

Abstract

The invention relates to method for producing hot-rolled, seamless pipes (1) from transformable steel, in particular for pipelines for deep-water applications, in which the pipe ends (3) are hot-upsetted in order to obtain a wall thickening after a final rolling process of the pipes (1).

In order to produce pipes with excellent fatigue, corrosion and welding properties it is proposed that by means of the hot-upsetting process, a preselected ratio between a wall thickness of the pipe end (3) and a wall thickness of a pipe body (2) adjoining the pipe end (3) is set by the hot-upsetting process such that a pipe (1) is achieved with a pipe end which has a lower strength than the pipe body (2) after a uniform hardening and tempering process of the entire pipe (1) following the hot-upsetting process by using a previously ascertained wall thickness-dependent cooling rate during the tempering treatment.

(cf. Figure 2)