

**ABSTRACT**

There is disclosed an improved process and apparatus for forming pipe from a flat steel plate by curving the plate around a rotatable mandrel in which the ratio of plate length and width is relatively high comprising the process steps and apparatus of applying abutment members to against the sides of the mandrel and creating a horizontal component of force between the mandrel, plate and supporting rolls which horizontal component of force is opposed by said abutment member acting to stabilize the mandrel at most times and at least during the final stages of forming the pipe.