

Technological capabilities

MATERIAL CUTTING

Circular saws

Circular saw diameter:	max. 810 mm
Cut material diameter:	max. 270
Type of the machine:	KALTENBACH MB 330 ERGONOMIC

Flame cutting machine for plates

Plate size:	max. 3600 x 24000 mm
Plate thickness (carbon steel):	max. 200 mm
Plate thickness (austenitic steel):	max. 130 mm
Type of the machine:	MESSER-GRIESSHEIM CORTA P4600

Table shears

Plate thickness:	max. 20 mm
Plate width:	max. 2500 mm
Type of the machine:	SKODA 2500/20

Blanking press LE 160

Plate thickness:	max. 10 mm
Max. shear area:	max. 4000 mm ²
Type of the machine:	LE 160

PRODUCTION

Cold forming

Roll bending machines

Thickness by cold state:	min. 2 mm
Bended diameter:	min. 150 mm
Thickness by cold state:	max. 120 mm
Plate width:	max. 3500 mm
Type of the machines:	
- Three roll plate bending machines:	FACCIN 3 SI 2021 FACCIN 3HEL 2-25/20 SCHIESS UDBH-S 3600/4500
- Four roll plate bending machines:	FACCIN 4HEL 4-40/34

Tube bending machine

Diameter:	18 – 273 mm
Type of the machine:	PERFECT NC 40 PERFECT W60 XOT 110 H273

Hot forming

Roll bending machines

Thickness by hot state:	max. 250 mm
Plate width:	max. 3500 mm
Type of the machines:	FACCIN 3SI 2021 SHIESS UDBH-S 3600/4500

Inductive tubes bending

Range of diameter application:	76 - 680 mm
Wall thickness:	max. 40 mm
Type of the machines:	EOS 630

Machining

Lathes (various types)

Swing over bed:	max. 655 mm
Swing over cross-slide:	max. 390 mm
Distance between centres:	max. 2000 mm
Type of the machines:	SUS 63/2000

Vertical turret lathes

Turning diameter:	max. 5200 mm
Height of workpiece:	max. 4000 mm
Weight of workpiece:	max. 100 t
Type of the machine:	SKD 32 B NC SKD 50

Horizontal boring machine

Spindle diameter:	max. 200 mm
Type of the machine:	W160 G W 200 G W 200 HC WEQ 200 NC

Spindle diameter:	max. 150 mm
Type of the machine:	WRD 150

Milling machine:

Length of plate:	max. 12000 mm
Plate thickness:	max. 300 mm
Type of the machine:	HUGH SMITH EDGEMILL 12,2

Welding

Welder's Qualification acc. to EN ISO 9606-1, Operator's acc. to EN ISO 14 732 for:

SMAW	Manual Metal Arc Welding
GTAW	Gas-shielded Arc Welding with non-consumable tungsten electrode
GMAW	Gas-shielded Metal Arc Welding
OFW	Oxyfuel Gas Welding
SAW	Submerged Arc Welding with solid wire electrode
FCAW	Gas Metal Arc Welding using active gas and flux cored electrode

- SMA Welding and cladding of carbon steel and high alloy materials
- GTA Welding of carbon steel and high alloy materials
- Semi-automated Shield Pulse Welding of carbon and high – alloy pipes to tube plates with tungsten electrodes
- Orbital Welding of carbon and high alloy steels with tungsten electrodes
- Automatic Submerged Arc Welding and building up of carbon and high alloy steels with welding wire or stripe

Welding Certificates

- EN ISO 3834-2
- AD Merkblatt HP O/TRD 201
- ASME Section I, VIII, Div. 1 and 2
- PED certificate for welding of the pressure part's acc. to EN standards

Preheating for welding by

- Gas
- Electro-resistant
- Inductive

Equipment for welding

- Welding rectifiers
- WIG welding machines
- MAG welding machines
- Welding automatic machines
- Collums with booms for SAW

Base material's range

Steel groups acc. to ISO/TR 20 172

- Group 1 – carbon and low alloyed steels
- Group 3 – fine-grained steels
- Group 5 – 13CrMo4-5, 10CrMo9 10 and others
- Group 6 – 14MoV63, X10CrMoVNb9-1 and others
- Group 8 – austenitic steels

Heat treatment

Annealing furnaces

- type LOI 5000 x 6000 x 13000 mm – 1150 °C
5500 x 6500 x 20000 mm – 850 °C

Annealing machines

- Electro resistant machines for preheating and PWHT - WELDOTERM 4 x 100 kW
- Machines for preheating and PWHT - ELPHIAC 2 x 250 kW

SURFACE TREATMENT

Blasting

- Continuous blast-clean plant – through section 3000 x 700 mm type of the machine: SKODA TMT 30 x 7
- Manual blast – cleaning: D 6000 x 6000 x 16000 mm
- Blast cleaning box size: 10000 x 8500 x 18000 mm

Painting:

- Box size: 10000 x 8500 x 19000 mm
- Coating facility: type Waagner, Kovofinish