

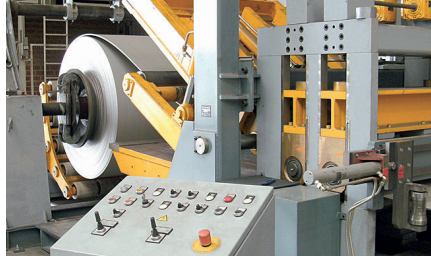
## The production process from coil

### 1. Preparation of the coil



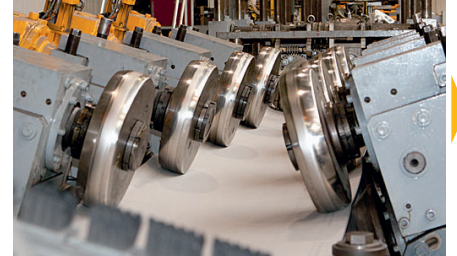
The basic prerequisite for high-quality pipes is high-quality raw material

### 2. Coil on the decoiler



The incoming goods inspection of the coil is performed when it is put on the decoiler

### 3. Forming to make an open seam pipe



The coil is formed into an open seam pipe by means of profiling rollers

### 4. Welding the longitudinal seam



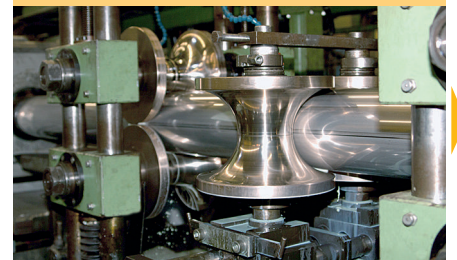
The longitudinal seam is welded using the laser beam, plasma or TIG welding process

### 5. Heat treatment



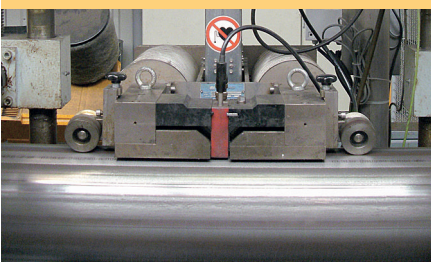
Heat treatment is performed online – in an inductive solution annealing process followed by a rapid cooling

### 6. Calibration procedure



The pipes are calibrated in line with the tolerance requirements

### 7. Non-destructive testing



A leakage test of the longitudinal weld is performed online; the equipment highlights any faulty areas

### 8. Cutting the pipe lengths



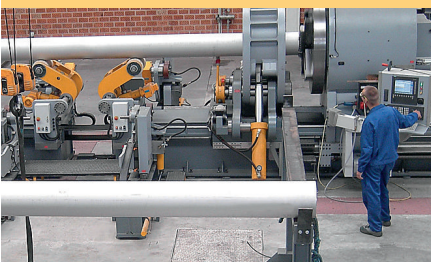
Production lengths from 6 m to 18 m are possible, as are fixed lengths

### 9. Non-destructive testing



X-ray or radiography testing is performed, depending on the individual project

### 10. Processing the pipe ends



In this stage of production, the pipe ends can be bevelled or faced

### 11. Surface treatment



At BUTTING, all pipes are full body pickled – this results in a passive layer to protect against corrosion

### 12. Quality testing



In our certified laboratory, a large number of destructive and non-destructive tests can be performed