

**HEBEI ABTER STEEL GROUP**  
**HEBEI ABTER STEEL PIPE CO.,LTD**

Office Address: 7th Floor,Shengji International Building,  
Beijing Road,Yunhe District,Cangzhou City,Hebei Province,China  
Tel : +86-317-3736333 Fax: +86-317-2011165

Factory Address: 1826# Lijiapuqiao Road,Mengcun County,  
Cangzhou City, Hebei Province, China  
Tel:+86-0317-8986625 Email: [Info@hebei-tube.com](mailto:Info@hebei-tube.com) Web:[www.abtersteel.com](http://www.abtersteel.com)







To Create "Sunny Ecosphere" of Steel Trade Industry

## ● ● ● ● CONTENTS

- 03-06 Company profile
- 07 Organization culture
- 08 Organization framework

### ERW steel pipe

- 09-10 Manufacturing processes
- 11-12 Manufacturing equipments
- 13-14 Production standards

### LSAW steel pipe

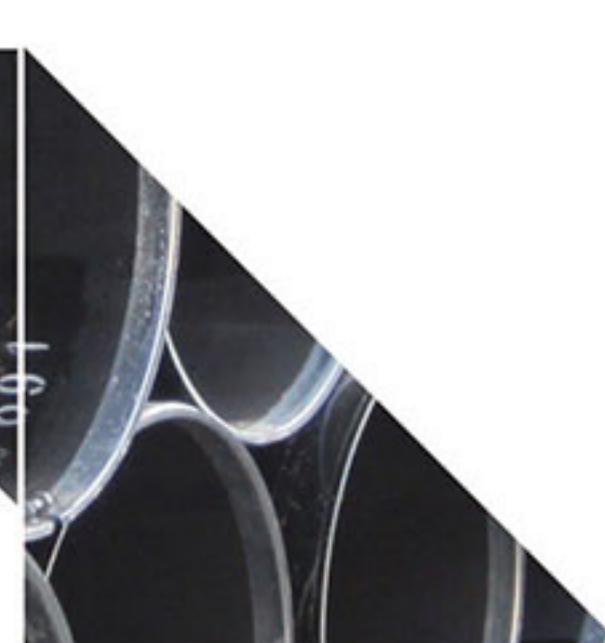
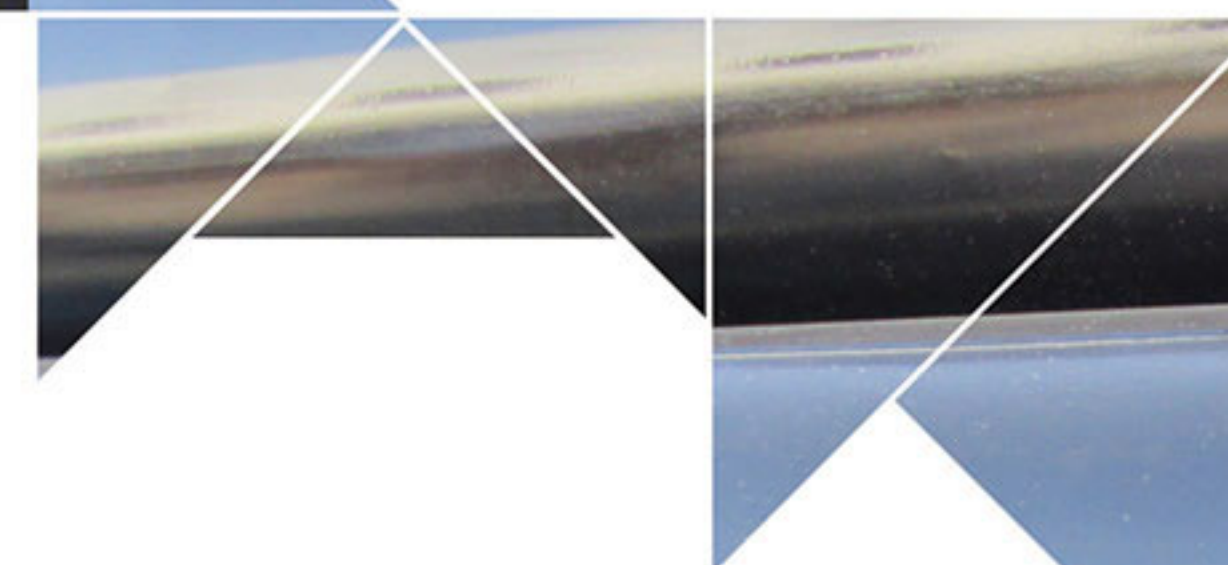
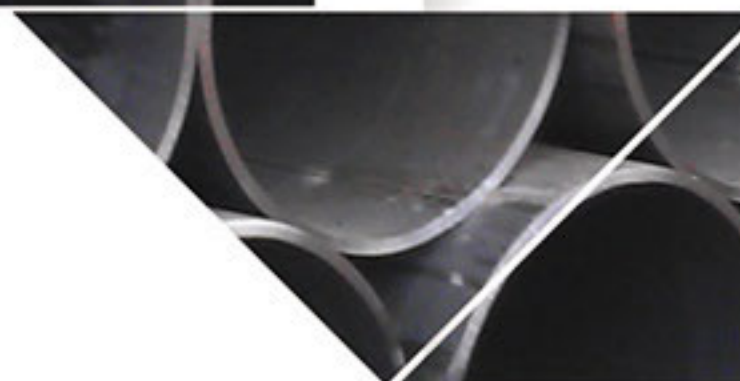
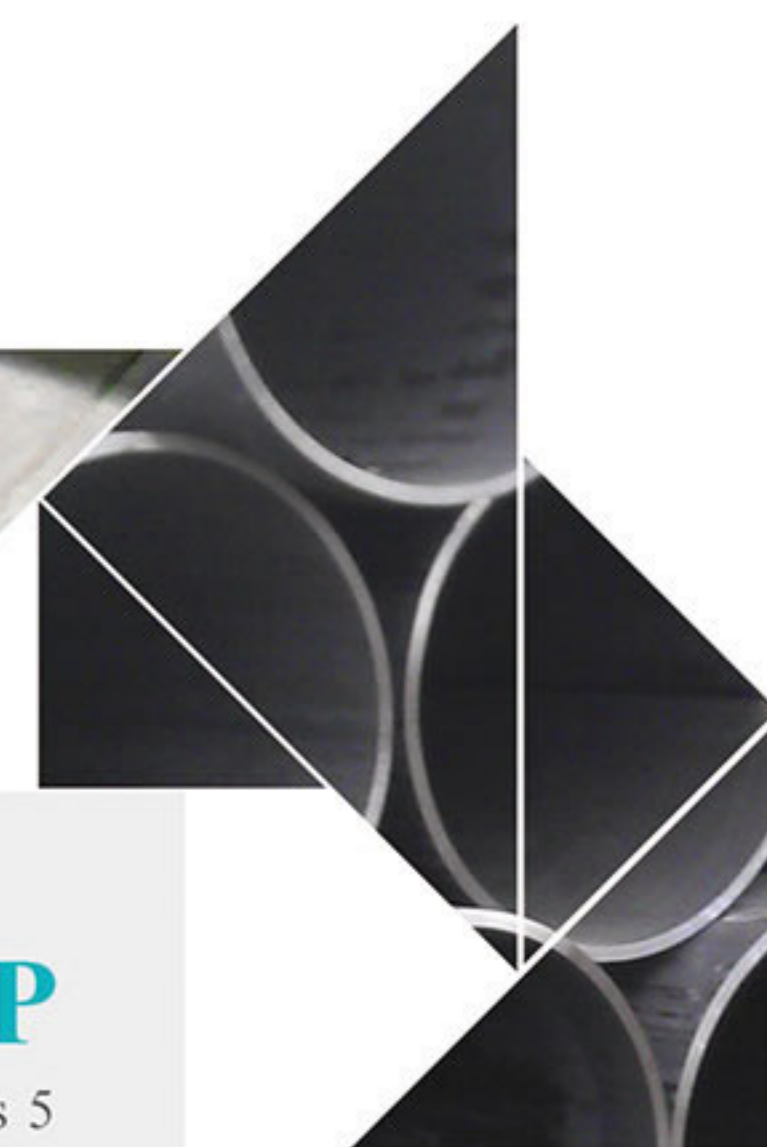
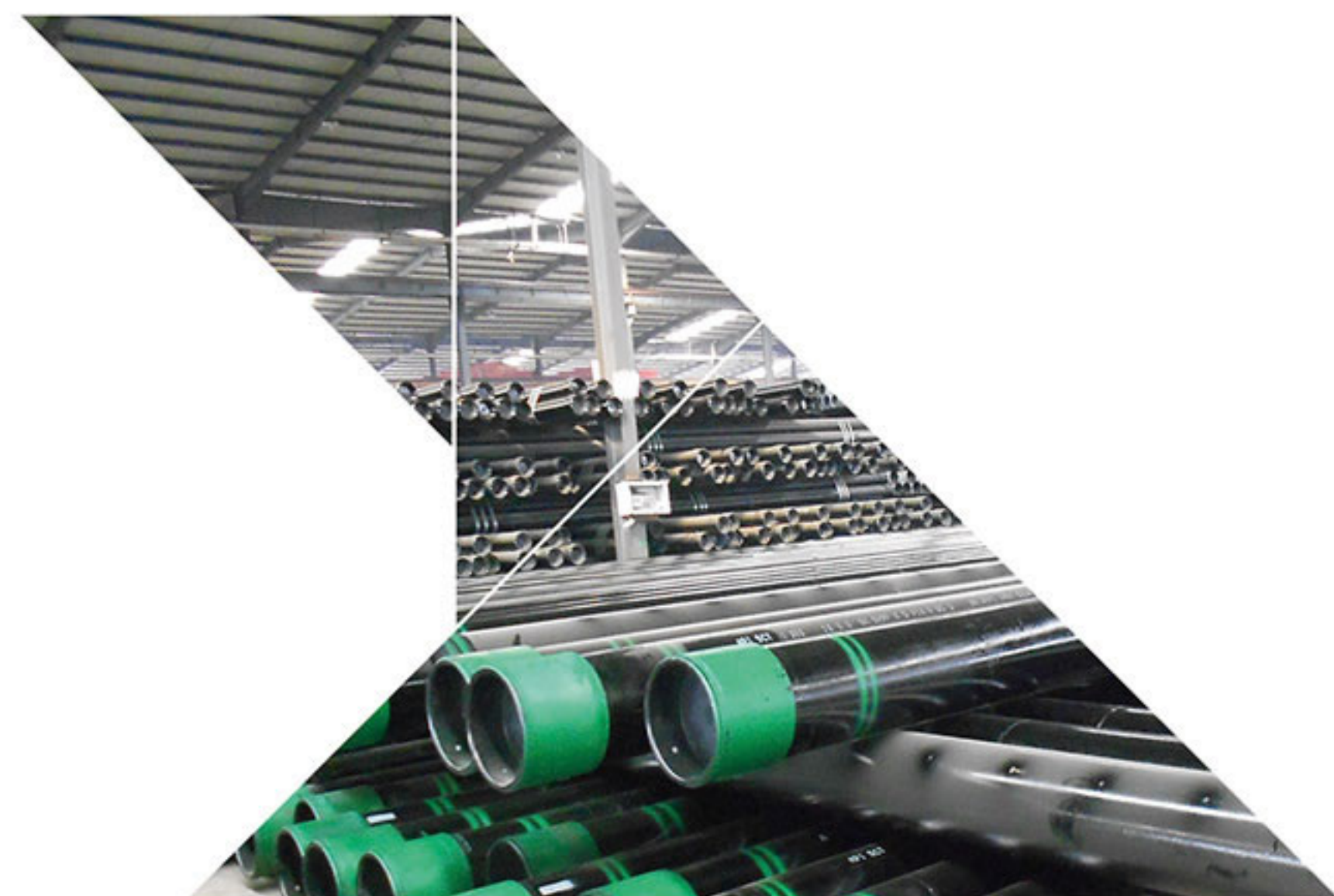
- 15-16 Manufacturing processes
- 17-18 Manufacturing equipments
- 19-20 Production standards

### SSAW/SAWH steel pipe

- 21 Manufacturing processes
- 22 Manufacturing equipments
- 23-24 Production standards
- 25 Coatings
- 26 Pile

- 27-28 Testing equipments and quality management
- 29-30 Marketing and customers





## HEBEI ABTER STEEL GROUP

Approved by Hebei Entry-Exit Inspection and Quarantine Bureau and has 5 manufacture bases in China, ABTER STEEL GROUP is a group company which integrates production, sales and service of steel pipes. The company not only provides active online transaction but also integrates four resources including supply chain, quality control and warehouse logistics as well as provides the customers with sufficient information transparency, so as to reduce the purchasing cost of the customers, promote the efficiency of commodity circulation and share interests with the customers. Setting "exploration and innovation, mutual aid and win-win, and striving to be the "good helper" of steel users" as its mission, the company is committed to create "sunny ecosphere" of steel trade industry to make steel trade more efficient and sunny and ultimately realize win-win cooperation with industrial users.

ABTER STEEL GROUP is committed to create a "seamless transaction platform" which integrates customization, spot goods supermarket, quality control, warehouse logistics and supporting services. The company holds following advantages after years of development:

1. As the direct sales window of steel factory, the company can provide the customers with high quality products with preferable price. Meanwhile, the diversified steel products allows for integrative purchase and full services for the customers to save enterprise cost.
2. Our group has the warehouse covering an area of 5,0000 square meters where abundant steel pipes are stored on long-term basis to meet the emergency need of foreign customers and domestic programs. Additionally, our group has developed many professionals who are very familiar with steel trades, know the situation of each key warehouse in China explicitly and get in wide and deep touch with warehouse logistics institutions across China.

## COMPANY PROFILE

3. Based on the belief that safety and quality makes the achievement of future, Hebei Entry-Exit Inspection and Quarantine Bureau not only strictly controls the quality of products from the five steel plants but also goes to the plant and supervises the production process and production equipment safety from time to time for the purpose of ensuring the interests of the customers at the source.

4. Our group has a wholly-owned international logistics company-Hebei Haichuan International Logistics Agency Limited, which possesses professional transportation team and maintains long-term cooperation with various large shipping companies to minimize the transportation cost for the customers and deliver their goods to the destination safely and timely as well as realize simpler and more reliable steel transportation.

We have exported to more than thirty countries and regions all over the world. The company has extensive marketing network for different fields such as automobile, household appliances, petrochemical, manufacture of machinery, energy, transportation, metalwork, aeronautics and astronautics, nuclear power and electronic instruments. By providing refined services based on the requirement of enterprises in steel industry for reduced purchasing cost and improved decision accuracy and by means of resource integration, ABTER STEEL GROUP has been widely recognized in the industry. We have exported to more than thirty countries and regions all over the world. The company has extensive marketing network for different fields such as automobile, household appliances, petrochemical, manufacture of machinery, energy, transportation, metalwork, aeronautics and astronautics, nuclear power and electronic instruments.



## HEBEI ABTER STEEL PIPE CO.,LTD

As one of the subsidiary companies under Abter Steel Group, Hebei Abter Steel Pipe Co.,Ltd is a large enterprise for high performance-price ratio welded and seamless steel pipes covering various steel grades. We have set up extensive international sales network covering Middle East, Southeast Asia, South Africa, Europe, the Americas etc. with powerful financial strength, advanced managerial concept, excellent marketing service, strict quality control system and the whole scientific method, Abter has become to one of the major exporters of OCTG and line pipe for crude oil and natural gas delivery in China. And with the professional "Can-do" approach, Abter Steel is well acclaimed by the Client at home and abroad.

### The range of our products:

Seamless steel pipe(OD:13.72-1426mm, WT:1.25-160mm)

ERW steel pipe (OD:6-610mm, WT:max26.5mm)

SSAW steel pipe(OD219.1-3220mm, WT:max26mm)

LSAW steel pipe(OD340-1820mm, WT :max 160mm)

### The rules of our company(4B):

1. Best price: Abter believes in customers' satisfaction due to money saving
2. Best quality: Abter believes in durability of equipment
3. Best leadtime: Abter respects to the time schedule planned by the esteemed customers
4. Best reliability: Abter believes in providing high quality products and reliable after sales services.

Welcome to contact or visit us for further information ,we sincerely hope to establish long-term cooperation



## HEBEI HAICHUAN INTERNATIONAL FORWARDERS LIMITED

Founded on August 8, 2008, HEBEI HAICHUAN INTERNATIONAL FORWARDERS LIMITED is a company subordinated to HEBEI ABTER STEEL GROUP. Holding abundant logistics knowledge and experienced professionals, the company mainly handles businesses related to international transportation such as international shipping, international air transport, commodity inspection, customs declaration, storage and cargo insurance. The company provides domestic and foreign importers, exporters and manufacturers with safe, rapid and quality global logistics and supply chain services by adhering to the "integrity-based and service-oriented" philosophy. Relying on its "window" advantage, the company has established good and close long-term cooperative relationship with various world-renowned shipping companies (OOCL, MAERSK, EVERGREEN, PIL, WANHAI, MSC, YANGMING, CMA, HANJIN, COSCO, etc.) Its international networks spread all over Europe, America, Africa, Australia, Japan, Southeast Asia and Middle East and provide customs clearance, transshipment, freight collect, home service and imported goods transportation at various main ports all over the world. We will do our best to provide most professional and intimate services for every customer. Making it as our mission to protect the interests of the customers, we will truly repay every customer with sincerity and high efficiency, and control every risk practically, soundly and broadly.







# CULTURE

OPERATION TARGET:  
To create "sunny ecosphere" of steel trade industry

ADMINISTRATION MODE:  
Human-oriented, standardized and digitalized administration

CORE VALUE:  
Gratitude, diligent, realistic, persistent

SERVICE CONCEPT:  
Customer first, reputation first

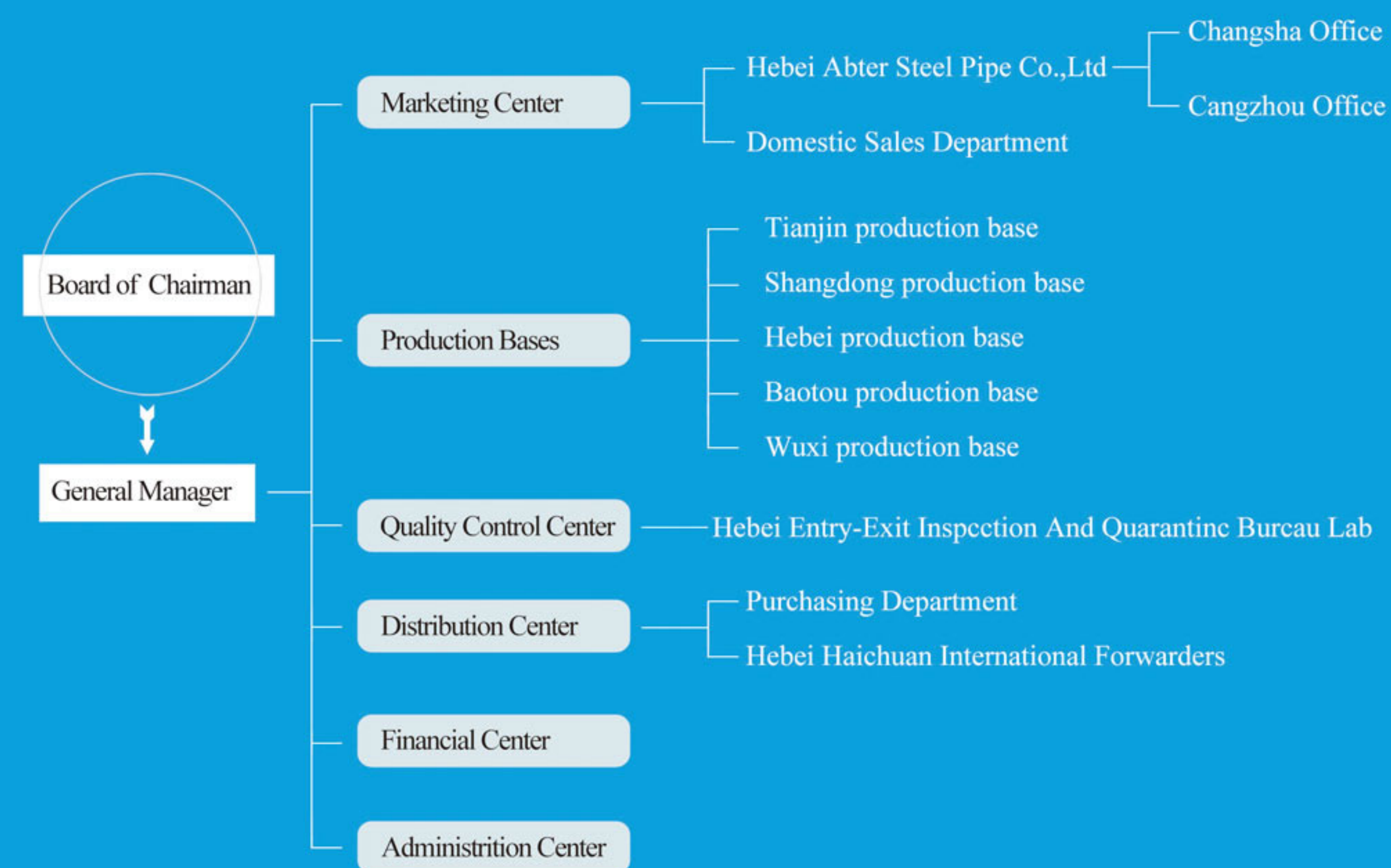
QUALITY CONCEPT:  
Development depends on quality, while quality comes from details

ACTION NORM:  
Actively and efficiently

GRATITUDE, DILIGENT, REALISTIC, PERSISTENT

ABTER

## ORGANIZATION FRAME





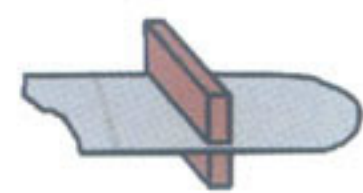
## ERW STEEL PIPE MANUFACTURING PROCESSES



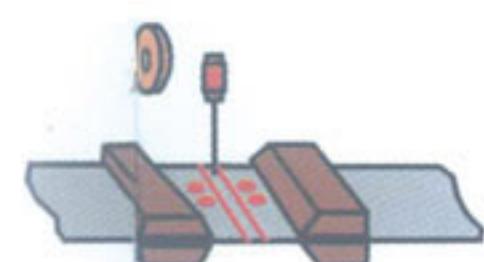
1. Decoiling



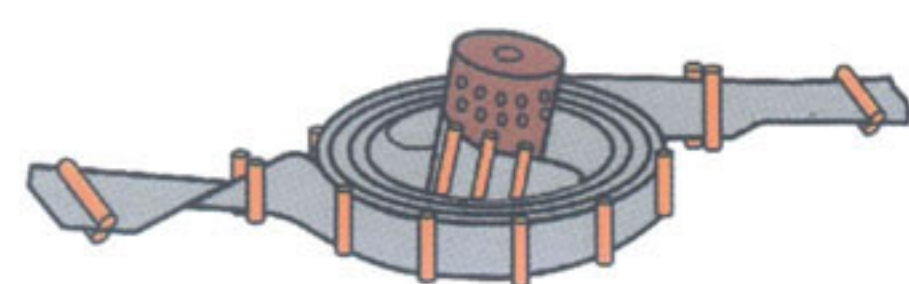
2. Flattening



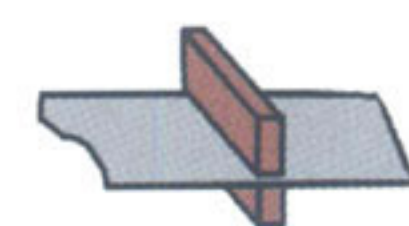
3. End Cropping



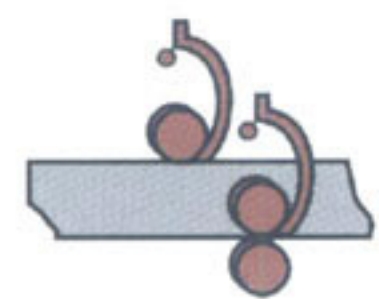
4. Butt Welding



5. Superior Accumulator



6. Flying Cut-off Device



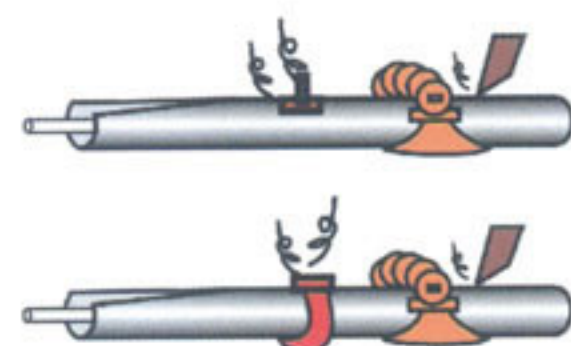
7. Edge Milling



8. Board Exploration



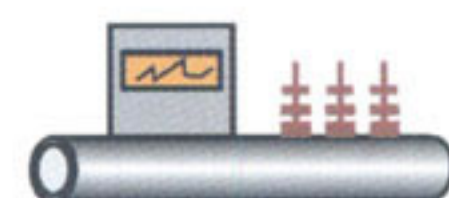
9. Forming



10. Contact Welding / Induction Welding



11. Foreign burr scraping



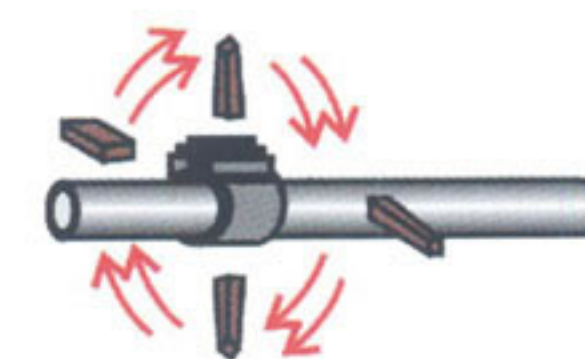
12. Ultrasonic Test



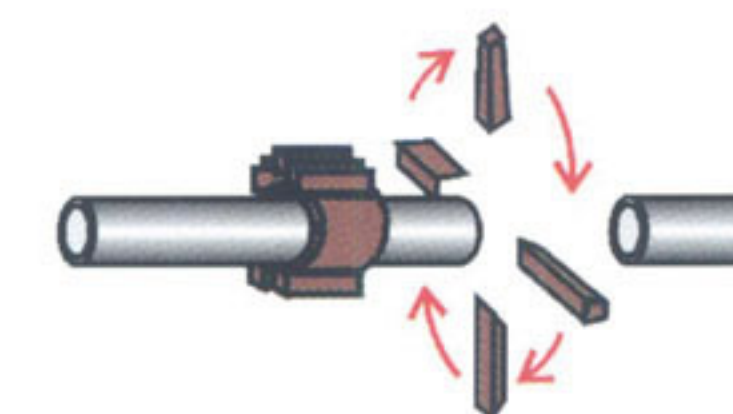
13. If Heat Treatment



14. Sizing



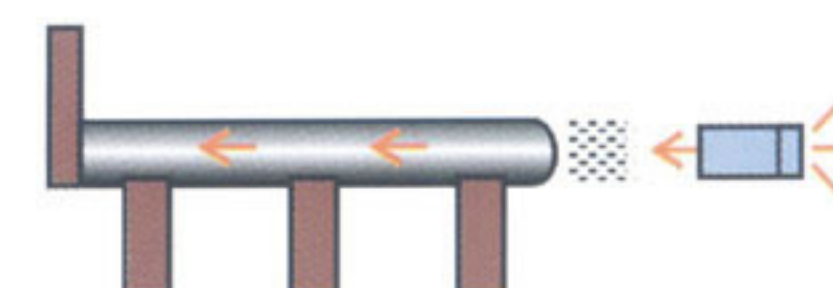
15. Flying Saw



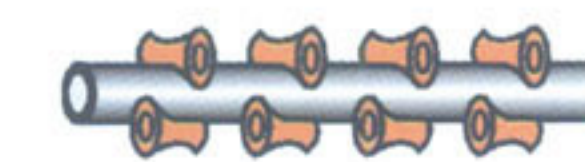
16. Sampling



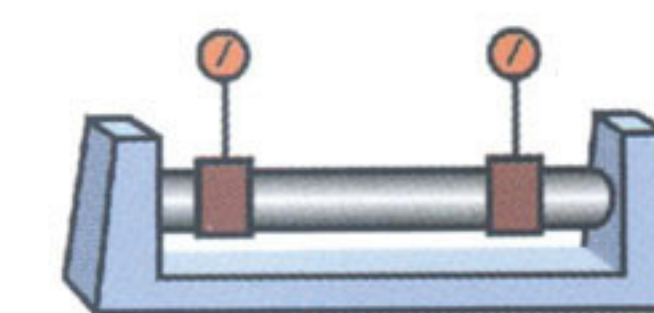
17. Flattening Test



18. Scrap Remove



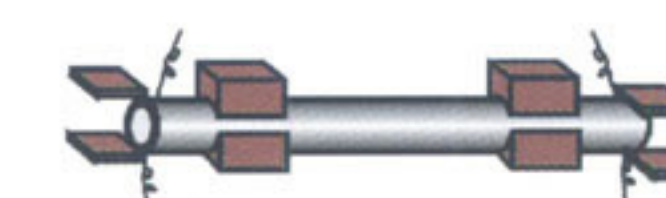
19. Straightening



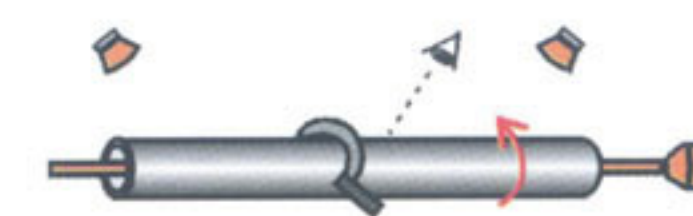
20. Hydraulic Test



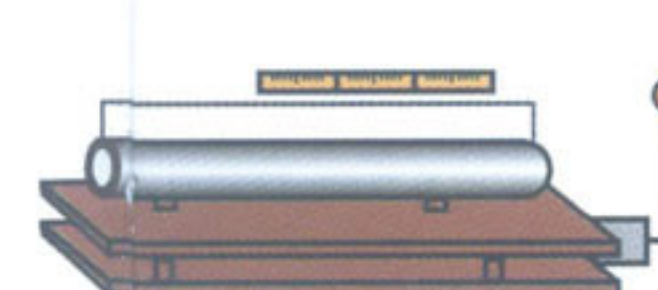
21. Eelding Seam Ultrasonic Test(UT)  
on the Pipe Body, Pipe-end



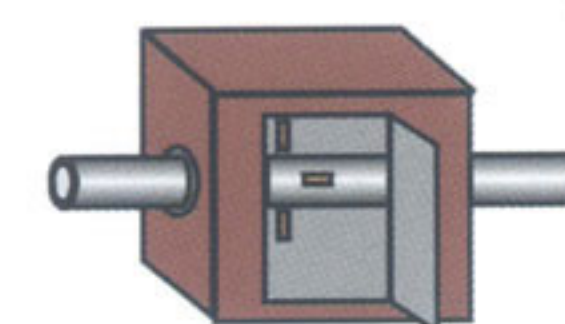
22. End Facting and Chamfering



23. Visual Inspection



24. Measuring, Weighing,  
Marking and Printing



25. Painting



26. Storage



## ERW STEEL PIPE MANUFACTURING EQUIPMENTS



**On-line Super Spiral Accumulator**

Super spiral accumulator is famous for large storage, high in and out speed and maintaining good plate surface quality, as well as advanced equipment in obtaining ideal pipe surface and larger capacity.



**on-line Advanced Straight Edge Case Forming Process**

case forming introduces the advantages of roll forming, and eliminates the "eaving" defect in fabricating thin, large diameter pipe. Our steel pipe's straight edge casing forming process has adopted substantial innovations based upon traditional casing forming. In traditional case forming, the plate edges rebound fiercely, while straight edge case forming can restrict the plate to a smooth, natural moving track, overcoming the disadvantages of traditional case forming, the whole forming process is more flexible, and the quality of formed pipe is greatly improved. By this method, the edges are well controlled, and pipes have highly accurate dimensions and better surface quality, and retain the mechanical properties of raw materials are primely retained.

**On-Line SXFJ610 Digital Rotatory Cutting Machine**

This machine is the most advantaged homemade digital flying cutting machine, which is equated with the most advanced machines abroad. This machine is equipped with high accuracy fact microcomputer system, can accurately fix the length, get perfect cross section, without flash, Eend facing and beveling machines also ensure the pipe and quality



**Off-line UT test**

**On-Line Weld Seam Annealing**

Three intermediate seam annealing machines of different frequency reheat the quenched welded pipes to above the critical temperature, applying normalizing and tempering and annealing on the seam, so as to achieve utmost stress relief and eliminate potential crack, the fine grain structures produced hereby ensure pipes to meet all specifications of the standard. This on line weld seam annealing settings adopt piecewise return and plane heating mode, the entire course is under PLC autocontrol and temperature inducting closed-circuit system, the weld seam is subject to part and quick heating, the oxidation of steel pipe is minimized and accurate and accordant conductivity conduce to the fine grain structure of weld seam,



**Sizing, Straightening Unites**

Equipment for steel tube diameter, straightness of finishing.



**On line UT**



**Hydrostatic Tester**



**Flattening machine**



**Marker**



## ERW STEEL PIPE PRODUCTION STANDARDS

Standard: API SPEC.5L PSL1, API SPEC.5L PSL2, API5CT  
 Dimension: OD:6mm-610mm, WT:max26.5mm  
 Length: 5.8m-22m  
 Steel Grade

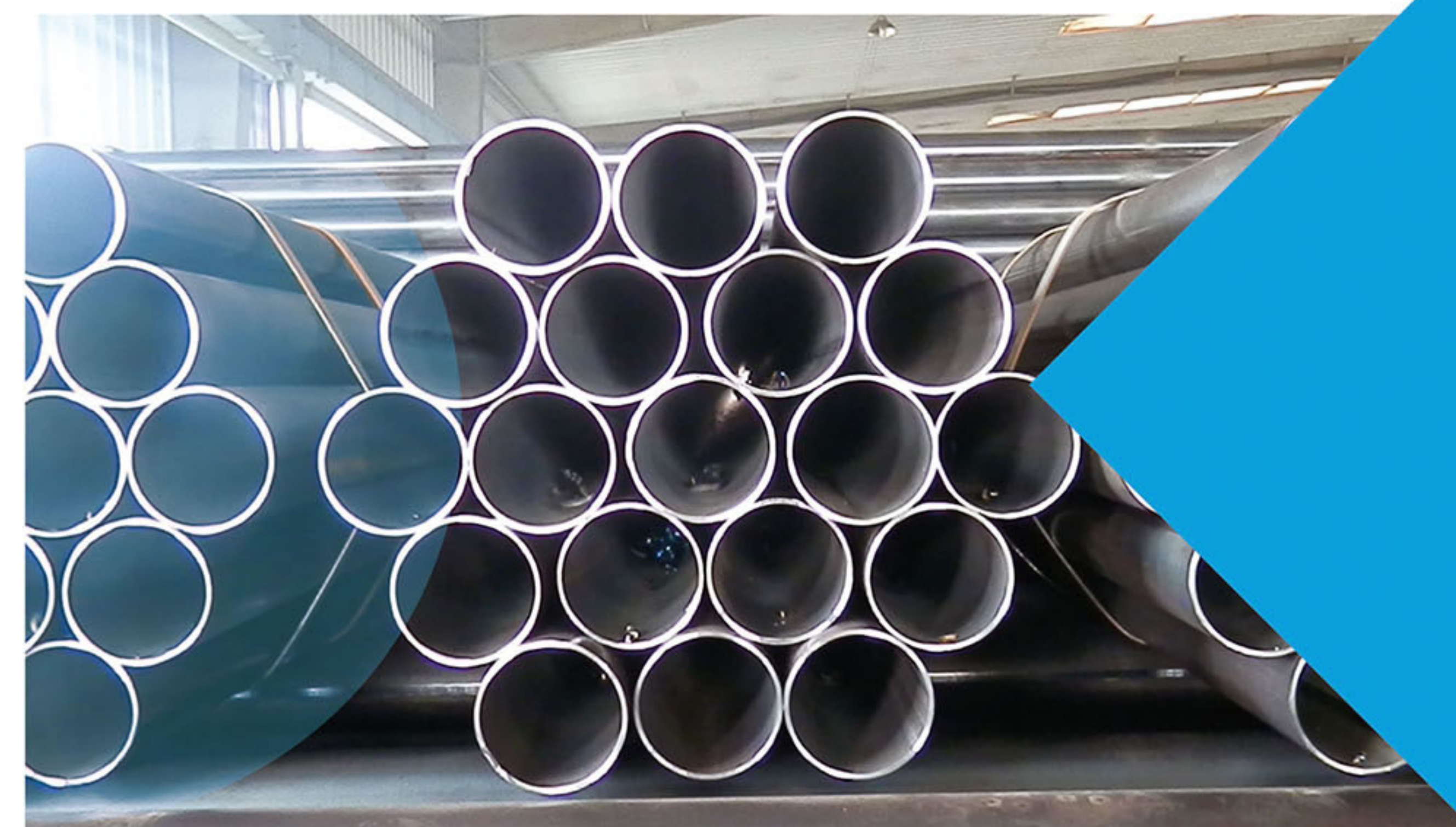


No.	Name	Standard	Grades	Uses
1	Oil Casing	API SPEC5CT	H40, J55, K55, N80-1	For oil-gas well casing
2	Line Pipe	API SPEC 5L ISO 3183	A, B—X80 L210—L555	For the pipeline transportation of oil and natural gas

End: square ends (straight cut, saw cut, and torch cut), or beveled for welding, beveled,

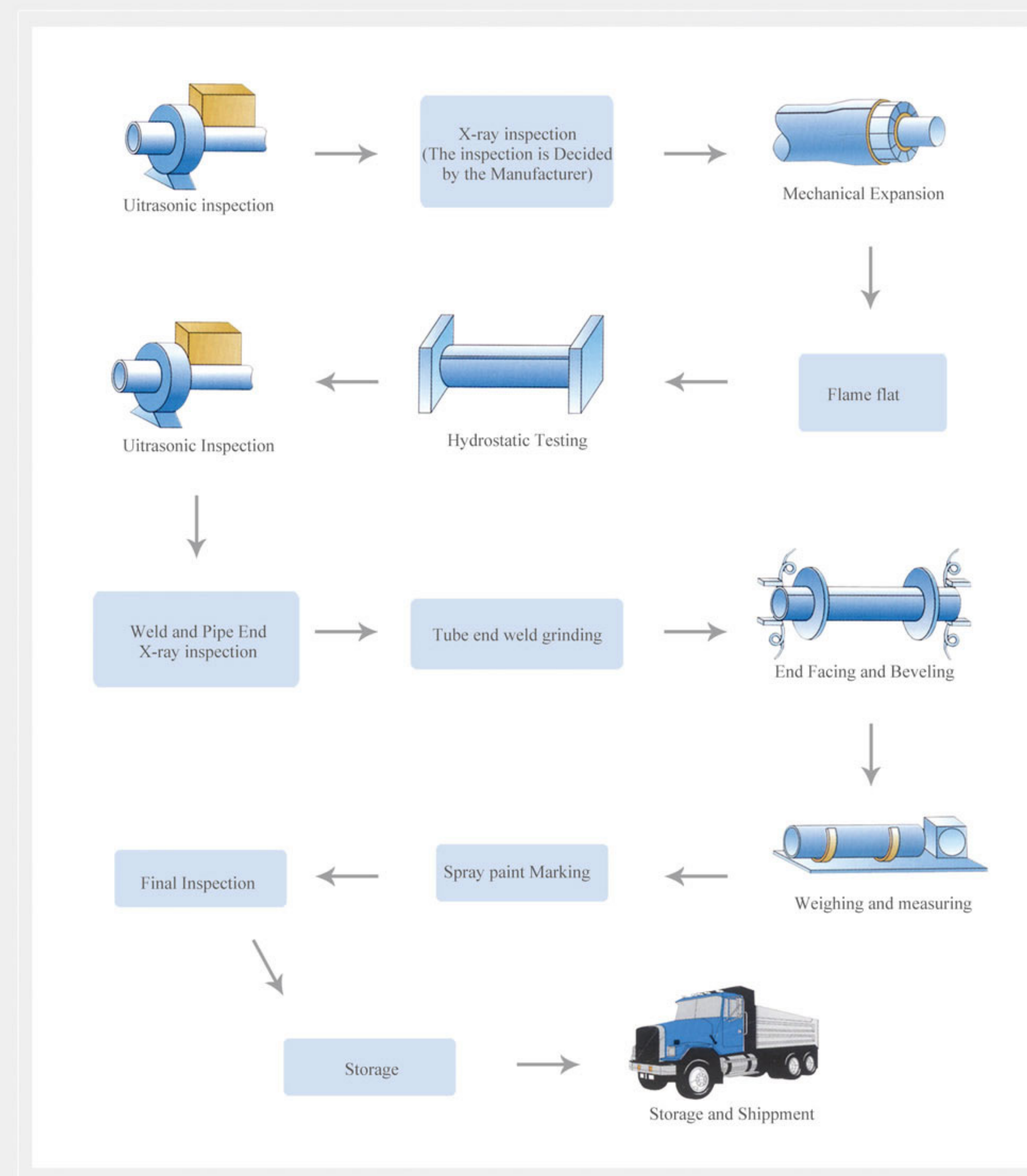
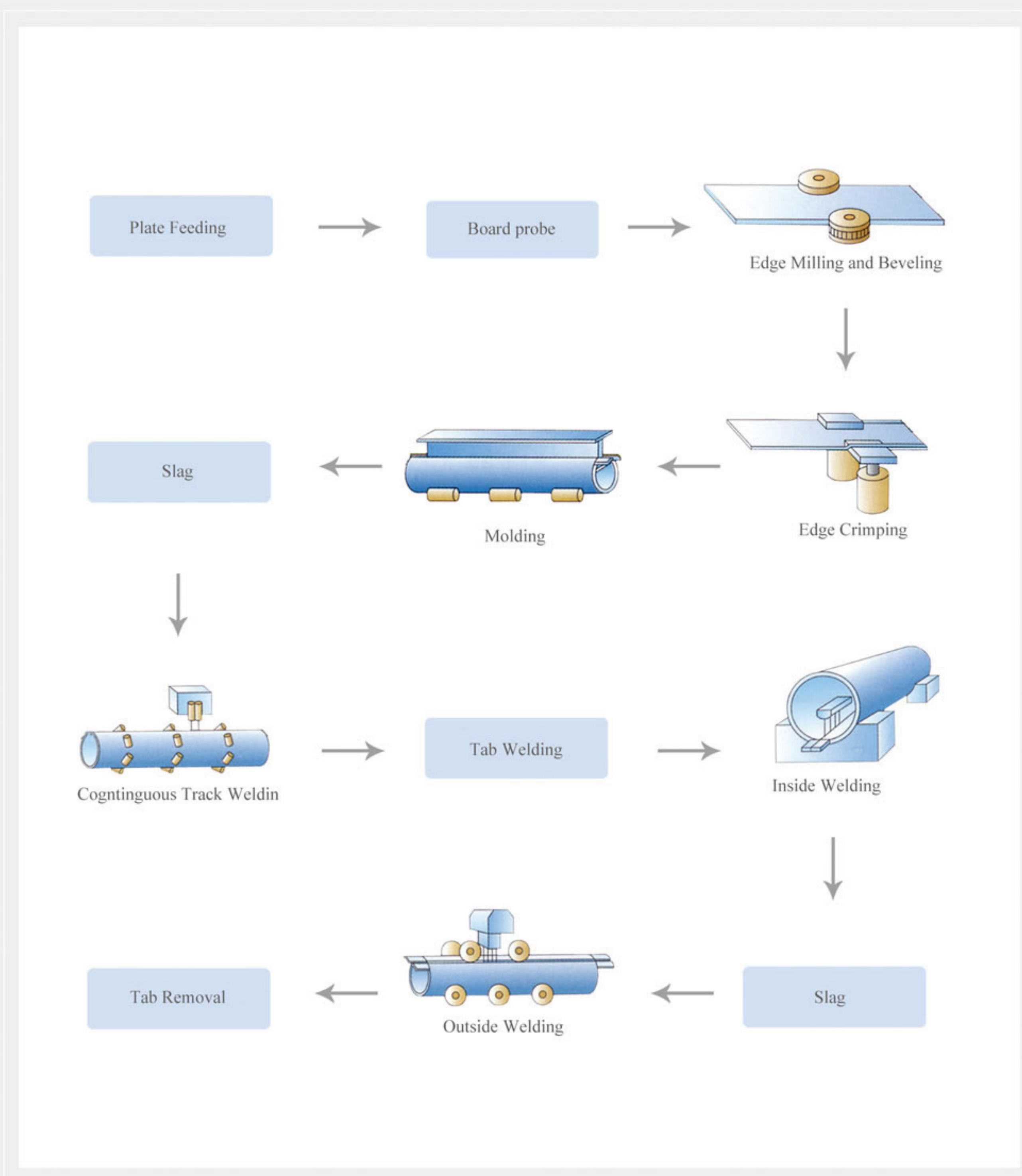
Surface: Lightly oiled, Hot dip galvanized, Electro galvanized, Black, Bare, Varnish coating/Anti rust oil, Protective Coatings (Coal Tar Epoxy, Fusion Bond Epoxy, 3-layers PE)

Packing: Plastic plugs in both ends, Hexagonal bundles of max. 2,000kg with several steel strips, Two tags on each bundle, Wrapped in waterproof paper, PVC sleeve, and sackcloth with several steel strips, Plastic caps





## LSAW STEEL PIPE MANUFACTURING PROCESSES





## LSAW STEEL PIPE MANUFACTURING EQUIPMENTS

The JCOE production line for large-diameter, double-side, submerged-arc welded steel pipes (hereinafter referred to as JCOE Production Line) is equipped with YSD forming machine, which is of high forming precision and fast forming speed, evenly distributed stress and small residual stress; major equipment for pre-bending, etc. is supplied by Tianshui Metalforming Machine Tool Co., Ltd.; the pre-welding is of large-power CO<sub>2</sub> gas shielded welding and high-speed full-length pre-welding techniques; the internal and external

welding equipment is Lincoln multiple wire DC/AC automatic submerged-arc welding machine, affiliated by automatic steel plate cutting torch, steel pipe straightener steel pipe finishing machine, on-line manual UT examination for steel plate, etc. All these are assured that the advanced quality level must be in the steel pipe manufacturing process. Products supported by the NDT, as oil and natural gas and other fluid large diameter pipeline. JCOE steel pipe production for the international system of advanced technology, JCOE pipe production is an international advanced pipe-product technology which has filled gaps in traditional ERW pipe production line of diameter outscoring 610mm and wall thickness surpassing 610mm, the largest produces is caliber 2150mm, thickness 30mm JCOE pipe.



Large caliber straight double submerged arc welding joints uses the most advanced domestic hydraulic bending process, the bending machine is duplex structure, maximum length up to 16m, the pressure of 1600 tons, single-equipment weighing about more than 400 tons, Machinable

diameter of 325-2150 mm and wall thickness 6-30 mm of ordinary and special steel-pipe, the products undergo a number of processes to the American Petroleum Institute standards, just like bending, perfect fitting of seams, within welding, the welding, straightening, ending facing

process etc., it is large pipeline project, water gas project, city pipeline building the best choice. National "West-East Gas Transmission" project as an example, JCOE steel pipe would require a total of 964,000 tons, which can prove that JCOE steel pipe





## LSAW STEEL PIPE PRODUCTION STANDARDS

### 1、Product specification:

Dimension:OD:340-1820mm,WT:max160mm

Product standards:ISO3183、API Spec 5L、PSL1& PSL2、API Spec2B、GB/T9711etc

Annual output:150000tons

2、**Application:** The pipes are mainly used as long distance transportation pipeline for oil,gas,liquid coal etc on land and offshore.And also can be applied as construction pipes on offshore platform,power station,petrochemistry and city construction etc.

### 3、characteristics:

- \* The pipe internal stress is very small and uniformly distributed after the full-length expansion.The corrosion and cracking of the pipes owing to stress can be effectively prevented.The application of welding on site is very easy because of the high dimension precision;
- \* The inside and outside welding are performed after the tack welding ,so the welding process is very stable with good weld quality;
- \* The NDT is easy to perform on the weld durign production and field operation as well;
- \* The length of the weld is shorter than that of the non-longitudinal seam pipe,so the probability of defects occurrence is very low;
- \* The coverage of the pipe specification is very wide.The pipe can be either in large diameter with thick wall or in small diameter with thick wall.

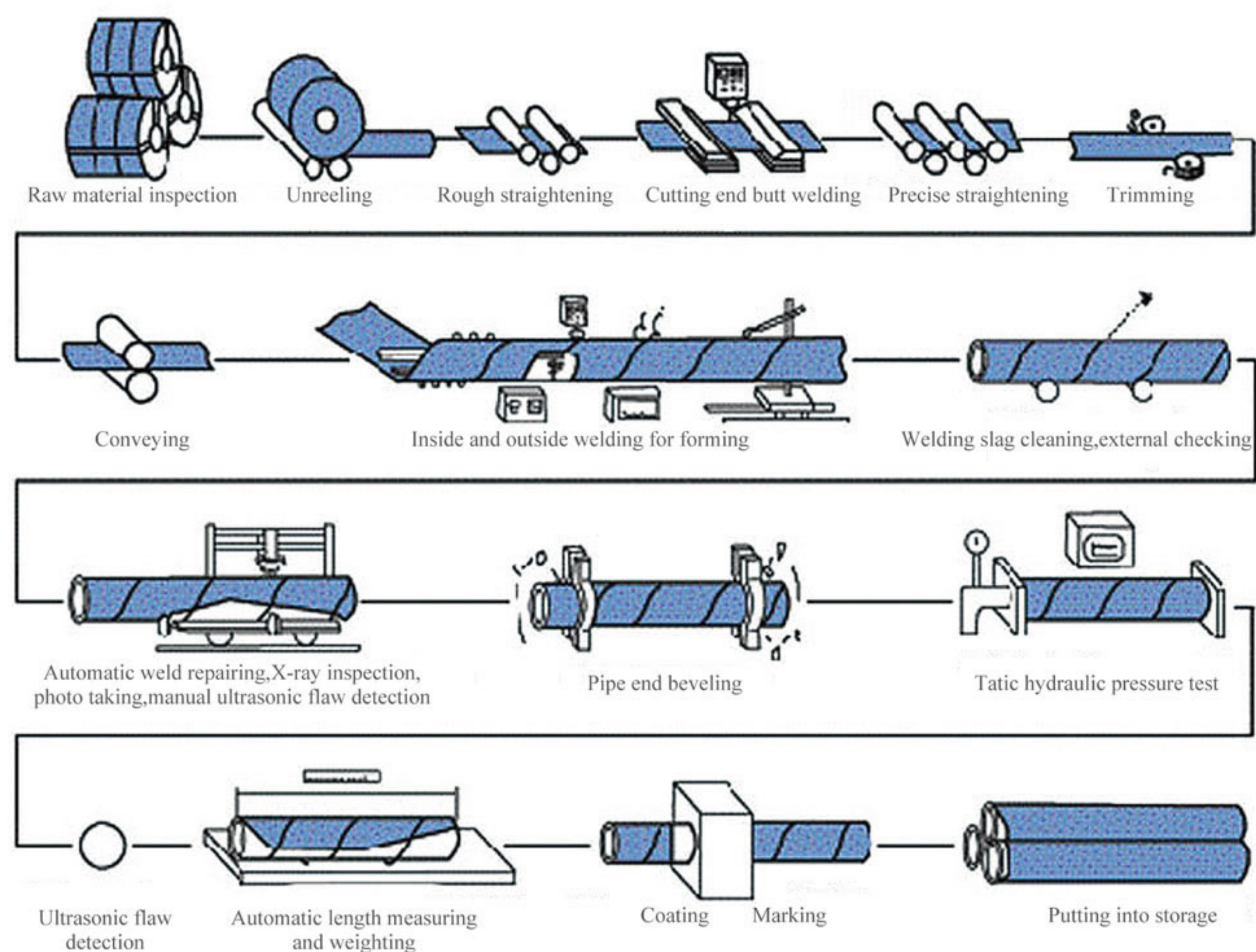


DEVELOPMENT DEPENDS ON QUALITY,  
WHILE QUALITY COMES FROM DETAILS





## SSAW/SAWH STEEL PIPE MANUFACTURING PROCESSES



## MANUFACTURING EQUIPMENTS SSAW/SAWH STEEL PIPE

1. The spiral steel pipe production lines, equipped with submerged arc welding automatic apparatus. The characteristics are high scientific and technological content and modern techniques, etc.. The steel pipe product is able to bear the high temperature and the high pressure. Because of dense and strong, it can defend permeating. It is extensively used in petroleum, coal gas, natural gas, heating power.
2. Newly produced spiral pipes are all inspected with hydraulic pressure, flaw detector and ultrasonic testing machines respectively.
3. In submerged arc welding pipe workshop workers are busy processing. provide high quality product to customers. ABTER staff's firm norm.
3. With advanced technique, good producing equipments and high quality steel pipes are ready to the customers' need.





## SSAW/SAWH STEEL PIPE PRODUCTION STANDARDS



### Quality Standard:

SY/T5037 Spiral submerged arc-welded steel pipe for pipelines for low pressure field fluid service

SY/T5040 Spiral submerged arc-welded steel pipe piles

CJT 3022 Spiral submerged-arc welded steel pipe for municipal heat supply

IS: 1978 Steel tubes for use in transportation of oil; gas d Petroleum products

ASTM A252 WELDED AND SEAMLESS STEEL PIPE PILES

### Coating Standard:

ANSI/AWWA C104121.4 American National Standard for Cement-Mortar Lining for Ductile-Iron Pipe and Fillings for Water  
ISO 21809 Petroleum and natural gas industries-External coatings for buried or submerged pipelines used in pipeline transportation systems

DIN 30670 Polyethylen coatings of steel pipes and fillings

### Steel Grade:

GB/T3091, SY/T5037, SY/T5040, CJ/T3022:

Q195, Q215, Q235, Q275, Q295, Q345, Q355, Q355JR, Q355J2H, St12, St13, St14, St33, St37, St44, ST52

BS: 1387, EN10217: 8185, 5235, S235JR, S235 G2H, S275, S275JR, S355JR, S355J2H, St12, St13, St14, St33, St37, St44, ST52

ASTM A 53: Gr A, Gr B, Gr C, Gr D

API 5L: A, B, X42, X46, X52, X56, X60, X65, X70

GB/T9711: L175, L210, L245, L290, L320, L360, L290, L320, L360, L390, L415, L450, L485, L555

### Size:

Outer Diameter: 219.1mm-3220mm

Wall Thickness: max 26mm

Length: 6M-30M

End square ends (straight cut, saw cut, and torch cut). or beveled for welding, beveled,

Surface: Lightly oiled hot dip galvanized, Electro galvanized black, Bare, Vamish coating/Anti rust

oil, Protective Coatings (Coal Tar epoxy Fusion Bond Epoxy, 3-layers PE)

Packing: Plastic plugs in both ends, Hexagonal bundles of max. 2,000kg with several steel strps, Two tags on each bundle, Wrapped in watetpro of paper, PVC sleeve, and sackcloth with several steel ships, Plastic caps.

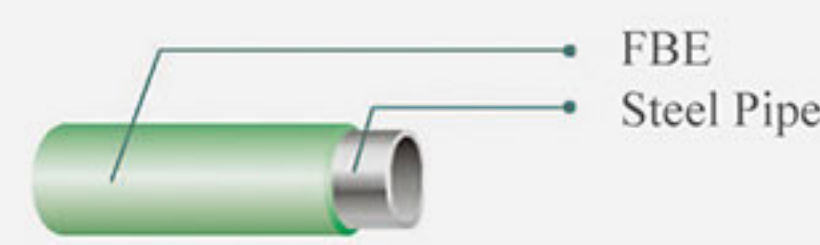
## SSAW/SAWH STEEL PIPE





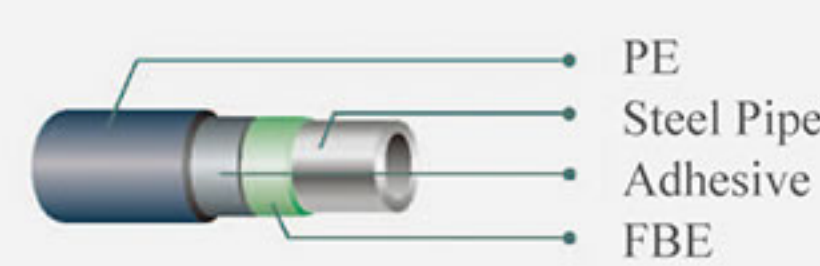
## COATINGS

FBE Coating



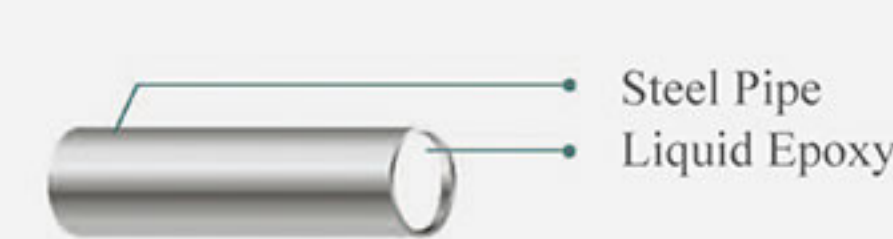
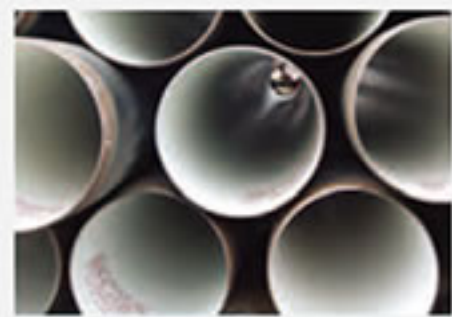
FBE  
Steel Pipe

PE/PP Coating



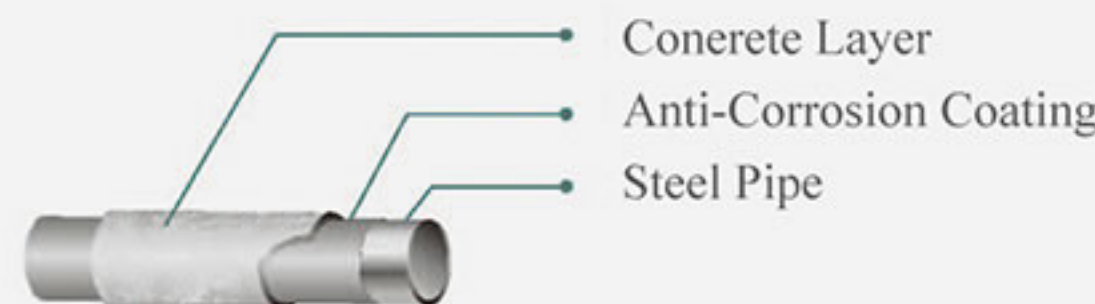
PE  
Steel Pipe  
Adhesive  
FBE

Liquid Epoxy Coating



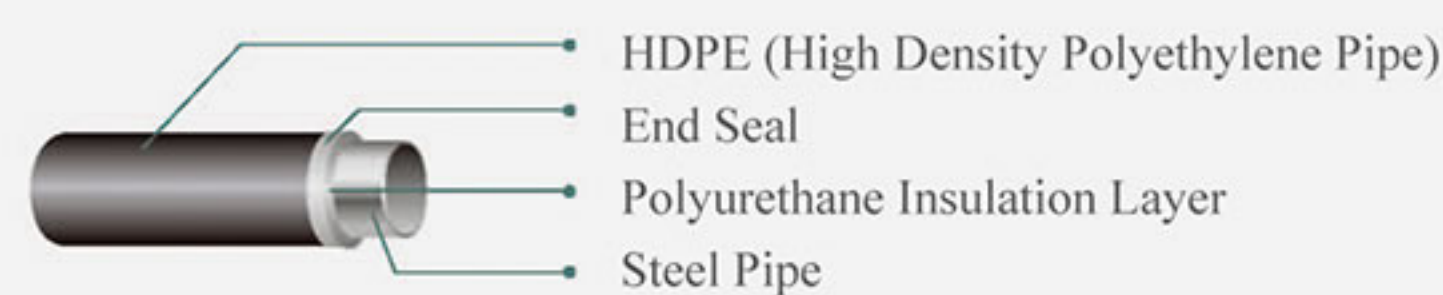
Steel Pipe  
Liquid Epoxy

Concrete Weight Coating



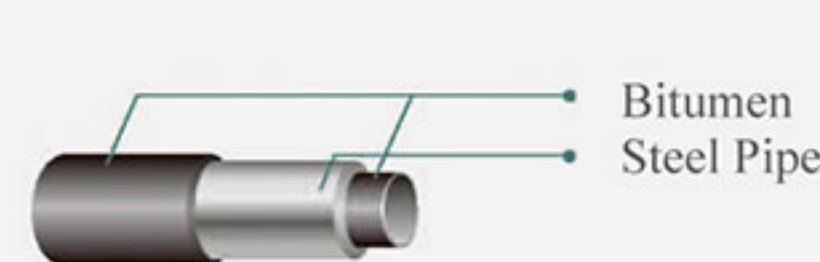
Concrete Layer  
Anti-Corrosion Coating  
Steel Pipe

Insulation Coating



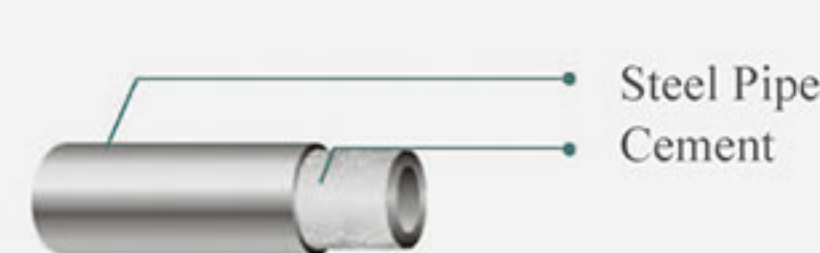
HDPE (High Density Polyethylene Pipe)  
End Seal  
Polyurethane Insulation Layer  
Steel Pipe

Bitumen Coating



Bitumen  
Steel Pipe

Cement Lining



Steel Pipe  
Cement

## PILE

Pipe piling are steel pipe piles that are used as steel piling purpose, for example, deep foundation, port constructions etc. Pipe piling take pressures from soils, waters, sands from one side to make use the projects on the other side can go ahead. Pipe piling are also called pipe piles, tubular piles, or tubular pilings. Although we can produce the pipe piles in almost any diameter and thickness, the projects almost all require big diameter pipes. We can supply in 100m per single length, or we can also supply in shorter length and clients can splice and welding at job sites.

Pipe piles are almost all spiral pipes due to dimension and economical considerations. Spiral pipes can reach 3000mm diameter easily, which means bigger modulus of sections and bending moment. The main tubular piling standard is API 5L and EN 10219-1. Piling pipe and piling tubes steel grade from grade B, X42, X46, X52, X56, X60, X65 up to X70, and X80. API is petroleum standard, so very strict requirements. Compared with wood or concrete construction, pipe piles are high speed installation, lower in total costs, and also friendly to environment.



Tubular piling can be supplied in open end or closed end with a piling shoe. If in open end, the sand and soils will come out through the pipe inside. We can supply tubular pilings with various piling shoes. Depending on the structure, load and soil conditions you are working with, you may use open or closed ended pipe piles. Tubular piling can be retaining elements for horizontal loads from soil and water pressures as bearing piles for vertical loads. Pipe and piling standard in EN 10219-1 has S235JRH, S275JRH/J2H, S355JRH/JEH S420MN, S460MH steel grades.

Tubular piles can also be used as foundation piles when soil and ground conditions are not suitable to support the structure. In deep foundation, steel piles can transfer the structure load to rock formations or to stronger soil conditions deep beneath the ground. With various sizes, strengths and grades available, you can find the ideal steel pipe piling for your needs.



Our welders are AWS D1.1 certified to accommodate most marine piling, bridge piling or building pile requirements. Pipe piling can be connected with sheet piles to form combined walls or combiwall. The intermediate sheet piles transfer horizontal loads to the pipes. Intermediate sheet piles can be shorter than the pipes. Our clients are a wide variety of contractors, including building contractors, marine contractors, bridge contractors and more.



# TESTING EQUIPMENTS



DM2500M Metallographic microscope



MAXXLMFO4 Direct-reading spectrograph



MH2000 Carbon sulfur analyzer



SHT4605 Universal testing machine



HRS-ISO Rockwell hardness tester



20°C-60°C Impact testing machine

# QUALITY MANAGEMENT

And so she was approved by famous oil companies such as Shell, Mobil, Total, Petro China, Sinopec, CNOOC, NPDC, PAVISA, TPOC etc.

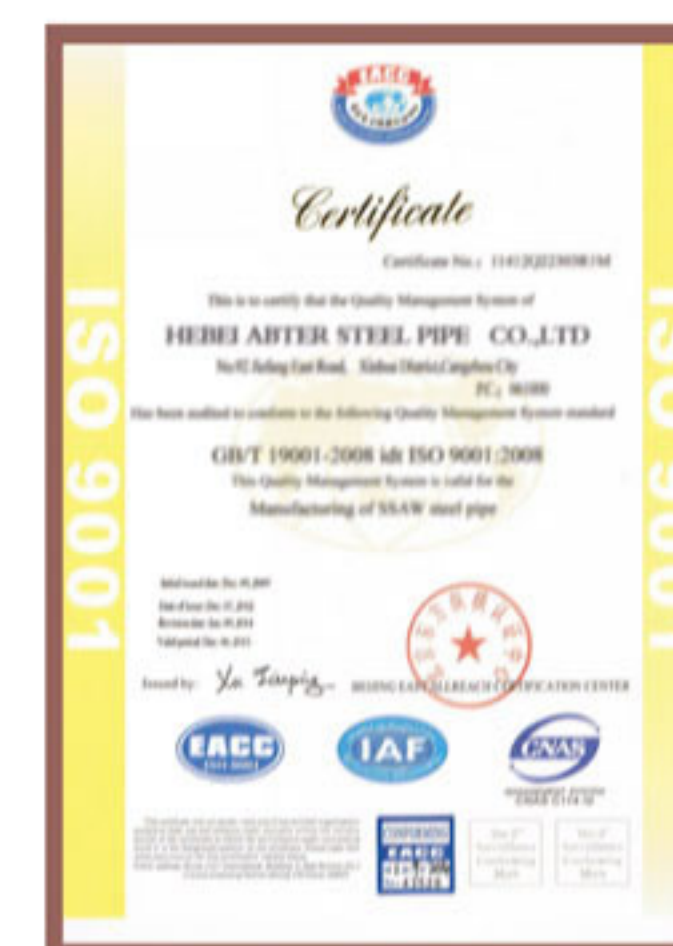
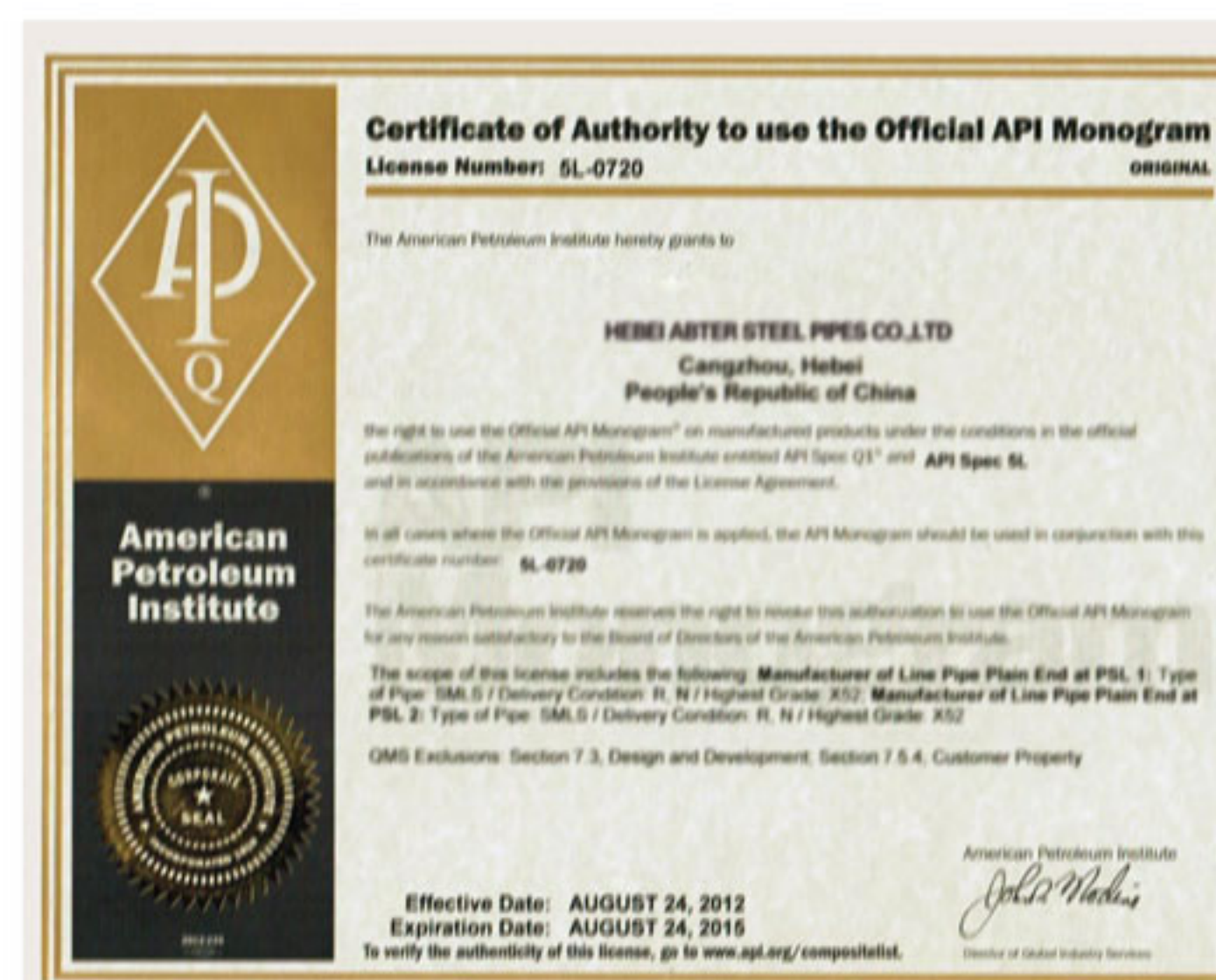
Abter Steel insists on his operation concept with "to seek the survival at his quality" and Management objective with

"to focus on customers". It develops the system and products certification as the propelling force and implements

the quality policy by deepening the total quality management, process approach, continuous improvement of his

product application and enhancement of the customers' satisfaction. It improves the product's stable quality by quality

performance indicators to each individual person and standardization quality management.





## MARKETING AND CUSTOMERS

