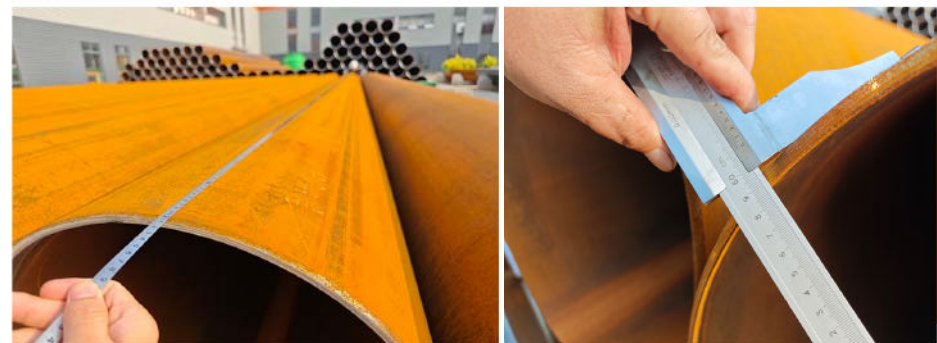
Plain Ends (Square Cut), Bevel Ends (ASME B16.25)

Charpy Impact Test

Supplementary Requirements-S2:

-Standard: ASTM A20/A20M

-Number of Specimens: Base metal/Weld metal/Heat affected zone(HAZ)



Application

It is mainly used for oil and gas transportation pipelines.



ASTM A672 EFW steel pipe

This specification covers steel pipe: electric-fusion-welded with filler metal added, fabricated from pressure-vessel quality plate of any of several analyses and strength levels and suitable for high-pressure service at moderate temperatures.

Type: EFW

Grade: A55, B60, B65, B70, C60, C65, C70

Class: 10, 11, 12, 13, 20, 21, 22, 23, 30, 31, 32, 33, 40, 41, 42, 43, 50, 51, 52, 53

Available Specification

Out Diameter: 406.4-1422.2mm (16" - 56")

Wall Thickness: 6.35-50.8mm

Length: 3-12.5 meters

Tolerances

Outside Diameter: $\pm 0.5\%$ of the specified outside diameter

Out of Roundness: 1% (Difference between major and minor outside diameters)

Thickness: -0.3mm(0.01 in),+(no requirement)

Length: -0,+13mm(1/2 in)

End Finish

Plain Ends (Square Cut), Bevel Ends (ASME B16.25)

Charpy Impact Test

Supplementary Requirements-S2:

-Standard: ASTM A20/A20M

-Number of Specimens: Base metal/Weld metal/Heat affected zone(HAZ)

Application

It is mainly used for oil and gas transportation pipelines.

Chemical Composition %

Steel grade	C max	Si	Mn	P	S
A45	0.17	/	0.98	0.035	0.035
A50	0.22	/			
CA55/A55	0.28	/			
B55	0.2	/			
CB60/B60	0.24	0.13~0.45	1.3	0.035	0.035
CB65/B65	0.28				
CB70/C70	0.31		0.55-0.98		
C55	0.18				
CC60/C60	0.21		0.79-1.30		
CC65/C65	0.24				
CC70/C70	0.27				

Mechanical Properties

Steel Grade	Yield point (N/mm2) max	Tensile Strength (N/mm2)max	Elongation (%)
A45	165	310~450	30
A50	185	345~485	28
A50	185	345~485	28
CA55/A55	205	380~515	27
B55	205	380~515	27
CB60/B60	220	415~550	25
CB65/B65	240	450~585	23
CB70/B70	260	485~620	21
C55	205	380~515	27
CC60/C60	220	415~550	25
CC65/C65	240	450~585	23
CC70/C70	260	485~620	21

Plate Materials

Pipe Grade	Type of Steel	ASTM Specification	
		No.	Grade
Grade A45 Pipe	plain carbon	A285 / A285M	A
Grade A50 Pipe	plain carbon	A285 / A285M	B
Grade A55 Pipe	plain carbon	A285 / A285M	C
Grade B55 Pipe	plain carbon, killed	A515 / A515M	55
Grade B60 Pipe	plain carbon, killed	A515 / A515M	60
Grade B65 Pipe	plain carbon, killed	A515 / A515M	65
Grade B70 Pipe	plain carbon, killed	A515 / A515M	70
Grade C55 Pipe	plain carbon, killed, fine grain	A516 / A516M	55
Grade C60 Pipe	plain carbon, killed, fine grain	A516 / A516M	60
Grade C65 Pipe	plain carbon, killed, fine grain	A516 / A516M	65
Grade C70 Pipe	plain carbon, killed, fine grain	A516 / A516M	70



ASTM A691 EFW steel pipe

This specification covers carbon and alloy steel pipe electric-fusion-welded with filler metal added, fabricated from pressure-vessel-quality plate of several analyses and strength levels and suitable for high-pressure service at high temperatures.

Type: EFW

Grade: 1Cr, 1-1/4Cr, 2-1/4Cr, 3Cr, 5Cr, 9Cr, 91

Class: 10, 11, 12, 13, 20, 21, 22, 23, 30, 31, 32, 33, 40, 41, 42, 43, 50, 51, 52, 53

Available Specification

Out Diameter: 406.4-1422.2mm (16" - 56")

Wall Thickness: 6.35-100mm

Length: 3-12.5 meters

Tolerances

Outside Diameter: ±0.5% of the specified outside diameter

Out of Roundness: 1% (Difference between major and minor outside diameters)

Thickness: -0.3mm(0.01 in),+(no requirement)

Length: -0,+13mm(1/2 in)

End Finish

Plain Ends (Square Cut), Bevel Ends (ASME B16.25)

Charpy Impact Test

Supplementary Requirements-S2:

-Standard: ASTM A20/A20M

-Number of Specimens: Base metal/Weld metal/Heat affected zone(HAZ)

Application

It is mainly used for oil and gas transportation pipelines.

Chemical Composition %

%	C	Mn	P	S	Si	Cr	Mo	V
1CR	0.05-0.17	0.40-0.65	0.025	0.025	0.15-0.40	0.80-1.15	0.45-0.60	-
1-1/4CR	0.05-0.17	0.40-0.65	0.025	0.025	0.50-0.80	1.00-1.50	0.45-0.65	-
2-1/4 CR	0.05-0.15	0.30-0.60	0.025	0.025	0.50	2.00-2.50	0.90-1.10	-
3Cr	0.05-0.15	0.30-0.60	0.025	0.025	0.50	2.75-3.25	0.90-1.10	-
5 CR	0.15	0.30-0.60	0.025	0.025	0.50	4.00-6.00	0.45-0.65	-
9 CR	0.15	0.30-0.60	0.025	0.025	1.00	8.00-10.00	0.90-1.10	0.04
91	0.08-0.12	0.30-0.60	0.02	0.01	0.20-0.50	8.00-9.50	0.85-1.05	0.18-0.25

*Grade 91 also includes restrictions on Nickel 0.40 max, Columbium 0.06-0.10, Nitrogen 0.030-0.070, Aluminum 0.02 max, titanium 0.01 max, Zirconium 0.01 max.

Mechanical Properties

Class 1 Plates

Grade	Tensile (MPa)	Yield (MPa)	Elong. (50mm)	Reduc'n of Area*
1CR	380 - 550	230 min	22% min	-
1-1/4CR	415 - 585	240 min	22% min	-
2-1/4CR, 3Cr, 5CR, 9CR	415 - 585	205 min	18% min	40% min
91	415 - 585	205 min	18% min	40% min

Class 2 Plates

Grade	Tensile (MPa)	Yield (MPa)	Elong. (50 mm)	Reduc'n of Area*
2	485 - 620	310 min	22% min	-
1-1/4CR	515 - 690	310 min	22% min	-
1CR	450 - 585	275 min	22% min	-
2-1/4CR, 3Cr, 5CR, 9CR	515 - 690	310 min	18% min	40% min
91	585 - 760	415 min	18% min	-



ASTM A500 Cold Formed Welded steel pipe

LONGMA produce and stock high quality ASTM A500 Cold Formed Welded Steel Pipes, widely used in building structure, machinery and equipment, transportation and other fields.

Grade: A, B, C, D

Available Specification

Out Diameter: 114.3-1422mm(4"-56")

Wall Thickness: 6.02-101.6mm(0.237"-4")

Length: ≤6.5m(-6,+13mm);>6.5m(-6,+19mm)

Tolerances

Outside Diameter: ≤48.0mm: ±0.5%; ≥50mm: ±0.75%

Thickness: ±10%

Length: -0,+13mm(1/2 in)

End Finish

Plain Ends (Square Cut), Bevel Ends (ASME B16.25)

Chemical Composition

Element %	Grades A, B and D				Grade C
	Heat		Product		
	Analysis	Analysis	Analysis	Analysis	
Carbon, max	0.26	0.3	0.23	0.27	
Manganese, max	1.35	1.4	
Phosphorus, max	0.035	0.045	0.035	0.045	
Sulfur, max	0.035	0.045	0.035	0.045	
Copper, when specified, min	0.2	0.18	0.2	0.18	

Mechanical Property

Round Structural Tubing	Grade A	Grade B	Grade C	Grade D
Tensile strength, min, psi (MPa)	45 000	58 000	62 00	58 000
	310	400	427	400
Yield strength, min, psi (MPa)	33 000	42 000	46 000	36 000
	228	290	317	250
Elongation in 2 in. (50.8 mm), min, %	25	23	21	23

ASTM A252 Welded Steel Pipe Piles

LONGMA specialize in manufacturing high-quality steel pipe piles that fully comply with ASTM A252 standards. Our products are specifically designed for foundation and marine construction applications, offering superior strength and durability for driven pile foundations.

Grade: 1, 2, 3

Available Specification

Out Diameter: 219.1-1016mm(8"-40")

Wall Thickness: 8.18-25mm

Length: SRL 4.88-7.62m; DRL 7.62-10.67m

Tolerances

Outside Diameter: ±1%D

Thickness: -12.5%

Length: ±1 inch if specified length

Chemical Composition

%	C, max	Si, max	Mn, max	P, max	S, max
Grade 1	0.26	0.45	1.6	0.05	0.03
Grade 2	0.26	0.45	1.6	0.05	0.03
Grade 3	0.26	0.45	1.6	0.05	0.03

*The steel shall contain no more than 0.050% phosphorous.

Mechanical Property

Mechanical Property	Minimum Yield strength ReH MPa	Tensile strength Rm MPa	Minimum elongation A %
Grade 1	205	345	30
Grade 2	240	415	25
Grade 3	310	455	20



AS/NZS 1163: 2016 Cold Formed Structural Steel Hollow Sections

LONGMA is China leading manufacturers and suppliers of longitudinal welded cold-formed structural steel hollow sections for general structural and engineering applications.

Grade: C250, C350, C450; C250L0, C350L0, C450L0

Available Specification

Out Diameter: 114.3-1142.2mm(4"-56")

Wall Thickness: 6.02-50.8mm(0.237" - 2")

Length: 3-12.5 meters

Tolerances

Circular Shape - Tolerances on dimensions

External Dimensions (D): $\pm 1\%$, with a minimum of ± 0.5 mm

Thickness (T): $\pm 10\%$ of specified Wall Thickness

Out-of-roundness: 2% for hollow sections having $d/t \leq 100$

Straightness (e): 0.20% of total length

Mass per unit length: Not less than 0.96 times the specified mass

Chemical Composition %

Grade	C	Si	Mn	P	S	Mo	Al	Ti	Micro-alloying elements	CEV
C250	0.12	0.05	0.50	0.04	0.03	0.10	0.10	0.04	0.03	0.25
C250L0	0.12	0.05	0.50	0.04	0.03	0.10	0.10	0.04	0.03	0.25
C350	0.20	0.25	1.60	0.04	0.03	0.10	0.10	/	0.15	0.43
C350L0	0.20	0.25	1.60	0.04	0.03	0.10	0.10	/	0.15	0.43
C450	0.20	0.45	1.60	0.04	0.03	0.35	0.10	/	0.15	0.43
C450L0	0.20	0.45	1.60	0.04	0.03	0.35	0.10	/	0.15	0.43

Mechanical Property

Grade	Yield strength ReH MPa	Tensile strength Rm MPa	Elongation A %	Impact energy test temperature/Individual test/Average of 3 tests/(J)
C250	250	320	22	/
C250L0	250	320	22	0°C/20/27
C350	350	430	20	/
C350L0	350	430	20	0°C/20/27
C450	450	500	16	/
C450L0	450	500	16	0°C/20/27

Applications



LONGMA has four sets SAWL (JCO/JCOE method) straight seam double-sided submerged arc welded steel pipe production lines, which can produce 300,000 tons of SAWL steel pipes per year. The steel pipes can be used for various purposes such as land and marine natural gas transportation, shale gas, petroleum, petrochemicals, urban gas, water and slurry transportation, and are also widely used in construction, bridges, offshore platforms, power and other engineering fields.

Diameter: $\Phi 406.4 \sim \Phi 1422 \text{mm}$.
 Wall thickness: 6.3~50.8mm.
 Length: up to 18.3 meters.

Steel grade:

1. Line pipe: L245/B~L555/X80, PSL1 & PSL2, Sour service;
2. Carbon steel: Q235~Q460, CC60/C60, CC65/C65, CC70/C70, C350/C450, S235/S355JR/J2..

Standard: API SPEC 5L (46th edition), GB/T 3091-2015, ASTM A671, ASTM A672, ASTM A691, ASTM A252, ASTM A500, AS/NZS 1163, EN10219.

LONGMA is equipped with advanced testing equipments and standardized testing procedures to ensure that every steel pipe received by the customer meets the requirements.

Every steel plate that arrives at the factory is ultrasonically tested, during the production process, inspectors will conduct multiple rounds of inspections on the products to ensure that the dimensional performance meets the standards and every weld is double-tested by X-ray and ultrasonic testing to ensure that the product is defect-free, and every test is traceable..



UT on plates & sampling



RT on weld seam



Tensile test



UT on weld seam



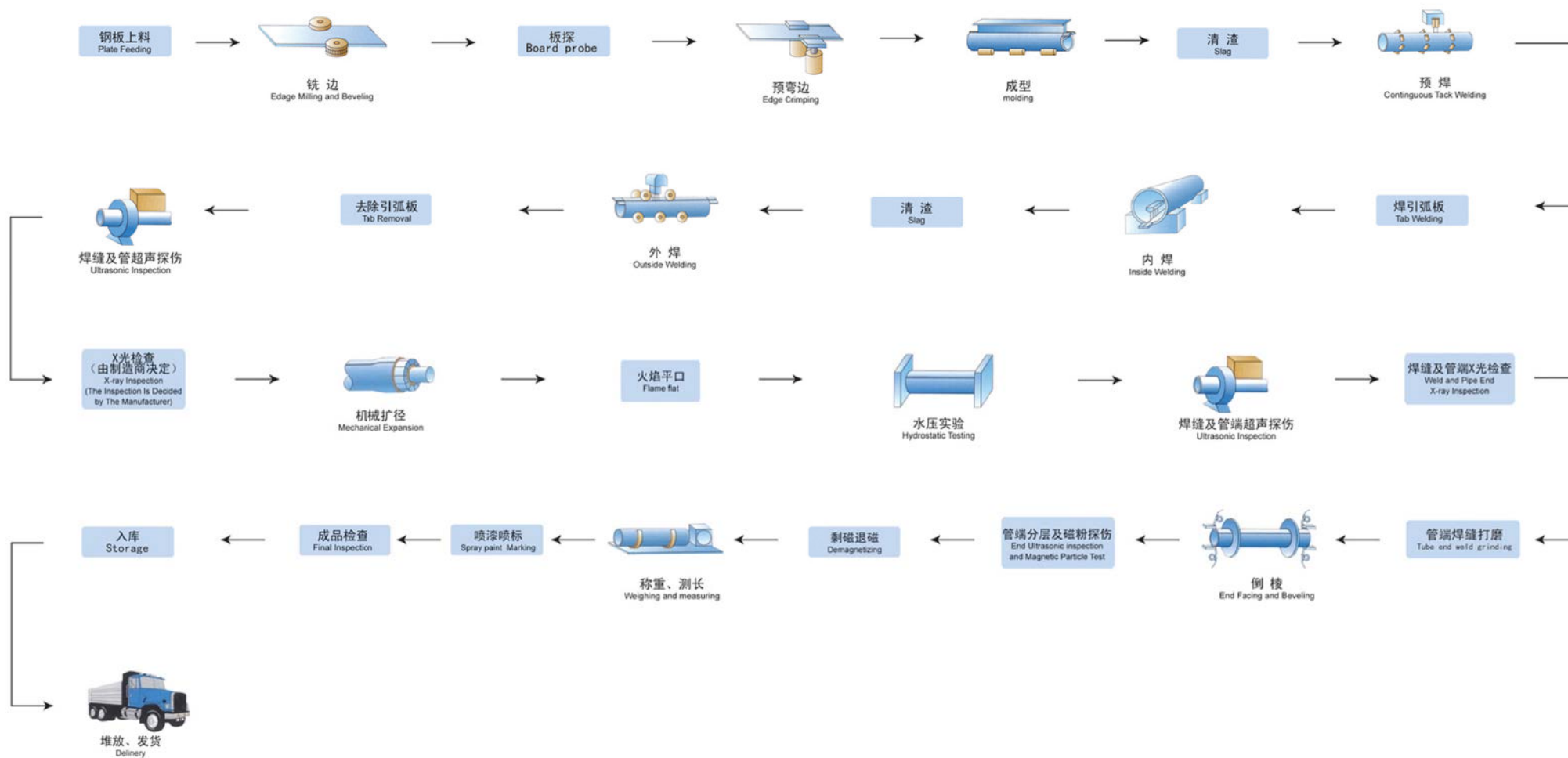
Dimension check



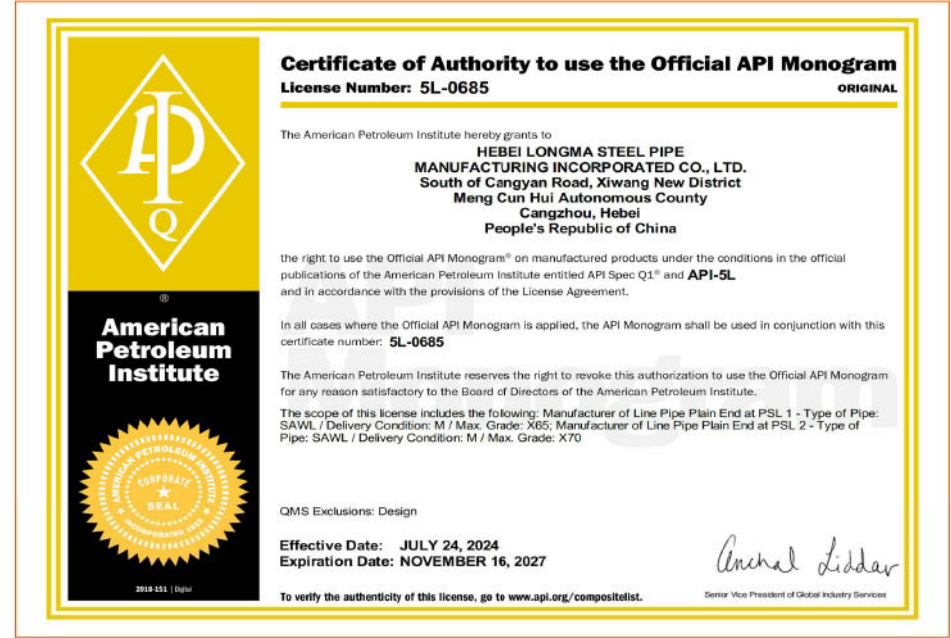
Dimension check

JCOE Steel Pipes Manufacturing Process

This production line is a large-diameter straight seam double-sided submerged arc welding production line, which adopts progressive bending forming process, has uniform stress distribution and good pipe shape. It adopts the typical configuration of JCOE factory, and its characteristics are large product specification range, fast and simple specification change, and can realize products of any pipe diameter size within the production range.



LONGMA has obtain API 5L, ISO9001, ISO14001, ISO45001, Q/SHS 0001.1-2001, Factory Production Control Certificate to BC 1:2012(FPC/ABS Consulting).



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THE INTERNATIONAL CERTIFICATION NETWORK

CERTIFICATE

CQM has issued an IQNet recognized certificate that the organization:

Hebei Longma Steel Pipe Manufacturing Co.,Ltd.

Certification Add.:South End of Cangyan Road, Xiwang New District, Meng Village Hui Autonomous County, Cangzhou City, Hebei, P.R.China

for the following scope:

Production of grade A straight seam submerged arc steel pipe

has implemented and maintains a

Quality Management System

which fulfils the requirements of the following standard:

ISO 9001:2015

Issued on:2022-11-06
Expires on: 2025-11-06

This attestation is directly linked to the IQNet Partner's original certificate and shall not be used as a stand-alone document

Registration Number: CN-00222Q26379R2S



Alex Stoichitoiu
President of IQNet



Ji XiaoDong
General Manager of CQM



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THE INTERNATIONAL CERTIFICATION NETWORK

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Hebei Longma Steel Pipe Manufacturing Co.,Ltd.

Certification Add.:South End of Cangyan Road, Xiwang New District, Meng Village Hui Autonomous County, Cangzhou City, Hebei, P.R.China

for the following scope:

Production of grade A straight seam submerged arc steel pipe

has implemented and maintains a

Environmental Management System

which fulfils the requirements of the following standard:

ISO 14001:2015

Issued on:2022-11-06
Expires on: 2025-11-06

This attestation is directly linked to the IQNet Partner's original certificate and shall not be used as a stand-alone document

Registration Number: CN-00222E33969R2S



Alex Stoichitoiu
President of IQNet



Ji XiaoDong
General Manager of CQM



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